

RTP 2599 X 125737 C

Polycarbonate + ABS

RTP Company

Message:

Stainless Steel Fiber - EMI/RFI Shielding - Electrically Conductive - Flame Retardant

General Information			
Filler / Reinforcement	Stainless steel fiber		
Features	Conductivity		
	Electromagnetic shielding (EMI)		
	Radio frequency shielding (RFI)		
	Flame retardancy		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.10 - 0.30	%	ASTM D955
Moisture Content	0.020	%	
Static Decay		sec	FTMS 101C 4046.1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11000	MPa	ASTM D638
Tensile Strength	110	MPa	ASTM D638
Tensile Elongation (Yield)	1.5	%	ASTM D638
Flexural Modulus	11000	MPa	ASTM D790
Flexural Strength	193	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	53	J/m	ASTM D256
Unnotched Izod Impact (3.20 mm)	400	J/m	ASTM D4812
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
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm, ** Values per RTP Company testing.)	V-0		UL 94
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. Use a reverse barrel profile. To maximize fiber length, the following injection barrel, screw, and tip designs should be followed. L/D ratio 16/1 - 22/1, Compression ratio 2:1, Flight depth 0.200 in (5 mm) minimum, in feed section, Screw diameter 0.65 - 0.8 in. Remove hopper magnets. Desiccant Type Dryer Required.

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