



**Product Data Sheet &
General Processing Conditions**

**RTP 2204 HF
Polyetheretherketone (PEEK)
Glass Fiber**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
-------------------	----------------	------------------	------------------

Primary Additive	25 %	25 %	
Specific Gravity	1.48	1.48	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0035 in/in	0.35 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.4 ft-lbs/in	75 J/m	D 256
unnotched 1/8 in (3.2 mm) section	14.0 ft-lbs/in	747 J/m	D 4812
Tensile Strength	24000 psi	165 MPa	D 638
Tensile Elongation	2.6 %	2.6 %	D 638
Tensile Modulus	1.50 x 10 ⁶ psi	10342 MPa	D 638
Flexural Strength	38000 psi	262 MPa	D 790
Flexural Modulus	1.40 x 10 ⁶ psi	9653 MPa	D 790

THERMAL

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	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

	English	SI Metric
Injection Pressure	12000 - 18000 psi	83 - 124 MPa
Melt Temperature	660 - 750 °F	349 - 399 °C
Mold Temperature	325 - 425 °F	163 - 218 °C
Drying	3 hrs @ 300 °F	3 hrs @ 149 °C
Moisture Content	0.10 %	0.10 %
Dew Point	-20 °F	-29 °C

PROCESSING NOTES

Desiccant Type Dryer Required.

14 Apr 2005 CDH

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.

No information supplied by RTP Company constitutes a warranty regarding product performance or use. Any information regarding performance or use is only offered as suggestion for investigation for use, based upon RTP Company or other customer experience. RTP Company makes no warranties, expressed or implied, concerning the suitability or fitness of any of its products for any particular purpose. It is the responsibility of the customer to determine that the product is safe, lawful and technically suitable for the intended use. The disclosure of information herein is not a license to operate under, or a recommendation to infringe any patents.

RTP COMPANY • 580 EAST FRONT STREET • WINONA, MN 55987 • 507-454-6900