



**Product Data Sheet &  
General Processing Conditions**

**RTP 800 TFE 15 SI 2 HB  
Acetal (POM)  
PTFE Lubricated  
Silicone Lubricated  
UL94 HB**



**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	1.47	1.47	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0180 - 0.0240 in/in	1.80 - 2.40 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.9 ft-lbs/in	48 J/m	D 256
unnotched 1/8 in (3.2 mm) section	10.0 ft-lbs/in	534 J/m	D 4812
Tensile Strength	5800 psi	40 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.32 x 10 <sup>6</sup> psi	2206 MPa	D 638
Flexural Strength	8500 psi	59 MPa	D 790
Flexural Modulus	0.28 x 10 <sup>6</sup> psi	1931 MPa	D 790

**THERMAL**

Deflection Temperature @ 264 psi (1820 kPa)	230 °F	110 °C	D 648
Ignition Resistance* Flammability	HB @ 1/16 in	HB @ 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	360 - 425 °F	182 - 218 °C
Mold Temperature	175 - 225 °F	79 - 107 °C
Drying	2 hrs @ 180 - 220 °F	2 hrs @ 82 - 104 °C
Moisture Content	0.15 %	0.15 %
Dew Point	-25 °F	-32 °C

**PROCESSING NOTES**

Desiccant Type Dryer Required.