



**Product Data Sheet &  
General Processing Conditions**

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

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.07	1.07	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0160 - 0.0240 in/in	1.60 - 2.40 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	17.7 ft-lbs/in	945 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	6500 psi	45 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.26 x 10 <sup>6</sup> psi	1793 MPa	D 638
Flexural Strength	9600 psi	66 MPa	D 790
Flexural Modulus	0.26 x 10 <sup>6</sup> psi	1793 MPa	D 790

**THERMAL**

Deflection Temperature @ 264 psi (1820 kPa)	112 °F	44 °C	D 648
Ignition Resistance* Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635

**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**

	<b>English</b>	<b>SI Metric</b>
Injection Pressure	10000 - 18000 psi	69 - 124 MPa
Melt Temperature	530 - 570 °F	277 - 299 °C
Mold Temperature	150 - 225 °F	66 - 107 °C
Drying	4 hrs @ 175 °F	4 hrs @ 79 °C
Moisture Content	0.20 %	0.20 %
Dew Point	0 °F	-18 °C

**PROCESSING NOTES**

Desiccant Type Dryer Required.