



**Product Data Sheet &
General Processing Conditions**

**RTP 4005 TFE 5
Polyphthalamide (PPA)
Glass Fiber Reinforced
PTFE Lubricated**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

| PERMANENCE | English | SI Metric | ASTM TEST |
|--|-----------------------|------------------|------------------|
| Primary Additive | 30 % | 30 % | |
| Specific Gravity | 1.49 | 1.49 | D 792 |
| Molding Shrinkage 1/8 in (3.2 mm) section | 0.0020 - 0.0030 in/in | 0.20 - 0.30 % | D 955 |

MECHANICAL

| | | | |
|--|----------------------------|-------------|--------|
| Impact Strength, Izod notched 1/8 in (3.2 mm) section | 1.6 ft-lbs/in | 85 J/m | D 256 |
| unnotched 1/8 in (3.2 mm) section | 15.0 ft-lbs/in | 801 J/m | D 4812 |
| Tensile Strength | 26000 psi | 179 MPa | D 638 |
| Tensile Elongation | 2.0 - 3.0 % | 2.0 - 3.0 % | D 638 |
| Tensile Modulus | 1.60 x 10 ⁶ psi | 11032 MPa | D 638 |
| Flexural Strength | 38000 psi | 262 MPa | D 790 |
| Flexural Modulus | 1.50 x 10 ⁶ psi | 10342 MPa | D 790 |

THERMAL

| | | | |
|--|--------------|-------------|-------|
| Deflection Temperature @ 264 psi (1820 kPa) | 550 °F | 288 °C | D 648 |
| Ignition Resistance* Flammability** | HB @ 1/16 in | HB @ 1.5 mm | D 635 |

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 | 10000 - 18000 psi | 69 - 124 MPa |
| Melt Temperature | 575 - 625 °F | 302 - 329 °C |
| Mold Temperature | 275 - 325 °F | 135 - 163 °C |
| Drying | 4 - 6 hrs @ 225 °F | 4 - 6 hrs @ 107 °C |
| Moisture Content | 0.05 % | 0.05 % |
| Dew Point | -25 °F | -32 °C |

PROCESSING NOTES

Desiccant Type Dryer Required.

21 Mar 2005 MAB

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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