



**Product Data Sheet &
General Processing Conditions**

**RTP 399 X 113385 B
Polycarbonate (PC)
LDS Platable**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.33	1.33	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0070 in/in	0.70 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	6.1 ft-lbs/in	326 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	7750 psi	53 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.35 x 10 ⁶ psi	2413 MPa	D 638
Flexural Strength	12800 psi	88 MPa	D 790
Flexural Modulus	0.35 x 10 ⁶ psi	2413 MPa	D 790

ELECTRICAL

Dielectric Constant, 1 MHz, Dry	3.1	3.1	D 150
Dissipation Factor, 1 MHz, Dry	0.0150	0.0150	D 150

THERMAL

Deflection Temperature @ 66 psi (455 kPa)	285 °F	141 °C	D 648
--	--------	--------	-------

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.