




**Product Data Sheet &
General Processing Conditions**

**RTP 800 TFE 5 HB
Acetal (POM)
PTFE Lubricated
UL94 HB**



The RTP 800 TFE Series materials are acetals containing PTFE lubricant. These products offer moldability and wear resistance.

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	5 %	5 %	
Specific Gravity	1.43	1.43	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0150 - 0.0250 in/in	1.50 - 2.50 %	D 955
MECHANICAL			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.3 ft-lbs/in	69 J/m	D 256
unnotched 1/8 in (3.2 mm) section	14.0 ft-lbs/in	747 J/m	D 4812
Tensile Strength	7750 psi	53 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.36 x 10 ⁶ psi	2482 MPa	D 638
Flexural Strength	11000 psi	76 MPa	D 790
Flexural Modulus	0.34 x 10 ⁶ psi	2344 MPa	D 790
Hardness Rockwell, R	107	107	D 785
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

	English	SI Metric
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 @ 250 °F	2 hrs @ 121 °C
Moisture Content	0.15 %	0.15 %
Dew Point	-25 °F	-32 °C

PROCESSING NOTES

Desiccant Type Dryer Required.