



**Product Data Sheet &  
General Processing Conditions**

**RTP 4000 ET-1001 L  
Polyphthalamide (PPA)  
Impact Modified  
Lubricated**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.13	1.13	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0150 - 0.0250 in/in	1.50 - 2.50 %	D 955
<b>MECHANICAL</b>			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	14.0 ft-lbs/in	747 J/m	D 256
unnotched 1/8 in (3.2 mm) section	40.0 ft-lbs/in	2136 J/m	D 4812
Tensile Strength	10000 psi	69 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.35 x 10 <sup>6</sup> psi	2413 MPa	D 638
Flexural Strength	15000 psi	103 MPa	D 790
Flexural Modulus	0.38 x 10 <sup>6</sup> psi	2620 MPa	D 790

**THERMAL**

Deflection Temperature @ 264 psi (1820 kPa)	240 °F	116 °C	D 648
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**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 - 18000 psi	69 - 124 MPa
Melt Temperature	540 - 600 °F	282 - 316 °C
Mold Temperature	150 - 280 °F	66 - 138 °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.

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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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