




**Product Data Sheet &  
General Processing Conditions**

**RTP 4207  
Thermoplastic Polyimide (TPI)  
Glass Fiber  
UL94 V-0**



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	40 %	40 %	
Specific Gravity	1.63	1.63	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0030 in/in	0.30 %	D 955
<b>MECHANICAL</b>			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	2.7 ft-lbs/in	144 J/m	D 256
unnotched 1/8 in (3.2 mm) section	20.0 ft-lbs/in	1068 J/m	D 4812
Tensile Strength	28000 psi	193 MPa	D 638
Tensile Elongation	2.0 %	2.0 %	D 638
Tensile Modulus	2.00 x 10 <sup>6</sup> psi	13790 MPa	D 638
Flexural Strength	43000 psi	296 MPa	D 790
Flexural Modulus	1.90 x 10 <sup>6</sup> psi	13100 MPa	D 790
Hardness Rockwell, R	124	124	D 785
<b>THERMAL</b>			
Deflection Temperature @ 264 psi (1820 kPa)	> 600 °F	> 316 °C	D 648
Ignition Resistance* Flammability	V-0 @ 1/16 in	V-0 @ 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	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.