

Makrolon® Rx2635

Grades / Medical devices

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

ISO Shortname

ISO 7391-PC,MR,(,)-18-9

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
C Melt volume-flow rate	300 °C; 1.2 kg	cm ³ /10 min	ISO 1133	12
Molding shrinkage, parallel/normal	Value range based on general practical experience	%	b.o. ISO 2577	0.6 - 0.8
Melt mass-flow rate	300 °C; 1.2 kg	g/10 min	ISO 1133	13
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	2400
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	67
C Yield strain	50 mm/min	%	ISO 527-1,-2	6.1
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
Stress at break	50 mm/min	MPa	ISO 527-1,-2	75
Strain at break	50 mm/min	%	b.o. ISO 527-1,-2	130
C Charpy impact strength	23 °C	kJ/m ²	ISO 179-1eU	N
C Charpy impact strength	-30 °C	kJ/m ²	ISO 179-1eU	N
Charpy impact strength	-60 °C	kJ/m ²	ISO 179-1eU	N
Izod notched impact strength	23 °C; 3 mm	kJ/m ²	ISO 7391/b.o. ISO 180-A	65P
Izod notched impact strength	-30 °C; 3 mm	kJ/m ²	ISO 7391/b.o. ISO 180-A	12C
C Puncture maximum force	23 °C	N	ISO 6603-2	5300
C Puncture energy	23 °C	J	ISO 6603-2	60
Thermal properties				
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	121
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	133
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	143
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.65
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.65
Flash ignition temperature		°C	ASTM D1929	480
Self ignition temperature		°C	ASTM D1929	550
Electrical properties (23 °C/50 % r. h.)				
C Volume resistivity		Ohm-m	IEC 60093	1E14
C Surface resistivity		Ohm	IEC 60093	1E16
Other properties (23 °C)				
C Water absorption (saturation value)	Water at 23 °C	%	ISO 62	0.30
C Water absorption (equilibrium value)	23 °C; 50 % r. h.	%	ISO 62	0.12
C Density		kg/m ³	ISO 1183-1	1200
Bulk density	Pellets	kg/m ³	ISO 60	660
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	290
C Injection molding-Mold temperature		°C	ISO 294	80
C Injection molding-Injection velocity		mm/s	ISO 294	200

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.

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



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Disclaimer

Typical value

These values are typical values only. Unless explicitly agreed in written form, they do not constitute a binding material specification or warranted values. Values may be affected by the design of the mold/die, the processing conditions and coloring/pigmentation of the product. Unless specified to the contrary, the property values given have been established on standardized test specimens at room temperature.

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Covestro Medical Grades

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