



**Product Data Sheet &  
General Processing Conditions**

**RTP 2283 HF TFE 15  
Polyetheretherketone (PEEK)  
Carbon Fiber  
PTFE Lubricated**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Primary Additive	20 %	20 %	
Specific Gravity	1.45	1.45	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0005 - 0.0020 in/in	0.05 - 0.20 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.2 ft-lbs/in	64 J/m	D 256
unnotched 1/8 in (3.2 mm) section	11.0 ft-lbs/in	587 J/m	D 4812
Tensile Strength	30000 psi	207 MPa	D 638
Tensile Elongation	1.0 - 2.0 %	1.0 - 2.0 %	D 638
Tensile Modulus	2.80 x 10 <sup>6</sup> psi	19306 MPa	D 638
Flexural Strength	43000 psi	296 MPa	D 790
Flexural Modulus	2.55 x 10 <sup>6</sup> psi	17582 MPa	D 790

**ELECTRICAL**

Volume Resistivity	1E2 - 1E4 ohm.cm	1E2 - 1E4 ohm.cm	D 257
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**THERMAL**

Deflection Temperature @ 264 psi (1820 kPa)	> 572 °F	> 300 °C	D 648
VICAT Softening Temperature 120 Å°C/h, 50 N	> 572 °F	> 300 °C	D 1525
Ignition Resistance* Flammability**	V-0 @ 1/16 in	V-0 @ 1.5 mm	D 3801
Coefficient of Linear Thermal Expansion Flow Direction	0.4 x 10 <sup>-5</sup> /°F	0.8 x 10 <sup>-5</sup> /°C	E 831
Transverse Direction	2.5 x 10 <sup>-5</sup> /°F	4.5 x 10 <sup>-5</sup> /°C	E 831
Thermal Conductivity Through-plane	2.60 (BTU.in)/(hr.ft <sup>2</sup> .°F)	0.37 W/(m.K)	E 1530

**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	12000 - 18000 psi	83 - 124 MPa
Melt Temperature	660 - 750 °F	349 - 399 °C
Mold Temperature	325 - 425 °F	163 - 218 °C

Drying	3 hrs @ 300 °F	3 hrs @ 149 °C
Moisture Content	0.10 %	0.10 %
Dew Point	-20 °F	-29 °C

**PROCESSING NOTES**

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Desiccant Type Dryer Required.