



**Product Data Sheet &  
General Processing Conditions**

**RTP 2505 FR  
Polycarbonate/ABS Alloy (PC/ABS)  
Glass Fiber  
Flame Retardant**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Primary Additive	30 %	30 %	
Specific Gravity	1.45	1.45	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0015 - 0.0030 in/in	0.15 - 0.30 %	D 955
Water Absorption, 24 hrs @ 23°C	0.100 %	0.100 %	D 570

**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	12.0 ft-lbs/in	641 J/m	D 4812
Tensile Strength	18000 psi	124 MPa	D 638
Tensile Elongation	1.5 - 2.5 %	1.5 - 2.5 %	D 638
Tensile Modulus	1.40 x 10 <sup>6</sup> psi	9653 MPa	D 638
Flexural Strength	27000 psi	186 MPa	D 790
Flexural Modulus	1.35 x 10 <sup>6</sup> psi	9308 MPa	D 790
Hardness Rockwell, R	119	119	D 785

**ELECTRICAL**

Volume Resistivity	> 1E16 ohm.cm	> 1E16 ohm.cm	D 257
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**THERMAL**

Deflection Temperature @ 264 psi (1820 kPa)	295 °F	146 °C	D 648
Ignition Resistance*			
Flammability**	V-0 @ 1/16 in	V-0 @ 1.5 mm	D 3801
Flammability**	5VA @ 1/8 in	5VA @ 3.0 mm	D 5048

**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	470 - 525 °F	243 - 274 °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**

Desiccant Type Dryer Required.