

# RTP 4005 TFE 13 SI 2

Polyphthalamide

RTP Company

Message:

Glass Fiber - PTFE Lubricated - Silicone Lubricated

| General Information                                        |                                                       |                   |             |
|------------------------------------------------------------|-------------------------------------------------------|-------------------|-------------|
| Filler / Reinforcement                                     | Glass fiber reinforced material, 30% filler by weight |                   |             |
| Additive                                                   | PTFE lubricant (13%)                                  |                   |             |
|                                                            | Silicone lubricant (2%)                               |                   |             |
| Features                                                   | Lubrication                                           |                   |             |
| RoHS Compliance                                            | Contact manufacturer                                  |                   |             |
| Processing Method                                          | Injection molding                                     |                   |             |
| Physical                                                   | Nominal Value                                         | Unit              | Test Method |
| Specific Gravity                                           | 1.54                                                  | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow (3.20 mm)                         | 0.10 - 0.40                                           | %                 | ASTM D955   |
| Moisture Content                                           | 0.050                                                 | %                 |             |
| Primary Additive                                           | 30                                                    | %                 |             |
| Mechanical                                                 | Nominal Value                                         | Unit              | Test Method |
| Tensile Modulus                                            | 10700                                                 | MPa               | ASTM D638   |
| Tensile Strength                                           | 179                                                   | MPa               | ASTM D638   |
| Tensile Elongation (Yield)                                 | 2.0 - 3.0                                             | %                 | ASTM D638   |
| Flexural Modulus                                           | 10300                                                 | MPa               | ASTM D790   |
| Flexural Strength                                          | 265                                                   | MPa               | ASTM D790   |
| Impact                                                     | Nominal Value                                         | Unit              | Test Method |
| Notched Izod Impact (3.20 mm)                              | 85                                                    | J/m               | ASTM D256   |
| Unnotched Izod Impact (3.20 mm)                            | 800                                                   | J/m               | ASTM D4812  |
| Thermal                                                    | Nominal Value                                         | Unit              | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed)    | 274                                                   | °C                | ASTM D648   |
| Flammability                                               | Nominal Value                                         |                   | Test Method |
| Flame Rating (1.50 mm, ** Values per RTP Company testing.) | HB                                                    |                   | UL 94       |
| Injection                                                  | Nominal Value                                         | Unit              |             |
| Drying Temperature                                         | 107                                                   | °C                |             |
| Drying Time                                                | 4.0 - 6.0                                             | hr                |             |
| Dew Point                                                  | -31.7                                                 | °C                |             |
| Processing (Melt) Temp                                     | 302 - 329                                             | °C                |             |
| Mold Temperature                                           | 135 - 163                                             | °C                |             |
| Injection Pressure                                         | 68.9 - 124                                            | MPa               |             |

## Injection instructions

Desiccant Type Dryer Required.

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### Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

