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Product Data Sheet & General Processing Conditions

RTP 399 X 137054 Polycarbonate (PC) Thermally Conductive Electrically Conductive

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.31	1.31	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0020 - 0.0040 in/in	0.20 - 0.40 %	D 955

MECHANICAL

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	0.8 ft-lbs/in	40 J/m	D 256
unnotched 1/8 in (3.2 mm) section	4.0 ft-lbs/in	214 J/m	D 4812
Tensile Strength	6500 psi	45 MPa	D 638
Tensile Elongation	1.0 - 3.0 %	1.0 - 3.0 %	D 638
Tensile Modulus	0.65 x 10 ⁶ psi	4482 MPa	D 638
Flexural Strength	11000 psi	76 MPa	D 790
Flexural Modulus	0.65 x 10 ⁶ psi	4482 MPa	D 790

ELECTRICAL

Volume Resistivity	< 1E6 ohm.cm	< 1E6 ohm.cm	D 257
Surface Resistivity	< 1E10 ohm/sq	< 1E10 ohm/sq	D 257

THERMAL

Thermal Conductivity			
Through-plane	5.90 (BTU.in)/(hr.ft ² .°F)	0.85 W/(m.K)	E 1530
In-plane	27.77 (BTU.in)/(hr.ft ² .°F)	4.00 W/(m.K)	E 1461-92

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

	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.