

RTP 2599 X 131264 A

Polycarbonate + ABS

RTP Company

Message:

Fiber Reinforced - Electrically Conductive - EMI/RFI Shielding

General Information			
Features	Conductivity		
	Electromagnetic shielding (EMI)		
	Radio frequency shielding (RFI)		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.31	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.10 - 0.40	%	ASTM D955
Moisture Content	0.020	%	
Static Decay		sec	FTMS 101C 4046.1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6890	MPa	ASTM D638
Tensile Strength	88.3	MPa	ASTM D638
Tensile Elongation (Yield)	1.0 - 2.0	%	ASTM D638
Flexural Modulus	6890	MPa	ASTM D790
Flexural Strength	141	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	69	J/m	ASTM D256
Unnotched Izod Impact (3.20 mm)	410	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	122	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity			
--	< 1.0E+4	ohms	ASTM D257
--	< 1.0E+3	ohms	ESD STM11.11
Volume Resistivity	< 10	ohms·cm	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	93.3	°C	
Drying Time	4.0	hr	
Dew Point	-28.9	°C	
Processing (Melt) Temp	243 - 274	°C	

Mold Temperature	51.7 - 93.3	°C
Injection Pressure	68.9 - 103	MPa
Injection instructions		

Use a reverse barrel profile. Remove hopper magnets. Allow 4 - 5 shots to properly disperse the conductive fibers. The surface finish should have a silver streaking appearance, not clumps. Remove hopper magnets. Desiccant Type Dryer Required.

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