



**Product Data Sheet &  
General Processing Conditions**

**RTP 4203  
Thermoplastic Polyimide (TPI)  
Glass Fiber**

Properties are based on annealed specimens.

**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	0.0100 in/in	1.00 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.9 ft-lbs/in	101 J/m	D 256
unnotched 1/8 in (3.2 mm) section	16.5 ft-lbs/in	881 J/m	D 4812
Tensile Strength	20000 psi	138 MPa	D 638
Tensile Elongation	3.5 %	3.5 %	D 638
Tensile Modulus	1.10 x 10 <sup>6</sup> psi	7584 MPa	D 638
Flexural Strength	31000 psi	214 MPa	D 790
Flexural Modulus	1.00 x 10 <sup>6</sup> psi	6895 MPa	D 790

**THERMAL**

Deflection Temperature @ 264 psi (1820 kPa)	550 °F	288 °C	D 648
Ignition Resistance* Flammability**	V-0 @ 1/16 in	V-0 @ 1.5 mm	D 3801

**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	20000 - 28000 psi	138 - 193 MPa
Melt Temperature	750 - 780 °F	399 - 416 °C
Mold Temperature	350 - 450 °F	177 - 232 °C
Drying	6 hrs @ 400 °F	6 hrs @ 204 °C
Moisture Content	0.01 %	0.01 %
Dew Point	-40 °F	-40 °C

**PROCESSING NOTES**

Desiccant Type Dryer Required.