




**Product Data Sheet &  
General Processing Conditions**

**RTP 2500 TFE 15 FR  
Polycarbonate/ABS Alloy (PC/ABS)  
PTFE Lubricated  
Flame Retardant  
UL94 V-0**



**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	1.30	1.30	D 792
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0040 - 0.0070 in/in	0.40 - 0.70 %	D 955
Water Absorption, 24 hrs @ 23°C	0.100 %	0.100 %	D 570
<b>MECHANICAL</b>			
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	No Break	No Break	D 4812
Tensile Strength	7500 psi	52 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.40 x 10 <sup>6</sup> psi	2758 MPa	D 638
Flexural Strength	14000 psi	97 MPa	D 790
Flexural Modulus	0.38 x 10 <sup>6</sup> psi	2620 MPa	D 790
<b>ELECTRICAL</b>			
Volume Resistivity	> 1E16 ohm.cm	> 1E16 ohm.cm	D 257
<b>THERMAL</b>			
Deflection Temperature			
@ 264 psi (1820 kPa)	200 °F	93 °C	D 648
@ 66 psi (455 kPa)	220 °F	104 °C	D 648
Ignition Resistance*			
Flammability	V-0 @ 1/16 in	V-0 @ 1.5 mm	UL94

**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.

**GENERAL PROCESSING FOR INJECTION MOLDING**

	<b>English</b>	<b>SI Metric</b>
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	470 - 525 °F	243 - 274 °C
Mold Temperature	125 - 200 °F	52 - 93 °C
Drying	4 hrs @ 200 °F	4 hrs @ 93 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-20 °F	-29 °C

**PROCESSING NOTES**

Desiccant Type Dryer Required.