



Makrolon® Rx2530 RE

PC

Covestro Deutschland AG

- 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
- transparent parts for medical devices

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	15	cm³/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577
Melt Flow Index, MFI	15.5	g/10min	ISO 1133
MFI temperature	300	°C	-
MFI load	1.2	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	67	MPa	ISO 527
Yield strain	6.1	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Impact Strength (Charpy), +23°C	no break	kJ/m²	ISO 179/1eU
Puncture - maximum force, +23°C	5300	N	ISO 6603-2
Puncture - maximum force, -30°C	6200	N	ISO 6603-2
Puncture energy, +23°C	60	J	ISO 6603-2
Puncture energy, -30°C	70	J	ISO 6603-2
Flexural Modulus (23°C)	2400	MPa	ISO 178
Flexural strength	100	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	65	kJ/m²	ISO 180/1A
Notched Impact Strength (Izod)	12	kJ/m²	ISO 180/1A
Temperature	-30	°C	-
Ball Indentation Hardness	118	MPa	ISO 2039-1

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Glass Transition Temperature (10°C/min)	142	°C	ISO 11357-1/-2
Temp. of deflection under load (1.80 MPa)	122	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	134	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	141	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	65	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	65	E-6/K	ISO 11359-1/-2
Oxygen index	27	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	>1E15	Ohm	IEC 62631-3-2

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.3	%	Sim. to ISO 62
Humidity absorption	0.12	%	Sim. to ISO 62
Density	1200	kg/m³	ISO 1183
Bulk density	660	kg/m³	-

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	280	°C	ISO 294

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Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.02	%	-
Melt temperature	280 - 320	°C	-
Mold temperature	80 - 120	°C	-
Zone 1	250 - 260	°C	-
Zone 2	270 - 280	°C	-
Zone 3	280 - 290	°C	-
Nozzle temperature	290 - 300	°C	-
Back pressure	5 - 15	MPa	-

Characteristics

Processing

Injection Molding

Special Characteristics

Transparent, Sterilizable, Gamma irradiation sterilization

Chemical Resistance

Radiation Resistance

Certifications

Contains renewable resources, Medical, Biocompatibility ISO 10993, ISCC Plus

Applications

Medical