



**Product Data Sheet &
General Processing Conditions**

**RTP 399 X 127605
Polycarbonate (PC)
Glass Fiber
Flame Retardant**



PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.27	1.27	D 792
Melt Flow Rate			
@ 300 °C, / 1.2 kg	10.00 g/10 min	10.00 g/10 min	D 1238
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0030 - 0.0050 in/in	0.30 - 0.50 %	D 955

MECHANICAL

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	2.5 ft-lbs/in	133 J/m	D 256
unnotched 1/8 in (3.2 mm) section	35.0 ft-lbs/in	1869 J/m	D 4812
Tensile Strength	9500 psi	66 MPa	D 638
Tensile Elongation	5.0 - 8.0 %	5.0 - 8.0 %	D 638
Tensile Modulus	0.55 x 10 ⁶ psi	3792 MPa	D 638
Flexural Strength	16000 psi	110 MPa	D 790
Flexural Modulus	0.50 x 10 ⁶ psi	3448 MPa	D 790

THERMAL

Deflection Temperature			
@ 264 psi (1820 kPa)	290 °F	143 °C	D 648
@ 66 psi (455 kPa)	300 °F	149 °C	D 648
Ignition Resistance*			
Flammability	V-0 @ 0.04 in	V-0 @ 1.0 mm	UL94

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.

* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	550 - 600 °F	288 - 316 °C
Mold Temperature	180 - 250 °F	82 - 121 °C
Drying	4 hrs @ 250 °F	4 hrs @ 121 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-20 °F	-29 °C

PROCESSING NOTES

Desiccant Type Dryer Required.