




**Product Data Sheet &
General Processing Conditions**

**RTP 805 SI 2 HB
Acetal (POM)
Glass Fiber
Silicone Lubricated
UL94 HB**



PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	30 %	30 %	
Specific Gravity	1.61	1.61	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0040 - 0.0060 in/in	0.40 - 0.60 %	D 955
Water Absorption, 24 hrs @ 23°C	0.900 %	0.900 %	D 570
MECHANICAL			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.5 ft-lbs/in	80 J/m	D 256
unnotched 1/8 in (3.2 mm) section	12.0 ft-lbs/in	641 J/m	D 4812
Tensile Strength	17000 psi	117 MPa	D 638
Tensile Elongation	2.0 - 3.0 %	2.0 - 3.0 %	D 638
Tensile Modulus	1.30 x 10 ⁶ psi	8964 MPa	D 638
Flexural Strength	26000 psi	179 MPa	D 790
Flexural Modulus	1.15 x 10 ⁶ psi	7929 MPa	D 790
ELECTRICAL			
Volume Resistivity	> 1E15 ohm.cm	> 1E15 ohm.cm	D 257
THERMAL			
Deflection Temperature @ 264 psi (1820 kPa)	325 °F	163 °C	D 648
@ 66 psi (455 kPa)	330 °F	166 °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.