



**Product Data Sheet &
General Processing Conditions**

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

This product has been tested to have a Flame Spread Index of less than 25 per ASTM E-162 and a Smoke Developed Index of less than 200 at 4 mins in the flaming mode per ASTM E-662.

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	30 %	30 %	
Specific Gravity	1.43	1.43	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	2.3 ft-lbs/in	123 J/m	D 256
unnotched 1/8 in (3.2 mm) section	20.0 ft-lbs/in	1068 J/m	D 4812
Tensile Strength	19000 psi	131 MPa	D 638
Tensile Elongation	4.0 %	4.0 %	D 638
Tensile Modulus	1.30 x 10 ⁶ psi	8964 MPa	D 638
Flexural Strength	33000 psi	228 MPa	D 790
Flexural Modulus	1.50 x 10 ⁶ psi	10342 MPa	D 790

THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	415 °F	213 °C	D 648
@ 66 psi (455 kPa)	390 °F	199 °C	D 648
Ignition Resistance*			
Flammability**	V-0 @ 1/16 in	V-0 @ 1.5 mm	D 3801
Aerospace**	F2 @ 0.060 in.	F2 @ 1.5 mm	FAR 25.853

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.