Product Data Sheet &
General Processing Conditions

RTP 2500 FR-3010
Polycarbonate/ABS Alloy (PC/ABS)
Flame Retardant
Bromine/Chlorine Free

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.20	1.20	D 792
Melt Flow Rate			
@ 240 °C, / 5.0 kg	15.00 g/10 min	15.00 g/10 min	D 1238
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0050 - 0.0080 in/in	0.50 - 0.80 %	D 955
MECHANICAL			
Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	13.0 ft-lbs/in	694 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	8500 psi	59 MPa	D 638
Tensile Elongation	> 40.0 %	> 40.0 %	D 638
Tensile Modulus	0.39 x 10^6 psi	2689 MPa	D 638
Flexural Strength	15000 psi	103 MPa	D 790
Flexural Modulus	0.42 x 10^6 psi	2896 MPa	D 790
ELECTRICAL			
Dielectric Strength, S/T, in oil	750 VPM	29.5 kV/mm	D 149
Volume Resistivity	> 1E15 ohm.cm	> 1E15 ohm.cm	D 257
THERMAL			
Deflection Temperature			
@ 264 psi (1820 kPa)	205 °F	96 °C	D 648
Ignition Resistance*			
Flammability	V-0 @ 1/16 in	V-0 @ 1.5 mm	UL94
Flammability	5VA @ 1/8 in	5VA @ 3.0 mm	UL94
Glow Wire Ignitability Temperature	850 °C @ 0.040 in	850 °C @ 1.0 mm	IEC 60695-2-13
Glow Wire Flammability Index	960 °C @ 0.040 in	960 °C @ 1.0 mm	IEC 60695-2-12

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.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
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.

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This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a “trial and error” basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.