



Product Data Sheet & General Processing Conditions

RTP 4005 UP Polyphthalamide (PPA) Glass Fiber Ultra Performance

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE		STANDARD
Primary Additive	30 %	
Density	1.44 g/cm ³	ISO 1183

MECHANICAL		
Impact Strength, Izod		
Unnotched, 4 mm thickness	75 kJ/m ²	ISO 180/1U
Tensile Strength	210 MPa	ISO 527
Tensile Elongation	2.5 %	ISO 527
Tensile Modulus	12500 MPa	ISO 527
Flexural Strength	310 MPa	ISO 178
Flexural Modulus	11000 MPa	ISO 178

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

Injection Pressure	70 - 125 MPa
Injection Pressure	680 - 1240 bar
Melt Temperature	300 - 330 °C
Mold Temperature	135 - 160 °C
Drying	4 - 6 hrs @ 105 °C
Moisture Content	0.05 %
Dew Point	-30 °C

PROCESSING NOTES

Desiccant Type Dryer Required.

30 Oct 2013 BLM

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.

No information supplied by RTP Company constitutes a warranty regarding product performance or use. Any information regarding performance or use is only offered as suggestion for investigation for use, based upon RTP Company or other customer experience. RTP Company makes no warranties, expressed or implied, concerning the suitability or fitness of any of its products for any particular purpose. It is the responsibility of the customer to determine that the product is safe, lawful and technically suitable for the intended use. The disclosure of information herein is not a license to operate under, or a recommendation to infringe any patents.

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