



**Product Data Sheet &  
General Processing Conditions**

**RTP 4405.3 HS L  
High Temperature Nylon (HTN)  
Glass Fiber  
Heat Stabilized  
Lubricated**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Primary Additive	33 %	33 %	
Specific Gravity	1.45	1.45	D 792
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0020 - 0.0030 in/in	0.20 - 0.30 %	D 955
Water Absorption, 24 hrs @ 23°C	0.410 %	0.410 %	D 570

**MECHANICAL**

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	1.4 ft-lbs/in	75 J/m	D 256
unnotched 1/8 in (3.2 mm) section	11.0 ft-lbs/in	587 J/m	D 4812
Tensile Strength	26000 psi	179 MPa	D 638
Tensile Elongation	2.3 %	2.3 %	D 638
Tensile Modulus	1.60 x 10 <sup>6</sup> psi	11032 MPa	D 638
Flexural Strength	37000 psi	255 MPa	D 790
Flexural Modulus	1.50 x 10 <sup>6</sup> psi	10342 MPa	D 790
Hardness			
Rockwell, R	125	125	D 785

**THERMAL**

Deflection Temperature			
@ 264 psi (1820 kPa)	500 °F	260 °C	D 648

**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.

**GENERAL PROCESSING FOR INJECTION MOLDING**

	<b>English</b>	<b>SI Metric</b>
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	590 - 650 °F	310 - 343 °C
Mold Temperature	275 - 325 °F	135 - 163 °C
Drying	4 hrs @ 175 °F	4 hrs @ 79 °C
Moisture Content	0.10 %	0.10 %
Dew Point	-40 °F	-40 °C

**PROCESSING NOTES**

Desiccant Type Dryer Required.

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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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