



**Product Data Sheet &
General Processing Conditions**

**RTP 205 D HS TFE 15
Nylon 6/12 (PA)
Glass Fiber
Heat Stabilized
PTFE Lubricated**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

| PERMANENCE | English | SI Metric | ASTM TEST |
|--|-----------------------|------------------|------------------|
| Primary Additive | 30 % | 30 % | |
| Specific Gravity | 1.42 | 1.42 | D 792 |
| Molding Shrinkage 1/8 in (3.2 mm) section | 0.0030 - 0.0080 in/in | 0.30 - 0.80 % | D 955 |

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 | 16.0 ft-lbs/in | 854 J/m | D 4812 |
| Tensile Strength | 18500 psi | 128 MPa | D 638 |
| Tensile Elongation | 2.5 - 4.0 % | 2.5 - 4.0 % | D 638 |
| Tensile Modulus | 1.25 x 10 ⁶ psi | 8619 MPa | D 638 |
| Flexural Strength | 28500 psi | 197 MPa | D 790 |
| Flexural Modulus | 1.15 x 10 ⁶ psi | 7929 MPa | D 790 |

THERMAL

| | | | |
|--|--------------|-------------|-------|
| Deflection Temperature @ 264 psi (1820 kPa) | 420 °F | 216 °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 | 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.