



Product Data Sheet & General Processing Conditions

RTP 4207
Thermoplastic Polyimide (TPI)
Glass Fiber
UL94 V-0



Properties are based on annealed specimens.

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	40 %	40 %	
Specific Gravity	1.63	1.63	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0030 in/in	0.30 %	D 955
MECHANICAL			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	2.7 ft-lbs/in	144 J/m	D 256
unnotched 1/8 in (3.2 mm) section	20.0 ft-lbs/in	1068 J/m	D 4812
Tensile Strength	28000 psi	193 MPa	D 638
Tensile Elongation	2.0 %	2.0 %	D 638
Tensile Modulus	2.00 x 10 ⁶ psi	13790 MPa	D 638
Flexural Strength	43000 psi	296 MPa	D 790
Flexural Modulus	1.90 x 10 ⁶ psi	13100 MPa	D 790
Hardness Rockwell, R	124	124	D 785
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	UL94

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.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	20000 - 28000 psi	138 - 193 MPa
Melt Temperature	750 - 780 °F	399 - 416 °C
Mold Temperature	350 - 450 °F	177 - 232 °C
Drying	6 hrs @ 400 °F	6 hrs @ 204 °C
Moisture Content	0.01 %	0.01 %
Dew Point	-40 °F	-40 °C

PROCESSING NOTES

Desiccant Type Dryer Required.

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