



Makrolon® 2408

Grades / Medical devices

MVR (300 °C/1.2 kg) 19 cm³/10 min; medical devices; suitable for ETO and steam sterilization at 121 °C; biocompatible according to many ISO 10993-1 test requirements; low viscosity; injection molding - melt temperature 280 - 320 °C; available in color code 000000 only

ISO Shortname

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

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
C Melt volume-flow rate	300 °C; 1.2 kg	cm³/10 min	ISO 1133	19
C Molding shrinkage, parallel	60x60x2 mm; 500 bar	%	ISO 294-4	0.65
C Molding shrinkage, normal	60x60x2 mm; 500 bar	%	ISO 294-4	0.65
Molding shrinkage, parallel/normal	Value range based on general practical experience	%	b.o. ISO 2577	0.5 - 0.7
Melt mass-flow rate	300 °C; 1.2 kg	g/10 min	ISO 1133	20
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	2350
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	65
C Yield strain	50 mm/min	%	ISO 527-1,-2	6.3
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
Stress at break	50 mm/min	MPa	ISO 527-1,-2	70
Strain at break	50 mm/min	%	b.o. ISO 527-1,-2	120
C Tensile creep modulus	1 h	MPa	ISO 899-1	2200
C Tensile creep modulus	1000 h	MPa	ISO 899-1	1900
Flexural modulus	2 mm/min	MPa	ISO 178	2350
Flexural strength	2 mm/min	MPa	ISO 178	96
Flexural strain at flexural strength	2 mm/min	%	ISO 178	7.0
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178	72
C Charpy impact strength	23 °C	kJ/m²	ISO 179-1eU	N
C Charpy impact strength	-30 °C	kJ/m²	ISO 179-1eU	N
Charpy impact strength	-60 °C	kJ/m²	ISO 179-1eU	N
Charpy notched impact strength	23 °C; 3 mm	kJ/m²	ISO 7391/b.o. ISO 179-1eA	65P
Charpy notched impact strength	-30 °C; 3 mm	kJ/m²	ISO 7391/b.o. ISO 179-1eA	14C
Izod notched impact strength	23 °C; 3 mm	kJ/m²	ISO 7391/b.o. ISO 180-A	65P
Izod notched impact strength	-30 °C; 3 mm	kJ/m²	ISO 7391/b.o. ISO 180-A	15C
C Puncture maximum force	23 °C	N	ISO 6603-2	5100
C Puncture maximum force	-30 °C	N	ISO 6603-2	6000
C Puncture energy	23 °C	J	ISO 6603-2	55
C Puncture energy	-30 °C	J	ISO 6603-2	65
Ball indentation hardness		N/mm²	ISO 2039-1	113
Thermal properties				
C Glass transition temperature	10 °C/min	°C	ISO 11357-1,-2	147
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	127
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	139
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	147
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	148
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
Thermal conductivity, cross-flow	23 °C; 50 % r. h.	W/(m·K)	ISO 8302	0.20
Resistance to heat (ball pressure test)		°C	IEC 60695-10-2	138
Flash ignition temperature		°C	ASTM D1929	480
Self ignition temperature		°C	ASTM D1929	550





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Property	Test Condition	Unit	Standard	typical Value
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/m³	ISO 1183-1	1200
Bulk density	Pellets	kg/m³	ISO 60	660
Material specific properties				
Refractive index	Procedure A	-	ISO 489	1.586
Haze for transparent materials	3 mm	%	ISO 14782	< 0.8
Luminous transmittance (clear transparent materials)	1 mm	%	ISO 13468-2	89
C Luminous transmittance (clear transparent materials)	2 mm	%	ISO 13468-2	89
Luminous transmittance (clear transparent materials)	3 mm	%	ISO 13468-2	88
Luminous transmittance (clear transparent materials)	4 mm	%	ISO 13468-2	87
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	280
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

