



**Product Data Sheet &  
General Processing Conditions**

**RTP 205.3 TFE 15  
Nylon 6/6 (PA)  
Glass Fiber  
PTFE Lubricated**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

| PERMANENCE                                   | English               | SI Metric     | ASTM TEST |
|----------------------------------------------|-----------------------|---------------|-----------|
| Primary Additive                             | 33 %                  | 33 %          |           |
| Specific Gravity                             | 1.53                  | 1.53          | D 792     |
| Molding Shrinkage<br>1/8 in (3.2 mm) section | 0.0020 - 0.0040 in/in | 0.20 - 0.40 % | D 955     |

**MECHANICAL**

|                                                          |                            |             |        |
|----------------------------------------------------------|----------------------------|-------------|--------|
| Impact Strength, Izod<br>notched 1/8 in (3.2 mm) section | 1.8 ft-lbs/in              | 96 J/m      | D 256  |
| unnotched 1/8 in (3.2 mm) section                        | 16.5 ft-lbs/in             | 881 J/m     | D 4812 |
| Tensile Strength                                         | 22500 psi                  | 155 MPa     | D 638  |
| Tensile Elongation                                       | 2.5 - 3.5 %                | 2.5 - 3.5 % | D 638  |
| Tensile Modulus                                          | 1.40 x 10 <sup>6</sup> psi | 9653 MPa    | D 638  |
| Flexural Strength                                        | 35000 psi                  | 241 MPa     | D 790  |
| Flexural Modulus                                         | 1.45 x 10 <sup>6</sup> psi | 9998 MPa    | D 790  |

**ELECTRICAL**

|                    |                    |                    |       |
|--------------------|--------------------|--------------------|-------|
| Volume Resistivity | 1E14 - 1E16 ohm.cm | 1E14 - 1E16 ohm.cm | D 257 |
|--------------------|--------------------|--------------------|-------|

**THERMAL**

|                                                |              |             |       |
|------------------------------------------------|--------------|-------------|-------|
| Deflection Temperature<br>@ 264 psi (1820 kPa) | 480 °F       | 249 °C      | D 648 |
| Ignition Resistance*<br>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   | 530 - 570 °F      | 277 - 299 °C  |
| Mold Temperature   | 150 - 225 °F      | 66 - 107 °C   |
| Drying             | 4 hrs @ 175 °F    | 4 hrs @ 79 °C |
| Moisture Content   | 0.20 %            | 0.20 %        |
| Dew Point          | 0 °F              | -18 °C        |

**PROCESSING NOTES**

Desiccant Type Dryer Required.