



**Product Data Sheet &  
General Processing Conditions**

**RTP 605 TFE 15  
Acrylonitrile Butadiene Styrene  
(ABS)  
Glass Fiber Reinforced  
PTFE Lubricated**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Primary Additive	30 %	30 %	
Specific Gravity	1.40	1.40	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0010 in/in	0.10 %	D 955

**MECHANICAL**

Impact Strength, Izod 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	5.0 ft-lbs/in	267 J/m	D 4812
Tensile Strength	15000 psi	103 MPa	D 638
Tensile Elongation	1.0 - 2.0 %	1.0 - 2.0 %	D 638
Tensile Modulus	1.40 x 10 <sup>6</sup> psi	9653 MPa	D 638
Flexural Strength	21000 psi	145 MPa	D 790
Flexural Modulus	1.30 x 10 <sup>6</sup> psi	8964 MPa	D 790

**THERMAL**

Deflection Temperature @ 264 psi (1820 kPa)	215 °F	102 °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**

	<b>English</b>	<b>SI Metric</b>
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.