

Makrolon® 2458

Polycarbonate

<https://yifuhuiplastic.com/>

Covestro - Polycarbonates

Technical Data

Product Description

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; easy release; injection molding - melt temperature 280 - 320°C; available in transparent and opaque colors

General

Material Status	•Commercial: Active		
Literature 1	•Technical Datasheet (English)		
UL Yellow Card 2	•E41613-233136		
Search for UL Yellow Card	•Covestro - Polycarbonates • Makrolon®		
Availability	•Africa & Middle East •Asia Pacific	•Europe •Latin America	•North America
Features	•Biocompatible •Ethylene Oxide Sterilizable	•Good Mold Release •Low Viscosity	•Steam Sterilizable
Uses	•Medical Devices	•Medical/Healthcare Applications	
Agency Ratings	•ISO 10993-1		
RoHS Compliance	•RoHS Compliant		
Appearance	•Clear/Transparent	•Colors Available	
Processing Method	•Injection Molding		
Multi-Point Data	•Creep Modulus vs. Time (ISO 11403-1)	•Secant Modulus vs. Strain (ISO 11403-1)	
	•Isochronous Stress vs. Strain (ISO 11403-1)	•Shear Modulus vs. Temperature (ISO 11403-1)	•Viscosity vs. Shear Rate (ISO 11403-2)
	•Isothermal Stress vs. Strain (ISO 11403-1)	•Specific Volume vs Temperature (ISO 11403-2)	
ISO Shortname	•ISO 7391-PC,MR,(,)-18-9		

Physical	Nominal ValueUnit	Test Method
Density (23°C)	1.20g/cm³	ISO 1183
Apparent (Bulk) Density 4	0.66g/cm³	ISO 60
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	20g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	19cm³/10min	ISO 1133
Molding Shrinkage		
Across Flow	0.50 to 0.70%	ISO 2577
Flow	0.50 to 0.70%	ISO 2577
Across Flow : 280°C, 2.00 mm 5	0.70%	ISO 294-4
Flow : 2.00 mm 5	0.65%	ISO 294-4
Water Absorption		ISO 62
Saturation, 23°C	0.30%	
Equilibrium, 23°C, 50% RH	0.12%	
Mechanical	Nominal ValueUnit	Test Method
Tensile Modulus (23°C)	2400MPa	ISO 527-1/1
Tensile Stress		ISO 527-2/50
Yield, 23°C	65.0MPa	
Break, 23°C	70.0MPa	
Tensile Strain		ISO 527-2/50
Yield, 23°C	6.1%	
Break, 23°C	130%	
Nominal Tensile Strain at Break (23°C)	> 50%	ISO 527-2/50
Tensile Creep Modulus		ISO 899-1
1 hr	2200MPa	
1000 hr	1900MPa	

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Mechanical	Nominal ValueUnit	Test Method
Flexural Modulus 6 (23°C)	2350 MPa	ISO 178
Flexural Stress 6		ISO 178
23°C	97.0MPa	
3.5% Strain, 23°C	73.0MPa	
Flexural Strain at Flexural Strength 6 (23°C)	7.1%	ISO 178
Impact	Nominal ValueUnit	Test Method
Charpy Notched Impact Strength 7		ISO 179/1eA
-30°C, Complete Break	14 kJ/m²	
23°C, Partial Break	65 kJ/m²	
Charpy Unnotched Impact Strength		ISO 179/1eU
-60°C	No Break	
-30°C	No Break	
23°C	No Break	
Notched Izod Impact Strength 7		ISO 180/A
-30°C, Complete Break	15 kJ/m²	
23°C, Partial Break	65 kJ/m²	
Multi-Axial Instrumented Impact Energy		ISO 6603-2
-30°C	65.0J	
23°C	55.0J	
Multi-Axial Instrumented Impact Peak Force		ISO 6603-2
-30°C	6000 N	
23°C	5100 N	
Hardness	Nominal ValueUnit	Test Method
Ball Indentation Hardness	115 MPa	ISO 2039-1
Thermal	Nominal ValueUnit	Test Method
Deflection Temperature Under Load		
0.45 MPa, Unannealed	139 °C	ISO 75-2/B ISO
1.8 MPa, Unannealed	125 °C	75-2/A ISO
Glass Transition Temperature 8	146 °C	11357-2
Vicat Softening Temperature		
--	146 °C	ISO 306/B120
--	145 °C	ISO 306/B50
Ball Pressure Test (138°C)	Pass	IEC 60695-10-
CLTE		2 ISO 11359-2
Flow : 23 to 55°C	6.5E-5 cm/cm/°C	
Transverse : 23 to 55°C	6.5E-5 cm/cm/°C	
Thermal Conductivity 9 (23°C)	0.20W/m/K	ISO 8302
Electrical	Nominal ValueUnit	Test Method
Surface Resistivity	1.0E+16 ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+16 ohms·cm	IEC 60093
Electric Strength (23°C, 1.00 mm)	34 kV/mm	IEC 60243-1
Relative Permittivity		IEC 60250
23°C, 100 Hz	3.10	
23°C, 1 MHz	3.00	
Dissipation Factor	5.0E-4	IEC 60250
23°C, 100 Hz	9.0E-3	
23°C, 1 MHz		
Comparative Tracking Index (Solution A)	250V	IEC 60112
Flammability	Nominal ValueUnit	Test Method
Oxygen Index 10	28%	ISO 4589-2
Flash Ignition Temperature	480 °C	ASTM D1929
Self Ignition Temperature	550 °C	ASTM D1929

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Optical	Nominal ValueUnit	Test Method
Refractive Index 11	1.586	ISO 489
Light Transmittance		ISO 13468-2
1000 µm	89.0 %	
2000 µm	89.0%	
3000 µm	88.0%	
4000 µm	87.0%	
Haze (3000 µm)	< 0.800%	ISO 14782
Injection		
	Nominal ValueUnit	
Drying Temperature - Dry Air Dryer	120 °C	
Drying Time - Dry Air Dryer	2.0 to 3.0hr	
Suggested Max Moisture	< 0.020%	
Suggested Shot Size	30 to 70%	
Rear Temperature	250 to 260°C	
Middle Temperature	270 to 280°C	
Front Temperature	280 to 290°C	
Nozzle Temperature	290 to 300°C	
Processing (Melt) Temp	280 to 320°C	
Mold Temperature	80 to 120°C	
Back Pressure	5.00 to 15.0MPa	
Vent Depth	0.025 to 0.075mm	
Injection Notes		
Peripheral Screw Speed: 0.05 - 0.2 m/s		
Hold Pressure (% of Injection Pressure): 50 - 75%		
Standard Melt Temperature: 300°C		

Notes

¹ These links provide you with access to supplier literature. We work hard to keep them up to date; however you may find the most current literature from the supplier.

² A UL Yellow Card contains UL-verified flammability and electrical characteristics. UL Prospector continually works to link Yellow Cards to individual plastic materials in Prospector, however this list may not include all of the appropriate links. It is important that you verify the association between these Yellow Cards and the plastic material found in Prospector. For a complete listing of Yellow Cards, visit the UL Yellow Card Search.

³ Typical properties: these are not to be construed as specifications.

⁴ Pellets

⁵ 60x60x2mm, 500 bar

⁶ 2.0 mm/min

⁷ 3 mm

⁸ 10°C/min

⁹ Across Flow

¹⁰ Procedure A

¹¹ Method A