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Product Data Sheet & General Processing Conditions

RTP 4201 Thermoplastic Polyimide (TPI) Glass Fiber

Properties are based on annealed specimens.

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	10 %	10 %	
Specific Gravity	1.40	1.40	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0120 in/in	1.20 %	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	15.0 ft-lbs/in	801 J/m	D 4812
Tensile Strength	18000 psi	124 MPa	D 638
Tensile Elongation	4.0 %	4.0 %	D 638
Tensile Modulus	0.90 x 10 ⁶ psi	6206 MPa	D 638
Flexural Strength	28000 psi	193 MPa	D 790
Flexural Modulus	0.80 x 10 ⁶ psi	5516 MPa	D 790

THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	525 °F	274 °C	D 648
Ignition Resistance*			
Flammability**	V-0 @ 1/16 in	V-0 @ 1.5 mm	D 3801

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	20000 - 28000 psi	138 - 193 MPa
Melt Temperature	750 - 780 °F	399 - 416 °C
Mold Temperature	350 - 450 °F	177 - 232 °C
Drying	6 hrs @ 400 °F	6 hrs @ 204 °C
Moisture Content	0.01 %	0.01 %
Dew Point	-40 °F	-40 °C

PROCESSING NOTES

Desiccant Type Dryer Required.