Product Data Sheet &
General Processing Conditions

PermaStat® 2500 FR A
Polycarbonate/ABS Alloy (PC/ABS)
ESD Protection
Permanently Anti-static
Flame Retardant
UL94 V-0

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.30	1.30	D 792
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0060 - 0.0080 in/in	0.60 - 0.80 %	D 955
MECHANICAL			
Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	6.0 ft-lbs/in	320 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	6000 psi	41 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.30 x 10^6 psi	2068 MPa	D 638
Flexural Strength	10500 psi	72 MPa	D 790
Flexural Modulus	0.30 x 10^6 psi	2068 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
THERMAL			
Deflection Temperature			
@ 264 psi (1820 kPa)	192 °F	89 °C	D 648
Ignition Resistance*			
Flammability	V-0 @ 1/16 in	V-0 @ 1.5 mm	UL94

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	430 - 500 °F	221 - 260 °C
Mold Temperature	100 - 180 °F	38 - 82 °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.

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