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Product Data Sheet & General Processing Conditions

RTP 399 X 138998 C Polycarbonate (PC) Thermally Conductive Electrically Insulative

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.77	1.77	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0020 - 0.0050 in/in	0.20 - 0.50 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.5 ft-lbs/in	27 J/m	D 256
unnotched 1/8 in (3.2 mm) section	1.2 ft-lbs/in	64 J/m	D 4812
Tensile Strength	7500 psi	52 MPa	D 638
Tensile Elongation	< 1.0 %	< 1.0 %	D 638
Tensile Modulus	2.10 x 10 ⁶ psi	14480 MPa	D 638
Flexural Strength	12000 psi	83 MPa	D 790
Flexural Modulus	2.20 x 10 ⁶ psi	15169 MPa	D 790

ELECTRICAL

Surface Resistivity	> 1E12 ohm/sq	> 1E12 ohm/sq	D 257
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THERMAL

Ignition Resistance*			
Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635
Thermal Conductivity			
Through-plane	6.94 (BTU.in)/(hr.ft ² .°F)	1.00 W/(m.K)	E 1530
In-plane	34.72 (BTU.in)/(hr.ft ² .°F)	5.00 W/(m.K)	E 1461-92

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

	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.