



Makrolon® Rx2235

/ low viscosity; easy release; suitable for radiation sterilization; biocompatible according to many ISO 10993-1 test requirements; injection molding - melt temperature 280 - 320 °C; transparent parts for medical devices

ISO Shortname

PC

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
C Melt volume-flow rate	300 °C/ 1.2 kg	cm³/10 min	ISO 1133	34
Molding shrinkage, parallel/normal	Value range based on general practical experience	%	b.o. ISO 2577	0.5 - 0.7
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	65
C Yield strain	50 mm/min	%	ISO 527-1,-2	5.9
Stress at break	50 mm/min	MPa	ISO 527-1,-2	55
Strain at break	50 mm/min	%	b.o. ISO 527-1,-2	>50
Flexural modulus	2 mm/min	MPa	ISO 178	2400
Flexural strength	2 mm/min	MPa	ISO 178	95
C Charpy impact strength	23 °C	kJ/m²	ISO 179/1eU	N
Charpy notched impact strength	23 °C	kJ/m²	ISO 21305/based on ISO 179/1eA	12C(P)
Charpy notched impact strength	-30 °C	kJ/m²	ISO 21305/based on ISO 179/1eA	9C
Izod notched impact strength	23 °C	kJ/m²	ISO 21305/based on ISO 180/A	10C(P)
Izod notched impact strength	-30 °C	kJ/m²	ISO 21305/based on ISO 180/A	8C
C Puncture impact properties - maximum force	23 °C	N	ISO 6603-2	4900
C Puncture impact properties - maximum force	-30 °C	N	ISO 6603-2	6100
C Puncture energy	23 °C	J	ISO 6603-2	55
C Puncture energy	-30 °C	J	ISO 6603-2	60
Thermal properties				
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	117
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	131
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	138
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, normal	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.65
Other properties (23 °C)				
C Water absorption (saturation value)	Water at 23 °C	%	ISO 62	0.3
C Water absorption (equilibrium value)	23 °C; 50 % r. h.	%	ISO 62	0.12
C Density		kg/m³	ISO 1183-1	1200
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





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Property	Test Condition	Unit	Standard	typical Value
Recommended processing and drying conditions				
Melt temperatures		°C	-	280 - 320
Standard Melt temperature		°C	-	300
Barrel Temperatures - Rear		°C	-	250 - 260
Barrel Temperatures - Middle		°C	-	270 - 280
Barrel Temperatures - Front		°C	-	280 - 290
Barrel Temperatures - Nozzle		°C	-	290 - 300
Mold Temperatures		°C	-	80 - 120
Hold Pressure (% of injection pressure)		%	-	50 - 75
Plastic Back Pressure (specific)		bar	-	50 - 150
Peripheral Screw Speed		m/s	-	0.05 - 0.2
Shot-to-Cylinder Size		%	-	30 - 70
Dry Air Drying Temperature		°C	-	120
Dry Air Drying Time		h	-	2 - 3
Moisture Content max. (%)		%	-	<= 0.02
Vent Depth		mm	-	0.025 - 0.075

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

