




**Product Data Sheet &
General Processing Conditions**

**RTP 204 D TFE 15 FR
Nylon 6/12 (PA)
Glass Fiber
PTFE Lubricated
Flame Retardant
UL94 V-1**



RTP 204 D TFE 15 FR offers an excellent combination of physical strength, moduli, wear resistance, low moisture absorption and ignition resistance.

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	25 %	25 %	
Specific Gravity	1.64	1.64	D 792
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0015 - 0.0040 in/in	0.15 - 0.40 %	D 955
Water Absorption, 24 hrs @ 23°C	0.200 %	0.200 %	D 570

MECHANICAL

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	1.7 ft-lbs/in	91 J/m	D 256
unnotched 1/8 in (3.2 mm) section	12.0 ft-lbs/in	641 J/m	D 4812
Tensile Strength	17000 psi	117 MPa	D 638
Tensile Elongation	2.0 - 3.5 %	2.0 - 3.5 %	D 638
Tensile Modulus	1.30 x 10 ⁶ psi	8964 MPa	D 638
Flexural Strength	26000 psi	179 MPa	D 790
Flexural Modulus	1.25 x 10 ⁶ psi	8619 MPa	D 790
Hardness			
Rockwell, R	117	117	D 785

ELECTRICAL

Dielectric Strength, S/T, in oil	500 VPM	19.7 kV/mm	D 149
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THERMAL

Deflection Temperature			
@ 264 psi (1820 kPa)	420 °F	216 °C	D 648
@ 66 psi (455 kPa)	430 °F	221 °C	D 648
Ignition Resistance*			
Flammability	V-1 @ 1/32 in	V-1 @ 0.8 mm	UL94

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.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	10000 - 18000 psi	69 - 124 MPa
Melt Temperature	480 - 545 °F	249 - 285 °C
Mold Temperature	140 - 200 °F	60 - 93 °C
Drying	4 hrs @ 175 °F	4 hrs @ 79 °C
Moisture Content	0.20 %	0.20 %

Dew Point

0 °F

-18 °C

PROCESSING NOTES

Desiccant Type Dryer Required.