



**Product Data Sheet &
General Processing Conditions**

**RTP 300 TFE 5
Polycarbonate (PC)
PTFE Lubricated**

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 | 0.0050 - 0.0080 in/in | 0.50 - 0.80 % | D 955 |

MECHANICAL

| | | | |
|--|----------------------------|----------|--------|
| Impact Strength, Izod notched 1/8 in (3.2 mm) section | 2.8 ft-lbs/in | 149 J/m | D 256 |
| unnotched 1/8 in (3.2 mm) section | No Break | No Break | D 4812 |
| Tensile Strength | 8500 psi | 59 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 | 13500 psi | 93 MPa | D 790 |
| Flexural Modulus | 0.35 x 10 ⁶ psi | 2413 MPa | D 790 |

ELECTRICAL

| | | | |
|--------------------|--------------------|--------------------|-------|
| Volume Resistivity | 1E14 - 1E16 ohm.cm | 1E14 - 1E16 ohm.cm | D 257 |
|--------------------|--------------------|--------------------|-------|

THERMAL

| | | | |
|--|--------------|-------------|-------|
| Deflection Temperature @ 264 psi (1820 kPa) | 265 °F | 129 °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 - 15000 psi | 69 - 103 MPa |
| Melt Temperature | 550 - 600 °F | 288 - 316 °C |
| Mold Temperature | 180 - 250 °F | 82 - 121 °C |
| Drying | 4 hrs @ 250 °F | 4 hrs @ 121 °C |
| Moisture Content | 0.02 % | 0.02 % |
| Dew Point | -20 °F | -29 °C |

PROCESSING NOTES

Desiccant Type Dryer Required.