

(+) 18816996168

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**Product Data Sheet &
General Processing Conditions**

**RTP 3405-1
Liquid Crystal Polymer (LCP)
Glass Fiber**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	30 %	30 %	
Specific Gravity	1.62	1.62	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0010 - 0.0020 in/in	0.10 - 0.20 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.6 ft-lbs/in	85 J/m	D 256
unnotched 1/8 in (3.2 mm) section	7.0 ft-lbs/in	374 J/m	D 4812
Tensile Strength	24000 psi	165 MPa	D 638
Tensile Elongation	2.0 - 3.0 %	2.0 - 3.0 %	D 638
Tensile Modulus	2.00 x 10 ⁶ psi	13790 MPa	D 638
Flexural Strength	34000 psi	234 MPa	D 790
Flexural Modulus	1.95 x 10 ⁶ psi	13445 MPa	D 790

THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	435 °F	224 °C	D 648
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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.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	5000 - 12000 psi	34 - 83 MPa
Melt Temperature	520 - 575 °F	271 - 302 °C
Mold Temperature	100 - 200 °F	38 - 93 °C
Drying	4 hrs @ 300 °F	4 hrs @ 149 °C

PROCESSING NOTES

The key to successfully molding this material is to start mold open cycles as soon as the screw reaches its retracted position.