



**Product Data Sheet &
General Processing Conditions**

**RTP 600 TFE 5
Acrylonitrile Butadiene Styrene
(ABS)
PTFE Lubricated**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	5 %	5 %	
Specific Gravity	1.08	1.08	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0050 in/in	0.50 %	D 955
MECHANICAL			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	3.0 ft-lbs/in	160 J/m	D 256
unnotched 1/8 in (3.2 mm) section	15.0 ft-lbs/in	801 J/m	D 4812
Tensile Strength	6000 psi	41 MPa	D 638
Tensile Elongation	10.0 - 15.0 %	10.0 - 15.0 %	D 638
Tensile Modulus	0.38 x 10 ⁶ psi	2620 MPa	D 638
Flexural Strength	11000 psi	76 MPa	D 790
Flexural Modulus	0.37 x 10 ⁶ psi	2551 MPa	D 790
THERMAL			
Deflection Temperature @ 264 psi (1820 kPa)	210 °F	99 °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 - 15000 psi	69 - 103 MPa
Melt Temperature	400 - 460 °F	204 - 238 °C
Mold Temperature	145 - 185 °F	63 - 85 °C
Drying	2 hrs @ 180 °F	2 hrs @ 82 °C
Moisture Content	0.10 %	0.10 %
Dew Point	0 °F	-18 °C

PROCESSING NOTES

Desiccant Type Dryer Required.