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Product Data Sheet &
General Processing Conditions

RTP 299 A X 117575 A
Nylon 6 (PA)
Glass Fiber
Flame Retardant
Halogen Free

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.38	1.38	D 792
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0010 - 0.0030 in/in	0.10 - 0.30 %	D 955
MECHANICAL			
Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	1.8 ft-lbs/in	96 J/m	D 256
unnotched 1/8 in (3.2 mm) section	18.0 ft-lbs/in	961 J/m	D 4812
Tensile Strength	17500 psi	121 MPa	D 638
Tensile Elongation	3.0 - 5.0 %	3.0 - 5.0 %	D 638
Tensile Modulus	1.32 x 10^6 psi	9101 MPa	D 638
Flexural Strength	27500 psi	190 MPa	D 790
Flexural Modulus	1.30 x 10^6 psi	8964 MPa	D 790
THERMAL			
Ignition Resistance*			
Flammability**	V-0 @ 1/32 in	V-0 @ 0.8 mm	D 3801
Flammability**	5VA @ 0.08 in	5VA @ 2.0 mm	D 5048

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

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	470 - 535 °F	243 - 279 °C
Mold Temperature	130 - 200 °F	54 - 93 °C
Drying	2 hrs @ 180 °F	2 hrs @ 82 °C
Moisture Content	0.20 %	0.20 %
Dew Point	0 °F	-18 °C

PROCESSING NOTES

Desiccant Type Dryer Required.