

(+) 18816996168

Ponciplastics.com



**Product Data Sheet &  
General Processing Conditions**

**RTP 800 TFE 20 SI 2  
Acetal (POM)  
PTFE & Silicone Lubricated**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

| PERMANENCE                                   | English      | SI Metric | ASTM<br>TEST |
|----------------------------------------------|--------------|-----------|--------------|
| Primary Additive                             | 20 %         | 20 %      |              |
| Specific Gravity                             | 1.50         | 1.50      | D 792        |
| Molding Shrinkage<br>1/8 in (3.2 mm) section | 0.0220 in/in | 2.20 %    | D 955        |

**MECHANICAL**

|                                                          |                            |          |        |
|----------------------------------------------------------|----------------------------|----------|--------|
| Impact Strength, Izod<br>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                        | 11.0 ft-lbs/in             | 587 J/m  | D 4812 |
| Tensile Strength                                         | 5500 psi                   | 38 MPa   | D 638  |
| Tensile Elongation                                       | > 10.0 %                   | > 10.0 % | D 638  |
| Tensile Modulus                                          | 0.32 x 10 <sup>6</sup> psi | 2206 MPa | D 638  |
| Flexural Strength                                        | 8900 psi                   | 61 MPa   | D 790  |
| Flexural Modulus                                         | 0.29 x 10 <sup>6</sup> psi | 2000 MPa | D 790  |

**THERMAL**

|                                                |              |             |       |
|------------------------------------------------|--------------|-------------|-------|
| Deflection Temperature<br>@ 264 psi (1820 kPa) | 220 °F       | 104 °C      | D 648 |
| Ignition Resistance*<br>Flammability**         | HB @ 1/16 in | HB @ 1.5 mm | D 635 |

**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   | 360 - 425 °F      | 182 - 218 °C   |
| Mold Temperature   | 175 - 225 °F      | 79 - 107 °C    |
| Drying             | 2 hrs @ 250 °F    | 2 hrs @ 121 °C |
| Moisture Content   | 0.15 %            | 0.15 %         |
| Dew Point          | -25 °F            | -32 °C         |

**PROCESSING NOTES**

Desiccant Type Dryer Required.