



## Product Data Sheet & General Processing Conditions

### RTP 299 H X 114712 SP Impact-Modified Nylon 6/6 (PA) Unfilled Heat Stabilized Preliminary Datasheet

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

PERMANENCE		STANDARD
Density	1.07 g/cm <sup>3</sup>	ISO 1183
Shrinkage, 4 mm Thickness		
Flow direction	1.60 - 2.40 %	ASTM D 955

#### MECHANICAL

Impact Strength, Charpy		
Notched, 4 mm thickness	85 kJ/m <sup>2</sup>	ISO 179/1eA
Unnotched, 4 mm thickness	No Break	ISO 179/1eU
Tensile Strength	42 MPa	ISO 527
Tensile Elongation	50.0 %	ISO 527
Tensile Modulus	1600 MPa	ISO 527
Flexural Strength	55 MPa	ISO 178
Flexural Modulus	1600 MPa	ISO 178
Hardness		
Shore D, instantaneous	78	ISO 868

#### THERMAL

Heat Deflection Temperature		
@ 1.80 MPa	44 °C	ISO 75
Ignition Resistance*		
Flammability**	HB @ 1.5 mm	ISO 1210

#### 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

Injection Pressure	70 - 125 MPa
Injection Pressure	680 - 1240 bar
Melt Temperature	275 - 300 °C
Mold Temperature	65 - 105 °C
Drying	4 hrs @ 80 °C
Moisture Content	0.20 %
Dew Point	-25 °C

#### PROCESSING NOTES

Desiccant Type Dryer Required.

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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