



**Product Data Sheet &
General Processing Conditions**

**RTP 4000 TFE 15
Polyphthalamide (PPA)
PTFE Lubricated**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.29	1.29	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0150 - 0.0250 in/in	1.50 - 2.50 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.9 ft-lbs/in	48 J/m	D 256
unnotched 1/8 in (3.2 mm) section	10.0 ft-lbs/in	534 J/m	D 4812
Tensile Strength	11000 psi	76 MPa	D 638
Tensile Elongation	2.0 - 4.0 %	2.0 - 4.0 %	D 638
Tensile Modulus	0.50 x 10 ⁶ psi	3448 MPa	D 638
Flexural Strength	20000 psi	138 MPa	D 790
Flexural Modulus	0.50 x 10 ⁶ psi	3448 MPa	D 790

ELECTRICAL

Volume Resistivity	1E14 - 1E16 ohm.cm	1E14 - 1E16 ohm.cm	D 257
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THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	290 °F	143 °C	D 648
Ignition Resistance*			
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 - 18000 psi	69 - 124 MPa
Melt Temperature	575 - 625 °F	302 - 329 °C
Mold Temperature	275 - 325 °F	135 - 163 °C
Drying	4 - 6 hrs @ 225 °F	4 - 6 hrs @ 107 °C
Moisture Content	0.05 %	0.05 %
Dew Point	-25 °F	-32 °C

PROCESSING NOTES

Desiccant Type Dryer Required.