



**Product Data Sheet &
General Processing Conditions**

**RTP 4000 ET-1001 L
Polyphthalamide (PPA)
Impact Modified
Lubricated**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.13	1.13	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0150 - 0.0250 in/in	1.50 - 2.50 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	14.0 ft-lbs/in	747 J/m	D 256
unnotched 1/8 in (3.2 mm) section	40.0 ft-lbs/in	2136 J/m	D 4812
Tensile Strength	10000 psi	69 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.35 x 10 ⁶ psi	2413 MPa	D 638
Flexural Strength	15000 psi	103 MPa	D 790
Flexural Modulus	0.38 x 10 ⁶ psi	2620 MPa	D 790

THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	240 °F	116 °C	D 648
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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

	English	SI Metric
Injection Pressure	10000 - 18000 psi	69 - 124 MPa
Melt Temperature	540 - 600 °F	282 - 316 °C
Mold Temperature	150 - 280 °F	66 - 138 °C
Drying	4 - 6 hrs @ 225 °F	4 - 6 hrs @ 107 °C
Moisture Content	0.05 %	0.05 %
Dew Point	-25 °F	-32 °C

PROCESSING NOTES

Desiccant Type Dryer Required.