



**Product Data Sheet &
General Processing Conditions**

**RTP 204 RC HS Black
Nylon 6/6 (PA)
Glass Fiber
Heat Stabilized**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE		STANDARD
Primary Additive	25 %	
Density	1.33 g/cm ³	ISO 1183
Shrinkage, 4 mm Thickness		
Flow direction	0.10 - 0.40 %	ASTM D 955
MECHANICAL		
Impact Strength, Izod		
Notched, 4 mm thickness	10 kJ/m ²	ISO 180/1A
Unnotched, 4 mm thickness	60 kJ/m ²	ISO 180/1U
Tensile Strength	175 MPa	ISO 527
Tensile Elongation	3.0 - 4.0 %	ISO 527
Tensile Modulus	9000 MPa	ISO 527
Flexural Strength	250 MPa	ISO 178
Flexural Modulus	8250 MPa	ISO 178

THERMAL		
Heat Deflection Temperature @ 1.80 MPa	245 °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 - 125 MPa	
Injection Pressure	680 - 1240 bar	
Melt Temperature	275 - 300 °C	
Mold Temperature	65 - 105 °C	
Drying	4 hrs @ 80 °C	
Moisture Content	0.20 %	
Dew Point	-25 °C	

PROCESSING NOTES

Desiccant Type Dryer Required.