



**Product Data Sheet &  
General Processing Conditions**

**RTP 883 TFE 15  
Acetal (POM)  
Carbon Fiber Reinforced  
PTFE Lubricated**

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

| PERMANENCE                                   | English               | SI Metric     | ASTM TEST |
|----------------------------------------------|-----------------------|---------------|-----------|
| Primary Additive                             | 20 %                  | 20 %          |           |
| Specific Gravity                             | 1.50                  | 1.50          | D 792     |
| Molding Shrinkage<br>1/8 in (3.2 mm) section | 0.0010 - 0.0030 in/in | 0.10 - 0.30 % | D 955     |

**MECHANICAL**

|                                                          |                            |             |        |
|----------------------------------------------------------|----------------------------|-------------|--------|
| Impact Strength, Izod<br>notched 1/8 in (3.2 mm) section | 1.2 ft-lbs/in              | 64 J/m      | D 256  |
| unnotched 1/8 in (3.2 mm) section                        | 11.0 ft-lbs/in             | 587 J/m     | D 4812 |
| Tensile Strength                                         | 17000 psi                  | 117 MPa     | D 638  |
| Tensile Elongation                                       | 2.0 - 3.0 %                | 2.0 - 3.0 % | D 638  |
| Tensile Modulus                                          | 1.80 x 10 <sup>6</sup> psi | 12411 MPa   | D 638  |
| Flexural Strength                                        | 28000 psi                  | 193 MPa     | D 790  |
| Flexural Modulus                                         | 1.70 x 10 <sup>6</sup> psi | 11722 MPa   | D 790  |

**THERMAL**

|                                        |              |             |       |
|----------------------------------------|--------------|-------------|-------|
| 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.