



**Product Data Sheet &
General Processing Conditions**

**RTP 4685 TFE 15 SI 2
Syndiotactic Polystyrene (SPS)
Carbon Fiber
PTFE Lubricated
Silicone Lubricated**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	30 %	30 %	
Specific Gravity	1.29	1.29	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0010 in/in	0.10 %	D 955
MECHANICAL			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.0 ft-lbs/in	53 J/m	D 256
unnotched 1/8 in (3.2 mm) section	3.3 ft-lbs/in	176 J/m	D 4812
Tensile Strength	16000 psi	110 MPa	D 638
Tensile Elongation	0.7 %	0.7 %	D 638
Tensile Modulus	2.80 x 10 ⁶ psi	19306 MPa	D 638
Flexural Strength	22000 psi	152 MPa	D 790
Flexural Modulus	2.50 x 10 ⁶ psi	17238 MPa	D 790

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.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	560 - 620 °F	293 - 327 °C
Mold Temperature	160 - 300 °F	71 - 149 °C
Drying	2 hrs @ 180 °F	2 hrs @ 82 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-20 °F	-29 °C