



**Product Data Sheet &
General Processing Conditions**

**RTP 4085 UP
Polyphthalamide (PPA)
Carbon Fiber
Ultra Performance**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.33	1.33	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0005 - 0.0010 in/in	0.05 - 0.10 %	D 955
MECHANICAL			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.5 ft-lbs/in	80 J/m	D 256
unnotched 1/8 in (3.2 mm) section	13.0 ft-lbs/in	694 J/m	D 4812
Tensile Strength	46000 psi	317 MPa	D 638
Tensile Elongation	1.0 - 2.0 %	1.0 - 2.0 %	D 638
Tensile Modulus	4.30 x 10 ⁶ psi	29648 MPa	D 638
Flexural Strength	65000 psi	448 MPa	D 790
Flexural Modulus	3.50 x 10 ⁶ psi	24132 MPa	D 790

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	575 - 625 °F	302 - 329 °C
Mold Temperature	275 - 325 °F	135 - 163 °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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RTP COMPANY • 580 EAST FRONT STREET • WINONA, MN 55987 • 507-454-6900