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Ponciplastics.com



## Product Data Sheet & General Processing Conditions

**RTP 399 X 129972 C**  
**Polycarbonate (PC)**  
**Flame Retardant**  
**Transparent**



### PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

| PERMANENCE                                   | English               | SI Metric     | ASTM TEST |
|----------------------------------------------|-----------------------|---------------|-----------|
| Specific Gravity                             | 1.24                  | 1.24          | D 792     |
| Molding Shrinkage<br>1/8 in (3.2 mm) section | 0.0050 - 0.0080 in/in | 0.50 - 0.80 % | D 955     |

### MECHANICAL

|                                                          |                            |          |        |
|----------------------------------------------------------|----------------------------|----------|--------|
| Impact Strength, Izod<br>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                        | No Break                   | No Break | D 4812 |
| Tensile Strength                                         | 9500 psi                   | 66 MPa   | D 638  |
| Tensile Elongation                                       | > 10.0 %                   | > 10.0 % | D 638  |
| Tensile Modulus                                          | 0.30 x 10 <sup>6</sup> psi | 2068 MPa | D 638  |
| Flexural Strength                                        | 15000 psi                  | 103 MPa  | D 790  |
| Flexural Modulus                                         | 0.40 x 10 <sup>6</sup> psi | 2758 MPa | D 790  |

### THERMAL

|                                                |               |              |       |
|------------------------------------------------|---------------|--------------|-------|
| Deflection Temperature<br>@ 264 psi (1820 kPa) | 270 °F        | 132 °C       | D 648 |
| @ 66 psi (455 kPa)                             | 280 °F        | 138 °C       | D 648 |
| Ignition Resistance*                           |               |              |       |
| Flammability                                   | V-0 @ 1/16 in | V-0 @ 1.5 mm | UL94  |
| Flammability                                   | 5VA @ 1/8 in  | 5VA @ 3.0 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.