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Product Data Sheet & General Processing Conditions

RTP 299 A X 143325 A
Nylon 6 (PA)
Glass Fiber
Heat Stabilized

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE		STANDARD
Primary Additive	30 %	
Density	1.35 g/cm ³	ISO 1183
Shrinkage, 4 mm Thickness		
Flow direction	0.10 - 0.40 %	ASTM D 955
MECHANICAL		
Impact Strength, Charpy		
Notched, 4 mm thickness	13 kJ/m ²	ISO 179/1eA
Tensile Strength	180 MPa	ISO 527
Tensile Elongation	3.0 - 5.0 %	ISO 527
Tensile Modulus	9800 MPa	ISO 527
Flexural Strength	275 MPa	ISO 178
Flexural Modulus	9500 MPa	ISO 178
THERMAL		
Heat Deflection Temperature		
@ 1.80 MPa	> 198 °C	ISO 75

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

Injection Pressure	70 - 105 MPa
Injection Pressure	680 - 1030 bar
Melt Temperature	245 - 280 °C
Mold Temperature	55 - 95 °C
Drying	2 hrs @ 80 °C
Moisture Content	0.20 %
Dew Point	-25 °C

PROCESSING NOTES

Desiccant Type Dryer Required.