



**Product Data Sheet &  
General Processing Conditions**

**RTP 199 X 123127 A  
Polypropylene (PP)  
Long Glass Fiber  
Chemically Coupled  
UV Stabilized**

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

<b>PERMANENCE</b>		<b>STANDARD</b>
Primary Additive	30 %	
Density	1.12 g/cm <sup>3</sup>	ISO 1183
Shrinkage, 4 mm Thickness		
Flow direction	0.10 - 0.40 %	ASTM D 955

<b>MECHANICAL</b>		
Impact Strength, Izod		
Notched, 4 mm thickness	18 kJ/m <sup>2</sup>	ISO 180/1A
Tensile Strength	100 MPa	ISO 527
Tensile Elongation	3.0 %	ISO 527
Tensile Modulus	7500 MPa	ISO 527
Flexural Strength	150 MPa	ISO 178
Flexural Modulus	8000 MPa	ISO 178

<b>THERMAL</b>		
Heat Deflection Temperature		
@ 1.80 MPa	155 °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 - 105 MPa
Injection Pressure	680 - 1030 bar
Melt Temperature	190 - 230 °C
Mold Temperature	30 - 65 °C
Drying	2 hrs @ 80 °C

**PROCESSING NOTES**

Use a reverse barrel profile. To maximize fiber length, the following injection barrel, screw, and tip designs should be followed. L/D ratio 16/1 - 22/1, Compression ratio 2:1, Flight depth 5 mm minimum, in feed section, Screw diameter 16.5 - 20 mm minimum, Compression section length 12 - 13 diameters, Check ring valve assembly - free flow type no restrictions, Nozzle orifice 6 mm diameter. Feed throat from hopper to machine must have sufficient opening to prevent bridging of long pellet composition.