



**Product Data Sheet &
General Processing Conditions**

**RTP 299 H X 114712 SP
Impact-Modified Nylon 6/6 (PA)
Unfilled
Heat Stabilized
Preliminary Datasheet**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE		STANDARD
Density	1.07 g/cm ³	ISO 1183
Shrinkage, 4 mm Thickness		
Flow direction	1.60 - 2.40 %	ASTM D 955

MECHANICAL		
Impact Strength, Charpy		
Notched, 4 mm thickness	85 kJ/m ²	ISO 179/1eA
Unnotched, 4 mm thickness	No Break	ISO 179/1eU
Tensile Strength	42 MPa	ISO 527
Tensile Elongation	50.0 %	ISO 527
Tensile Modulus	1600 MPa	ISO 527
Flexural Strength	55 MPa	ISO 178
Flexural Modulus	1600 MPa	ISO 178
Hardness		
Shore D, instantaneous	78	ISO 868

THERMAL		
Heat Deflection Temperature		
@ 1.80 MPa	44 °C	ISO 75
Ignition Resistance*		
Flammability**	HB @ 1.5 mm	ISO 1210

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

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.