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**Product Data Sheet &  
General Processing Conditions**

**RTP 3499-3 X 113393 C  
Liquid Crystal Polymer (LCP)  
LDS Platable  
Reinforced**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

| <b>PERMANENCE</b>                            | <b>English</b>             | <b>SI Metric</b> | <b>ASTM TEST</b> |
|----------------------------------------------|----------------------------|------------------|------------------|
| Specific Gravity                             | 1.74                       | 1.74             | D 792            |
| Molding Shrinkage<br>1/8 in (3.2 mm) section | 0.0010 in/in               | 0.10 %           | D 955            |
| <b>MECHANICAL</b>                            |                            |                  |                  |
| Impact Strength, Izod                        |                            |                  |                  |
| notched 1/8 in (3.2 mm) section              | 3.2 ft-lbs/in              | 171 J/m          | D 256            |
| unnotched 1/8 in (3.2 mm) section            | 14.0 ft-lbs/in             | 747 J/m          | D 4812           |
| Tensile Strength                             | 17000 psi                  | 117 MPa          | D 638            |
| Tensile Elongation                           | 2.0 %                      | 2.0 %            | D 638            |
| Tensile Modulus                              | 1.80 x 10 <sup>6</sup> psi | 12411 MPa        | D 638            |
| Flexural Strength                            | 21500 psi                  | 148 MPa          | D 790            |
| Flexural Modulus                             | 1.80 x 10 <sup>6</sup> psi | 12411 MPa        | D 790            |

**PROPERTY NOTES**

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

**GENERAL PROCESSING FOR INJECTION MOLDING**

|                    | <b>English</b>    | <b>SI Metric</b> |
|--------------------|-------------------|------------------|
| Injection Pressure | 12000 - 18000 psi | 83 - 124 MPa     |
| Melt Temperature   | 630 - 690 °F      | 332 - 366 °C     |
| Mold Temperature   | 150 - 250 °F      | 66 - 121 °C      |
| Drying             | 8 hrs @ 300 °F    | 8 hrs @ 149 °C   |
| Dew Point          | -20 °F            | -29 °C           |

**PROCESSING NOTES**

The key to successfully molding this material is to start mold open cycles as soon as the screw reaches its retracted position.