



**Product Data Sheet &
General Processing Conditions**

**RTP 1800 A TFE 15
Polycarbonate/Acrylic Alloy (PC/PMMA)
PTFE Lubricated**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	15 %	15 %	
Specific Gravity	1.21	1.21	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0070 in/in	0.70 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	7.0 ft-lbs/in	374 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	6500 psi	45 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.33 x 10 ⁶ psi	2275 MPa	D 638
Flexural Strength	12000 psi	83 MPa	D 790
Flexural Modulus	0.30 x 10 ⁶ psi	2068 MPa	D 790

THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	215 °F	102 °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	8000 - 12000 psi	55 - 83 MPa
Melt Temperature	460 - 510 °F	238 - 266 °C
Mold Temperature	90 - 150 °F	32 - 66 °C
Drying	3 - 6 hrs @ 180 °F	3 - 6 hrs @ 82 °C
Moisture Content	0.02 %	0.02 %
Dew Point	0 °F	-18 °C

PROCESSING NOTES

Desiccant Type Dryer Required.