



**Product Data Sheet &
General Processing Conditions**

**RTP 1000 HI FR A
Polybutylene Terephthalate (PBT)
Impact Modified
Flame Retardant**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.35	1.35	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0180 - 0.0220 in/in	1.80 - 2.20 %	D 955
MECHANICAL			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	2.0 ft-lbs/in	107 J/m	D 256
unnotched 1/8 in (3.2 mm) section	35.0 ft-lbs/in	1869 J/m	D 4812
Tensile Strength	6200 psi	43 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.30 x 10 ⁶ psi	2068 MPa	D 638
Flexural Strength	10000 psi	69 MPa	D 790
Flexural Modulus	0.32 x 10 ⁶ psi	2206 MPa	D 790
THERMAL			
Deflection Temperature @ 264 psi (1820 kPa)	150 °F	66 °C	D 648
@ 66 psi (455 kPa)	300 °F	149 °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	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	460 - 520 °F	238 - 271 °C
Mold Temperature	175 - 225 °F	79 - 107 °C
Drying	4 hrs @ 250 °F	4 hrs @ 121 °C
Moisture Content	0.03 %	0.03 %
Dew Point	-20 °F	-29 °C

PROCESSING NOTES

Desiccant Type Dryer Required.