



**Product Data Sheet &  
General Processing Conditions**

**RTP 4799 X 121826 C  
Biobased Polyester  
Permanently Anti-static  
ESD Protection  
29% Bio-Content**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.27	1.27	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0200 in/in	2.00 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.2 ft-lbs/in	64 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	6000 psi	41 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.30 x 10 <sup>6</sup> psi	2068 MPa	D 638
Flexural Strength	10000 psi	69 MPa	D 790
Flexural Modulus	0.30 x 10 <sup>6</sup> psi	2068 MPa	D 790

**ELECTRICAL**

Volume Resistivity	1E9 - 1E10 ohm.cm	1E9 - 1E10 ohm.cm	D 257
Surface Resistivity	1E10 - 1E11 ohm/sq	1E10 - 1E11 ohm/sq	D 257
Static Decay	< 2.00 s	< 2.00 s	FTMS101C 4046.1

**THERMAL**

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 - 15000 psi	69 - 103 MPa
Melt Temperature	400 - 460 °F	204 - 238 °C
Mold Temperature	100 - 250 °F	38 - 121 °C
Drying	4 hrs @ 250 °F	4 hrs @ 121 °C
Moisture Content	0.03 %	0.03 %
Dew Point	-20 °F	-29 °C

**PROCESSING NOTES**

Do not exceed 520 °F (270 °C) melt temperature.

Desiccant Type Dryer Required.