

Makrolon® 6487 X

Designation according to ISO 1043: PC-I FR(40)



Product description

Polycarbonate; impact modified; flame retardant; medium viscosity; UV stabilized; good hydrolysis resistance; easy release

Applications

Injection molding; Electrical/electronic; Information technology

Typical Values

Rheological properties

Property	Test Condition	Value	Unit	Standard
Melt Volume-flow Rate (MVR)	300 °C/1.2 kg	9	cm ³ /10 min	ISO 1133-1
Melt Viscosity	300 °C; 1,000 s ⁻¹	260	Pa·s	b. o. ISO 11443-A
Molding Shrinkage, parallel/normal	Value range based on general practical experience	0.60 - 0.80	%	b. o. ISO 2577

Mechanical properties (23 °C; 50 % r. h.)

Property	Test Condition	Value	Unit	Standard
Tensile Modulus	1 mm/min	2,380	MPa	ISO 527-1,-2
Yield Stress	50 mm/min	58	MPa	ISO 527-1,-2
Yield Strain	50 mm/min	6	%	ISO 527-1,-2
Stress at Break	50 mm/min	58	MPa	ISO 527-1,-2
Strain at Break	50 mm/min	> 100	%	ISO 527-1,-2
Flexural Modulus	2 mm/min	2,430	MPa	ISO 178
Flexural Strength	2 mm/min	90	MPa	ISO 178
Flexural Stress at 3.5 % Flexural Strain	2 mm/min	74	MPa	ISO 178
Flexural Strain at Flexural Strength	2 mm/min	6	%	ISO 178
Izod Impact Strength	23 °C	N	kJ/m ²	ISO 180/U
Izod Impact Strength	-30 °C	N	kJ/m ²	ISO 180/U
Izod Notched Impact Strength	23 °C; 3 mm	67P	kJ/m ²	ISO 21305/b. o. ISO 180/A
Izod Notched Impact Strength	-20 °C; 3 mm	46P	kJ/m ²	ISO 21305/b. o. ISO 180/A
Izod Notched Impact Strength	-30 °C; 3 mm	26C	kJ/m ²	ISO 21305/b. o. ISO 180/A
Charpy Impact Strength	23 °C	N	kJ/m ²	ISO 179-1/1eU
Charpy Notched Impact Strength	23 °C; 3 mm	69P	kJ/m ²	ISO 21305/b. o. ISO 179-1/1eA

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Property	Test Condition	Value	Unit	Standard
Charpy Notched Impact Strength	-20 °C; 3 mm	56C	kJ/m ²	ISO 21305/b. o. ISO 179-1/1eA
Charpy Notched Impact Strength	-30 °C; 3 mm	33C	kJ/m ²	ISO 21305/b. o. ISO 179-1/1eA

Impact properties: N = non-break, P = partial break, C = complete break

Thermal properties

Property	Test Condition	Value	Unit	Standard
Temperature of Deflection under Load (HDT)	1.80 MPa	114	°C	ISO 75-1,-2
Temperature of Deflection under Load (HDT)	0.45 MPa	127	°C	ISO 75-1,-2
Vicat Softening Temperature	50 N; 50 °C/h	134	°C	ISO 306
Vicat Softening Temperature	50 N; 120 °C/h	136	°C	ISO 306
Coefficient of Linear Thermal Expansion (CLTE), parallel	23 to 55 °C	0.49	10 ⁻⁴ /K	ISO 11359-1,-2
Coefficient of Linear Thermal Expansion (CLTE), normal	23 to 55 °C	0.58	10 ⁻⁴ /K	ISO 11359-1,-2
Burning Behavior	1.5 mm	V-0		UL 94
Burning Behavior	2.0 mm	5VB		UL 94
Burning Behavior	3.0 mm	5VA		UL 94
Relative Temperature Index (RTI, Tensile Impact Strength)	1.5 mm	115	°C	UL 746B
Relative Temperature Index (RTI, Tensile Strength)	1.5 mm	125	°C	UL 746B
Relative Temperature Index (RTI, Electric Strength)	1.5 mm	125	°C	UL 746B

Other properties (23 °C)

Property	Test Condition	Value	Unit	Standard
Density		1,200	kg/m ³	ISO 1183-1

Processing conditions for test specimens

Property	Test Condition	Value	Unit	Standard
Injection Molding - Melt Temperature		280	°C	ISO 294-1
Injection Molding - Mold Temperature		80	°C	ISO 294-1

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Health and Safety Information

Before working with this product, you must read and become familiar with the available information regarding its risks, proper use, and safe handling. This information is provided in various formats, including the current Safety Data Sheet (SDS) and product label. SDS can be accessed via the following link:

[Safety Data Sheets \(SDS\) for Covestro products | Covestro](#)

For further questions, please use the contact information provided on this technical data sheet.

Please note that for products manufactured in different colors, safety data may vary depending on the color variant.

Disclaimer

Responsibility and Liability

The use of Covestro products, technical assistance, and information (regardless of how provided) is outside Covestro's control and is solely the responsibility of the customer. The customer must conduct adequate testing to determine the suitability of products for its intended use, including but not limited to technical, health, safety, and environmental aspects. Unless otherwise agreed in writing, all products are sold exclusively under Covestro's standard conditions of sale, which prevail in case of conflict and are available upon request.

The terms and conditions of sale and delivery are available via the following link:

<https://order.covestro.com/covestrostorefront/saleConditions>

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This product is not intended for use in regulated applications such as agriculture, cosmetics, drinking water contact, food contact, medical products (e.g., medical devices), toys, or similar uses subject to specific regulatory requirements. Prior written approval from Covestro is required before this product may be used in any regulated application. The customer is solely responsible for ensuring compliance with all applicable laws and determining product suitability. Covestro disclaims all liability and warranties for unauthorized regulated uses.

Typical Value

These values are provided as typical data only and do not constitute binding specifications or warranted performance, unless explicitly agreed by Covestro in writing. Performance may vary depending on factors including, but not limited to, mold/die, processing conditions and coloring/pigmentation. Unless otherwise stated, values are based on standardized test specimens at room temperature.

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Sample

Samples provided by Covestro are intended solely for evaluation and testing purposes by the customer and may not be used in commercial applications, resold, transferred to third parties (except qualified testing service providers acting on behalf of the customer), reverse engineered, modified, or used in any manner not explicitly authorized in writing by Covestro. Samples are provided 'as-is' without any warranties, express or implied, including fitness for a particular purpose. Customers are solely responsible for ensuring safe handling, regulatory compliance, and suitability of the material for their intended evaluations. Covestro disclaims all liability for damages or losses arising from the use of samples.

Shrinkage

Shrinkage data is provided for reference only and is based on plaques molded under specific, controlled processing conditions. Actual shrinkage values in production parts may vary due to numerous factors, including but not limited to part design (e.g., size, thickness, geometry), mold design (e.g., gate type and location, runner design, mold materials, cooling system), and molding conditions (e.g., processing temperature, mold temperature, packing time and pressure, injection speed).

The determination and application of shrinkage values are the sole responsibility of the customer and must be based on their own testing and experience under actual production conditions. To the maximum extent permitted by law, Covestro shall not be liable for any damages, losses, or claims arising from the use of, or reliance on, the shrinkage data provided.

Contact Information

Please use our [contact form](#) or contact us directly by sending an e-mail to technical-datasheets@cx.covestro.com.
