



**Product Data Sheet &  
General Processing Conditions**

**PermaStat® 2501  
Polycarbonate/ABS Alloy (PC/ABS)  
Glass Fiber  
ESD Protection  
Permanently Anti-static**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.22	1.22	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0025 - 0.0045 in/in	0.25 - 0.45 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	2.0 ft-lbs/in	107 J/m	D 256
unnotched 1/8 in (3.2 mm) section	8.0 ft-lbs/in	427 J/m	D 4812
Tensile Strength	8500 psi	59 MPa	D 638
Tensile Elongation	4.0 - 6.0 %	4.0 - 6.0 %	D 638
Tensile Modulus	0.55 x 10 <sup>6</sup> psi	3792 MPa	D 638
Flexural Strength	13000 psi	90 MPa	D 790
Flexural Modulus	0.55 x 10 <sup>6</sup> psi	3792 MPa	D 790

**ELECTRICAL**

Volume Resistivity	1E9 - 9.9E10 ohm.cm	1E9 - 9.9E10 ohm.cm	D 257
Surface Resistivity	1E10 - 9.9E11 ohm/sq	1E10 - 9.9E11 ohm/sq	D 257
Surface Resistance	1E9 - 9.9E10 ohm	1E9 - 9.9E10 ohm	ESD STM11.11
Static Decay MIL-PRF-81705D, 5kV to 50 V, 12% RH	< 2.00 s	< 2.00 s	FTMS101C 4046.1

**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**

	<b>English</b>	<b>SI Metric</b>
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	470 - 500 °F	243 - 260 °C
Mold Temperature	125 - 200 °F	52 - 93 °C
Drying	4 hrs @ 200 °F	4 hrs @ 93 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-20 °F	-29 °C

**PROCESSING NOTES**

Do not exceed 520 °F (270 °C) melt temperature.  
Desiccant Type Dryer Required.