



**Product Data Sheet &
General Processing Conditions**

**RTP 1000 HI
Polybutylene Terephthalate (PBT)
Impact Modified**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.22	1.22	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0100 - 0.0300 in/in	1.00 - 3.00 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	18.0 ft-lbs/in	961 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	5300 psi	37 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.25 x 10 ⁶ psi	1724 MPa	D 638
Flexural Strength	8300 psi	57 MPa	D 790
Flexural Modulus	0.25 x 10 ⁶ psi	1724 MPa	D 790

THERMAL

Ignition Resistance* Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635
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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.