



**Product Data Sheet &  
General Processing Conditions**

**RTP 4085 A TFE 15  
(Hot Water Moldable) Polyphthalamide  
(PPA)  
Carbon Fiber  
PTFE Lubricated**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Primary Additive	30 %	30 %	
Specific Gravity	1.42	1.42	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0005 - 0.0030 in/in	0.05 - 0.30 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.3 ft-lbs/in	69 J/m	D 256
unnotched 1/8 in (3.2 mm) section	12.0 ft-lbs/in	641 J/m	D 4812
Tensile Strength	34000 psi	234 MPa	D 638
Tensile Elongation	1.0 - 2.0 %	1.0 - 2.0 %	D 638
Tensile Modulus	3.50 x 10 <sup>6</sup> psi	24132 MPa	D 638
Flexural Strength	48000 psi	331 MPa	D 790
Flexural Modulus	3.00 x 10 <sup>6</sup> psi	20685 MPa	D 790

**THERMAL**

Deflection Temperature @ 264 psi (1820 kPa)	> 530 °F	> 277 °C	D 648
Ignition Resistance* 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**

	<b>English</b>	<b>SI Metric</b>
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	625 - 650 °F	329 - 343 °C
Mold Temperature	150 - 325 °F	66 - 163 °C
Drying	4 - 6 hrs @ 225 °F	4 - 6 hrs @ 107 °C
Moisture Content	0.10 %	0.10 %
Dew Point	-20 °F	-29 °C

**PROCESSING NOTES**

Desiccant Type Dryer Required.

16 Mar 2005 CDH

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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