



Product Data Sheet & General Processing Conditions

RTP 199 X 138109 A Polypropylene (PP) Glass Fiber Mineral

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

| PERMANENCE | STANDARD |
|------------|----------|
|------------|----------|

| | | |
|---------|------------------------|----------|
| Density | 1.23 g/cm ³ | ISO 1183 |
|---------|------------------------|----------|

MECHANICAL

| | | |
|---------------------------|----------------------|-------------|
| Impact Strength, Charpy | | |
| Notched, 4 mm thickness | 8 kJ/m ² | ISO 179/1eA |
| Unnotched, 4 mm thickness | 34 kJ/m ² | ISO 179/1eU |
| Tensile Strength | 70 MPa | ISO 527 |
| Tensile Elongation | 2.0 - 4.0 % | ISO 527 |
| Tensile Modulus | 7200 MPa | ISO 527 |
| Flexural Strength | 125 MPa | ISO 178 |
| Flexural Modulus | 7500 MPa | ISO 178 |

THERMAL

| | | |
|-----------------------------|-------------|----------|
| Heat Deflection Temperature | | |
| @ 1.80 MPa | > 142 °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 - 105 MPa |
| Injection Pressure | 680 - 1030 bar |
| Melt Temperature | 190 - 230 °C |
| Mold Temperature | 30 - 65 °C |
| Drying | 2 hrs @ 80 °C |

PROCESSING NOTES

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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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