



**Product Data Sheet &
General Processing Conditions**

**RTP PA6 33 GF BLK
Nylon 6 (PA)
Value Product
Glass Fiber
Heat Stabilized**



PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	33 %	33 %	
Specific Gravity	1.38	1.38	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0020 - 0.0040 in/in	0.20 - 0.40 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	2.0 ft-lbs/in	107 J/m	D 256
unnotched 1/8 in (3.2 mm) section	18.0 ft-lbs/in	961 J/m	D 4812
Tensile Strength	21000 psi	145 MPa	D 638
Tensile Elongation	3.0 - 4.0 %	3.0 - 4.0 %	D 638
Tensile Modulus	1.40 x 10 ⁶ psi	9653 MPa	D 638
Flexural Strength	32000 psi	221 MPa	D 790
Flexural Modulus	1.20 x 10 ⁶ psi	8274 MPa	D 790

THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	> 392 °F	> 200 °C	D 648
Ignition Resistance* Flammability	HB @ 1/16 in	HB @ 1.5 mm	UL94

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.

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.