



**Product Data Sheet &
General Processing Conditions**

**PermaStat® 2501 FR
Polycarbonate/ABS Alloy (PC/ABS)
Glass Fiber
ESD Protection
Permanently Anti-static
Flame Retardant**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.38	1.38	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0025 - 0.0045 in/in	0.25 - 0.45 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.0 ft-lbs/in	53 J/m	D 256
unnotched 1/8 in (3.2 mm) section	6.0 ft-lbs/in	320 J/m	D 4812
Tensile Strength	7000 psi	48 MPa	D 638
Tensile Elongation	2.0 - 4.0 %	2.0 - 4.0 %	D 638
Tensile Modulus	0.50 x 10 ⁶ psi	3448 MPa	D 638
Flexural Strength	12000 psi	83 MPa	D 790
Flexural Modulus	0.45 x 10 ⁶ psi	3103 MPa	D 790

ELECTRICAL

Volume Resistivity	1.0E8 - 9.9E9 ohm.cm	1.0E8 - 9.9E9 ohm.cm	D 257
Surface Resistivity	1.0E10 - 9.9E11 ohm/sq	1.0E10 - 9.9E11 ohm/sq	D 257
Surface Resistance	1.0E9 - 9.9E10 ohm	1.0E9 - 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

Ignition Resistance* Flammability**	V-0 @ 1/16 in	V-0 @ 1.5 mm	D 3801
--	---------------	--------------	--------

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	470 - 500 °F	243 - 260 °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

Do not exceed 520 °F (270 °C) melt temperature.

Desiccant Type Dryer Required.

4 Nov 2004 LCR

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.

No information supplied by RTP Company constitutes a warranty regarding product performance or use. Any information regarding performance or use is only offered as suggestion for investigation for use, based upon RTP Company or other customer experience. RTP Company makes no warranties, expressed or implied, concerning the suitability or fitness of any of its products for any particular purpose. It is the responsibility of the customer to determine that the product is safe, lawful and technically suitable for the intended use. The disclosure of information herein is not a license to operate under, or a recommendation to infringe any patents.

RTP COMPANY • 580 EAST FRONT STREET • WINONA, MN 55987 • 507-454-6900