



**Product Data Sheet &  
General Processing Conditions**

**RTP 1800 A  
Polycarbonate/Acrylic Alloy (PC/PMMA)  
Base Resin**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.15	1.15	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0030 - 0.0090 in/in	0.30 - 0.90 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	27.5 ft-lbs/in	1468 J/m	D 256
unnotched 1/8 in (3.2 mm) section	38.0 ft-lbs/in	2029 J/m	D 4812
Tensile Strength	7700 psi	53 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.30 x 10 <sup>6</sup> psi	2068 MPa	D 638
Flexural Strength	11500 psi	79 MPa	D 790
Flexural Modulus	0.30 x 10 <sup>6</sup> psi	2068 MPa	D 790

**THERMAL**

Ignition Resistance* Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635
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**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	8000 - 12000 psi	55 - 83 MPa
Melt Temperature	460 - 510 °F	238 - 266 °C
Mold Temperature	90 - 150 °F	32 - 66 °C
Drying	3 - 6 hrs @ 180 °F	3 - 6 hrs @ 82 °C
Moisture Content	0.02 %	0.02 %
Dew Point	0 °F	-18 °C

**PROCESSING NOTES**

Desiccant Type Dryer Required.