

RTP 204 D TFE 15 FR

Polyamide 612

RTP Company

Message:

Glass Fiber - PTFE Lubricated - Flame Retardant - UL94 V-1

General Information			
UL YellowCard	E84658-251375		
Filler / Reinforcement	Glass fiber reinforced material, 25% filler by weight		
Additive	PTFE lubricant (15%)		
Features	Lubrication		
	Flame retardancy		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.64	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.15 - 0.40	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.20	%	ASTM D570
Moisture Content	0.20	%	
Primary Additive	25	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8960	MPa	ASTM D638
Tensile Strength	117	MPa	ASTM D638
Tensile Elongation (Yield)	2.0 - 3.5	%	ASTM D638
Flexural Modulus	8620	MPa	ASTM D790
Flexural Strength	179	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	91	J/m	ASTM D256
Unnotched Izod Impact (3.20 mm)	640	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	221	°C	ASTM D648
1.8 MPa, not annealed	216	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength ¹ (in Oil)	20	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.800 mm)	V-1		UL 94

Injection	Nominal Value	Unit
Drying Temperature	79.4	°C
Drying Time	4.0	hr
Dew Point	-17.8	°C
Processing (Melt) Temp	249 - 285	°C
Mold Temperature	60.0 - 93.3	°C
Injection Pressure	68.9 - 124	MPa

Injection instructions

Desiccant Type Dryer Required.

NOTE

1. Method A (short time)

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Recommended distributors for this material

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

