

ColorRx® PC-2500RXR

Americhem - Polycarbonate

General Information
Product Description

PC-2500RXR is a high flow injection molding grade of polycarbonate with good clarity and easy release. It is suitable for healthcare applications and sterilizable by EtO, steam at 121°C, and limited gamma radiation.

General

Material Status	<ul style="list-style-type: none"> Commercial: Active 		
Availability	<ul style="list-style-type: none"> Africa & Middle East Asia Pacific 	<ul style="list-style-type: none"> Europe Latin America 	<ul style="list-style-type: none"> North America
Features	<ul style="list-style-type: none"> Autoclave Sterilizable Biocompatible E-beam Sterilizable 	<ul style="list-style-type: none"> Ethylene Oxide Sterilizable Excellent Colorability Heat Sterilizable 	<ul style="list-style-type: none"> Radiation Sterilizable Steam Sterilizable
Uses	<ul style="list-style-type: none"> Closures Engineering Parts 	<ul style="list-style-type: none"> Housings Industrial Parts 	<ul style="list-style-type: none"> Medical/Healthcare Applications Surgical Instruments
Forms	<ul style="list-style-type: none"> Pellets 		
Processing Method	<ul style="list-style-type: none"> Injection Molding 		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.15	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	8950	psi	ASTM D638
Tensile Strength ² (Break)	9400	psi	ASTM D638
Tensile Elongation ² (Yield)	6.0	%	ASTM D638
Tensile Elongation ² (Break)	120	%	ASTM D638
Flexural Modulus ²	333000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	12	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	70		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed, 0.252 in)	259	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	248	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 to 60	%
Rear Temperature	480 to 520	°F
Middle Temperature	500 to 540	°F
Front Temperature	510 to 570	°F
Nozzle Temperature	500 to 560	°F
Processing (Melt) Temp	510 to 570	°F
Mold Temperature	160 to 200	°F
Back Pressure	40.0 to 100	psi
Screw Speed	40 to 70	rpm

