



**Product Data Sheet &  
General Processing Conditions**

**RTP 302 HF TFE 10  
Polycarbonate (PC)  
Glass Fiber  
PTFE Lubricated  
High Flow**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

| <b>PERMANENCE</b>                            | <b>English</b>        | <b>SI Metric</b> | <b>ASTM TEST</b> |
|--|-----------------------|------------------|------------------|
| Primary Additive                             | 15 %                  | 15 %             |                  |
| Specific Gravity                             | 1.37                  | 1.37             | D 792            |
| Molding Shrinkage<br>1/8 in (3.2 mm) section | 0.0010 - 0.0030 in/in | 0.10 - 0.30 %    | D 955            |

**MECHANICAL**

|  |                            |             |        |
|--|----------------------------|-------------|--------|
| Impact Strength, Izod<br>notched 1/8 in (3.2 mm) section | 1.8 ft-lbs/in              | 96 J/m      | D 256  |
| unnotched 1/8 in (3.2 mm) section                        | 11.0 ft-lbs/in             | 587 J/m     | D 4812 |
| Tensile Strength   | 13500 psi                  | 93 MPa      | D 638  |
| Tensile Elongation                                       | 2.5 - 3.5 %                | 2.5 - 3.5 % | D 638  |
| Tensile Modulus  | 0.78 x 10 <sup>6</sup> psi | 5378 MPa    | D 638  |
| Flexural Strength  | 21500 psi                  | 148 MPa     | D 790  |
| Flexural Modulus   | 0.82 x 10 <sup>6</sup> psi | 5654 MPa    | D 790  |

**THERMAL**

|  |              |             |       |
|--|--------------|-------------|-------|
| Deflection Temperature<br>@ 264 psi (1820 kPa) | 275 °F       | 135 °C      | D 648 |
| Ignition Resistance*<br>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**

|                    | <b>English</b>    | <b>SI Metric</b> |
|--------------------|-------------------|------------------|
| 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.