

Makrolon® Rx2635

Polycarbonate

Covestro - Polycarbonates

Message:

MVR (300 °C/1.2 kg) 12 cm³/10 min; medical devices; suitable for sterilization with high-energy radiation; biocompatible according to many ISO 10993-1 test requirements; medium viscosity; easy release; injection molding - melt temperature 280 - 320 °C; available in color code 451118 only; transparent parts for medical devices

General Information			
Features	Biocompatible		
	Good Mold Release		
	Medium Viscosity		
	Radiation Sterilizable		
Uses	Medical Devices		
	Medical/Healthcare Applications		
Agency Ratings	ISO 10993-Part 1		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.20	g/cm ³	ISO 1183
Apparent Density ¹	0.66	g/cm ³	ISO 60
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	13	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	12.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 2577
Across Flow	0.60 to 0.80	%	
Flow	0.60 to 0.80	%	
Water Absorption			ISO 62
Saturation, 23°C	0.30	%	
Equilibrium, 23°C, 50% RH	0.12	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2400	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield, 23°C	67.0	MPa	
Break, 23°C	75.0	MPa	
Tensile Strain			ISO 527-2/50
Yield, 23°C	6.1	%	
Break, 23°C	130	%	
Nominal Tensile Strain at Break (23°C)	> 50	%	ISO 527-2/50

Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength			ISO 179/1eU
-60°C	No Break		
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength ²			ISO 7391
-30°C, Complete Break	12	kJ/m ²	
23°C, Partial Break	65	kJ/m ²	
Multi-Axial Instrumented Impact Energy (23°C)	60.0	J	ISO 6603-2
Multi-Axial Instrumented Impact Peak Force (23°C)	5300	N	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	133	°C	ISO 75-2/B
1.8 MPa, Unannealed	121	°C	ISO 75-2/A
Vicat Softening Temperature	143	°C	ISO 306/B50
CLTE			ISO 11359-2
Flow : 23 to 55°C	6.5E-5	cm/cm/°C	
Transverse : 23 to 55°C	6.5E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+16	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flash Ignition Temperature	480	°C	ASTM D1929
Self Ignition Temperature	550	°C	ASTM D1929
ISO Shortname	ISO 7391-PC,MR,(,,)-18-9		
NOTE			
1.	Pellets		
2.	Based on ISO 180-A, 3 mm		

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