




**Product Data Sheet &
General Processing Conditions**

**RTP 2000 HC FR A
Polyester Alloy
Flame Retardant
UV Stabilized
Medical Cleaner Resistant**



RTP 2000 HC series are polyester alloys designed to withstand the aggressive cleaners used to disinfect medical equipment

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.30	1.30	D 792
Melt Flow Rate @ 240 °C, / 5 kg	7.00 g/10 min	7.00 g/10 min	D 1238
Molding Shrinkage 1/8 in (3.2 mm) section	0.0050 - 0.0080 in/in	0.50 - 0.80 %	D 955
MECHANICAL			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	12.0 ft-lbs/in	641 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	5500 psi	38 MPa	D 638
Tensile Elongation	> 50.0 %	> 50.0 %	D 638
Tensile Modulus	0.19 x 10 ⁶ psi	1310 MPa	D 638
Flexural Strength	8500 psi	59 MPa	D 790
Flexural Modulus	0.21 x 10 ⁶ psi	1448 MPa	D 790
THERMAL			
Deflection Temperature @ 264 psi (1820 kPa)	180 °F	82 °C	D 648
@ 66 psi (455 kPa)	205 °F	96 °C	D 648
Ignition Resistance*			
Flammability	V-0 @ 1/16 in	V-0 @ 1.5 mm	UL94
Flammability	5VA @ 1/8 in	5VA @ 3.0 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	15000 - 20000 psi	103 - 138 MPa
Melt Temperature	480 - 520 °F	249 - 271 °C
Mold Temperature	150 - 180 °F	66 - 82 °C
Drying	4 - 6 hrs @ 190 °F	4 - 6 hrs @ 88 °C
Moisture Content	< 0.02 %	< 0.02 %
Dew Point	-40 °F	-40 °C

PROCESSING NOTES

This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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