



Makrolon® Rx2530

Covestro - Polycarbonates - Polycarbonate

Friday, January 24, 2025

General Information

Product Description

MVR (300°C/1.2 kg) 15 cm³/10 min; medical devices; suitable for sterilization with high-energy radiation; biocompatible according to many ISO 10993-1 test requirements; medium viscosity; injection molding - melt temperature 280 - 320°C; transparent parts for medical devices

General

Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Biocompatible	• Medium Viscosity	• Radiation Sterilizable
Uses	• Medical Devices • Medical/Healthcare Applications		
Agency Ratings	• ISO 10993-1		
RoHS Compliance	• RoHS Compliant		
Processing Method	• Injection Molding		
ISO Shortname	• ISO 7391-PC,M,(,)-18-9		

ASTM & ISO Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density (73°F (23°C))	1.20 g/cm ³	1.20 g/cm ³	ISO 1183
Apparent (Bulk) Density ²	0.66 g/cm ³	0.66 g/cm ³	ISO 60
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	16 g/10 min	16 g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	15 cm ³ /10min	15 cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow	0.60 to 0.80 %	0.60 to 0.80 %	ISO 2577
Flow	0.60 to 0.80 %	0.60 to 0.80 %	ISO 2577
Across Flow : 536°F (280°C), 0.0787 in (2.00 mm) ³	0.65 %	0.65 %	ISO 294-4
Flow : 0.0787 in (2.00 mm) ³	0.60 %	0.60 %	ISO 294-4
Water Absorption			
Saturation, 73°F (23°C)	0.30 %	0.30 %	ISO 62
Equilibrium, 73°F (23°C), 50% RH	0.12 %	0.12 %	
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Modulus (73°F (23°C))	348000 psi	2400 MPa	ISO 527-1/1
Tensile Stress			ISO 527-2/50
Yield, 73°F (23°C)	9720 psi	67.0 MPa	
Break, 73°F (23°C)	10900 psi	75.0 MPa	
Tensile Strain			ISO 527-2/50
Yield, 73°F (23°C)	6.1 %	6.1 %	
Break, 73°F (23°C)	130 %	130 %	

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Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Nominal Tensile Strain at Break 73°F (23°C)	> 50 %	> 50 %	ISO 527-2/50
Flexural Modulus ⁴ (73°F (23°C))	348000 psi	2400 MPa	ISO 178
Flexural Stress ⁴ 73°F (23°C)	14500 psi	100 MPa	ISO 178
3.5% Strain, 73°F (23°C)	10700 psi	74.0 MPa	
Flexural Strain at Flexural Strength ⁵ 73°F (23°C)	7.0 %	7.0 %	ISO 178
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Charpy Notched Impact Strength ⁶ -22°F (-30°C), Complete Break	6.7 ft-lb/in ²	14 kJ/m ²	ISO 179/1eA
73°F (23°C), Partial Break	33 ft-lb/in ²	70 kJ/m ²	
Charpy Unnotched Impact Strength -76°F (-60°C)	No Break	No Break	ISO 179/1eU
-22°F (-30°C)	No Break	No Break	
73°F (23°C)	No Break	No Break	
Notched Izod Impact Strength ⁶ -22°F (-30°C), Complete Break	5.7 ft-lb/in ²	12 kJ/m ²	ISO 180/A
73°F (23°C), Partial Break	31 ft-lb/in ²	65 kJ/m ²	
Multi-Axial Instrumented Impact Energy -22°F (-30°C)	51.6 ft-lb	70.0 J	ISO 6603-2
73°F (23°C)	44.3 ft-lb	60.0 J	
Multi-Axial Instrumented Impact Peak Force -22°F (-30°C)	1390 lbf	6200 N	ISO 6603-2
73°F (23°C)	1190 lbf	5300 N	
Hardness	Typical Value (English)	Typical Value (SI)	Test Method
Ball Indentation Hardness	17100 psi	118 MPa	ISO 2039-1
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 66 psi (0.45 MPa), Unannealed	273 °F	134 °C	ISO 75-2/B
264 psi (1.8 MPa), Unannealed	252 °F	122 °C	ISO 75-2/A
Glass Transition Temperature ⁷	288 °F	142 °C	ISO 11357-2
Vicat Softening Temperature --	288 °F	142 °C	ISO 306/B120
--	286 °F	141 °C	ISO 306/B50
Ball Pressure Test (270°F (132°C))	Pass	Pass	IEC 60695-10-2
CLTE			ISO 11359-2
Flow : 73 to 131°F (23 to 55°C)	3.6E-5 in/in/°F	6.5E-5 cm/cm/°C	
Transverse : 73 to 131°F (23 to 55°C)	3.6E-5 in/in/°F	6.5E-5 cm/cm/°C	
Thermal Conductivity ⁸ (73°F (23°C))	1.4 Btu-in/hr/ft ² /°F	0.20 W/m/K	ISO 8302
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	1.0E+16 ohms	1.0E+16 ohms	IEC 60093
Volume Resistivity (73°F (23°C))	1.0E+16 ohms-cm	1.0E+16 ohms-cm	IEC 60093

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Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Oxygen Index ⁹	27 %	27 %	ISO 4589-2
Flash Ignition Temperature	896 °F	480 °C	ASTM D1929
Self Ignition Temperature	1022 °F	550 °C	ASTM D1929

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature - Dry Air Dryer	248 °F	120 °C
Drying Time - Dry Air Dryer	2.0 to 3.0 hr	2.0 to 3.0 hr
Suggested Max Moisture	< 0.020 %	< 0.020 %
Suggested Shot Size	30 to 70 %	30 to 70 %
Rear Temperature	482 to 500 °F	250 to 260 °C
Middle Temperature	518 to 536 °F	270 to 280 °C
Front Temperature	536 to 554 °F	280 to 290 °C
Nozzle Temperature	554 to 572 °F	290 to 300 °C
Processing (Melt) Temp	536 to 608 °F	280 to 320 °C
Mold Temperature	176 to 248 °F	80 to 120 °C
Back Pressure	725 to 2180 psi	5.00 to 15.0 MPa
Vent Depth	9.8E-4 to 3.0E-3 in	0.025 to 0.075 mm

Injection Notes

Standard Melt Temperature: 300°C
 Peripheral Screw Speed: 0.05 - 0.2 m/s
 Hold Pressure (% of Injection Pressure): 50 - 75%

Notes

¹ Typical properties: these are not to be construed as specifications.

² Pellets

³ 60x60x2mm, 500 bar

⁴ 0.079 in/min (2.0 mm/min)

⁵ 2.0 mm/min

⁶ 3.0 mm

⁷ 10°C/min

⁸ Across Flow

⁹ Procedure A

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