

Makrolon® Rx1805

 Covestro - Polycarbonates - *Polycarbonate*
General Information
Product Description

MVR (300°C/1.2 kg) 6.0 cm³/10 min; medical devices; high lipid resistance; suitable for sterilization with high-energy radiation; biocompatible according to many ISO 10993-1 test requirements; high viscosity; injection molding - melt temperature 280 - 320°C; transparent parts for medical devices

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Features	• Biocompatible	• High Viscosity	• Radiation Sterilizable
Uses	• Medical Devices	• Medical/Healthcare Applications	
Agency Ratings	• ISO 10993-1	• USP Class VI	
RoHS Compliance	• RoHS Compliant		
Appearance	• Clear/Transparent		
Processing Method	• Injection Molding		
ISO Designation	• ISO 7391-PC,M,(,)-09-9		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.20	g/cm ³	ISO 1183
Apparent (Bulk) Density ²	0.66	g/cm ³	ISO 60
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	6.5	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	6.0	cm ³ /10min	ISO 1133
Molding Shrinkage			
Across Flow	0.60 to 0.80	%	ISO 2577
Flow	0.60 to 0.80	%	ISO 2577
Across Flow : 536°F, 0.0787 in ³	0.70	%	ISO 294-4
Flow : 0.0787 in ³	0.70	%	ISO 294-4
Water Absorption (Saturation, 73°F)	0.30	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.12	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	348000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	9720	psi	ISO 527-2/50
Tensile Stress (Break, 73°F)	10900	psi	ISO 527-2/50
Tensile Strain (Yield, 73°F)	6.3	%	ISO 527-2/50
Tensile Strain (Break, 73°F)	130	%	ISO 527-2/50
Nominal Tensile Strain at Break (73°F)	> 50	%	ISO 527-2/50
Flexural Modulus ⁴ (73°F)	348000	psi	ISO 178
Flexural Stress ⁴			ISO 178
73°F	14200	psi	
3.5% Strain, 73°F	10600	psi	
Flexural Strain at Flexural Strength ⁵ (73°F)	7.1	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁶			ISO 179/1eA
-22°F, Complete Break	7.6	ft·lb/in ²	
73°F, Partial Break	38	ft·lb/in ²	
Charpy Unnotched Impact Strength			ISO 179/1eU



-76°F	No Break	
-22°F	No Break	
73°F	No Break	
Notched Izod Impact Strength ⁶		ISO 180/A
-22°F, Complete Break	7.1 ft·lb/in ²	
73°F, Partial Break	33 ft·lb/in ²	
Multi-Axial Instrumented Impact Energy		ISO 6603-2
-22°F	51.6 ft·lb	
73°F	47.9 ft·lb	
Multi-Axial Instrumented Impact Peak Force		ISO 6603-2
-22°F	1480 lbf	
73°F	1280 lbf	
Hardness	Nominal Value Unit	Test Method
Ball Indentation Hardness	16500 psi	ISO 2039-1
Thermal	Nominal Value Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	280 °F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	259 °F	ISO 75-2/A
Glass Transition Temperature ⁷	293 °F	ISO 11357-2
Vicat Softening Temperature		
--	293 °F	ISO 306/B120
--	291 °F	ISO 306/B50
Ball Pressure Test (275°F)	Pass	IEC 60695-10-2
CLTE - Flow (73 to 131°F)	3.6E-5 in/in/°F	ISO 11359-2
CLTE - Transverse (73 to 131°F)	3.6E-5 in/in/°F	ISO 11359-2
Thermal Conductivity ⁸ (73°F)	1.4 Btu·in/hr/ft ² /°F	ISO 8302
Flammability	Nominal Value Unit	Test Method
Oxygen Index ⁹	27 %	ISO 4589-2
Flash Ignition Temperature	896 °F	ASTM D1929
Self Ignition Temperature	1022 °F	ASTM D1929

Processing Information

	Nominal Value Unit
Injection	
Drying Temperature - Dry Air Dryer	248 °F
Drying Time - Dry Air Dryer	2.0 to 3.0 hr
Suggested Max Moisture	< 0.020 %
Suggested Shot Size	30 to 70 %
Rear Temperature	500 to 518 °F
Middle Temperature	536 to 554 °F
Front Temperature	554 to 572 °F
Nozzle Temperature	572 to 590 °F
Processing (Melt) Temp	554 to 626 °F
Mold Temperature	176 to 248 °F
Back Pressure	725 to 2180 psi
Vent Depth	9.8E-4 to 3.0E-3 in

Injection Notes

Hold Pressure (% of Injection Pressure): 50 - 75%
Peripheral Screw Speed: 0.05 - 0.2 m/s
Standard Melt Temperature: 310°C

Notes

- 1 Typical properties: these are not to be construed as specifications.
- 2 Pellets
- 3 60x60x2mm, 500 bar
- 4 0.079 in/min
- 5 2.0 mm/min
- 6 3.0 mm
- 7 10°C/min

