



**Product Data Sheet &
General Processing Conditions**

**RTP 4099 X 94115
Polyphthalamide (PPA)
Impact Modified
Glass Fiber
Heat Stabilized**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

| PERMANENCE | English | SI Metric | ASTM TEST |
|--|-----------------------|------------------|------------------|
| Primary Additive | 15 % | 15 % | |
| Specific Gravity | 1.20 | 1.20 | D 792 |
| Molding Shrinkage 1/8 in (3.2 mm) section | 0.0040 - 0.0070 in/in | 0.40 - 0.70 % | D 955 |

MECHANICAL

| | | | |
|--|----------------------------|-------------|--------|
| Impact Strength, Izod notched 1/8 in (3.2 mm) section | 3.5 ft-lbs/in | 187 J/m | D 256 |
| unnotched 1/8 in (3.2 mm) section | 14.0 ft-lbs/in | 747 J/m | D 4812 |
| Tensile Strength | 11000 psi | 76 MPa | D 638 |
| Tensile Elongation | 4.0 - 6.0 % | 4.0 - 6.0 % | D 638 |
| Tensile Modulus | 0.60 x 10 ⁶ psi | 4137 MPa | D 638 |
| Flexural Strength | 17000 psi | 117 MPa | D 790 |
| Flexural Modulus | 0.60 x 10 ⁶ psi | 4137 MPa | D 790 |

THERMAL

| | | | |
|--|--------|--------|-------|
| Deflection Temperature @ 264 psi (1820 kPa) | 322 °F | 161 °C | D 648 |
| @ 66 psi (455 kPa) | 519 °F | 271 °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

| | English | SI Metric |
|--------------------|--------------------|--------------------|
| Injection Pressure | 10000 - 18000 psi | 69 - 124 MPa |
| Melt Temperature | 550 - 575 °F | 288 - 302 °C |
| Mold Temperature | 250 - 300 °F | 121 - 149 °C |
| Drying | 4 - 6 hrs @ 225 °F | 4 - 6 hrs @ 107 °C |
| Moisture Content | 0.05 % | 0.05 % |
| Dew Point | -25 °F | -32 °C |

PROCESSING NOTES

Desiccant Type Dryer Required.

26 Jun 2019 MAB

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