



**Product Data Sheet &  
General Processing Conditions**

**RTP 300 2405  
Polycarbonate (PC)**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.20	1.20	D 792
Melt Flow Rate @ 300 °C, / 1.2 kg	20.00 g/10 min	20.00 g/10 min	D 1238
Molding Shrinkage 1/8 in (3.2 mm) section	0.0050 - 0.0070 in/in	0.50 - 0.70 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	14.0 ft-lbs/in	747 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	9100 psi	63 MPa	D 638
Tensile Elongation	6.0 %	6.0 %	D 638
Tensile Modulus	0.35 x 10 <sup>6</sup> psi	2413 MPa	D 638
Flexural Strength	12000 psi	83 MPa	D 790
Flexural Modulus	0.33 x 10 <sup>6</sup> psi	2275 MPa	D 790
Hardness Rockwell, R	118	118	D 785

**ELECTRICAL**

Dielectric Strength, S/T, in oil	760 VPM	29.9 kV/mm	D 149
Dielectric Constant, 1 MHz, Dry	2.9	2.9	D 150
Dissipation Factor, 1 MHz, Dry	0.0100	0.0100	D 150
Arc Resistance	120 s	120 s	D 495

**THERMAL**

Deflection Temperature @ 264 psi (1820 kPa)	259 °F	126 °C	D 648
@ 66 psi (455 kPa)	273 °F	134 °C	D 648
Ignition Resistance* Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635
Limiting Oxygen Index**	26.0 %	26.00 %	D 2863

**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.

\*\* Values per RTP Company testing.

**GENERAL PROCESSING FOR INJECTION MOLDING**

	<b>English</b>	<b>SI Metric</b>
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**

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Desiccant Type Dryer Required.

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This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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