



**Product Data Sheet &  
General Processing Conditions**

**RTP 4000 MG 50  
Polyphthalamide (PPA)  
Milled Glass**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Primary Additive	50 %	50 %	
Specific Gravity	1.63	1.63	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0020 in/in	0.20 %	D 955
Water Absorption, 24 hrs @ 23°C	0.200 %	0.200 %	D 570

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.5 ft-lbs/in	27 J/m	D 256
unnotched 1/8 in (3.2 mm) section	6.0 ft-lbs/in	320 J/m	D 4812
Tensile Strength	13500 psi	93 MPa	D 638
Tensile Elongation	1.0 - 2.0 %	1.0 - 2.0 %	D 638
Tensile Modulus	1.50 x 10 <sup>6</sup> psi	10342 MPa	D 638
Flexural Strength	21500 psi	148 MPa	D 790
Flexural Modulus	1.40 x 10 <sup>6</sup> psi	9653 MPa	D 790
Hardness Rockwell, R	125	125	D 785

**ELECTRICAL**

Volume Resistivity	> 1E15 ohm.cm	> 1E15 ohm.cm	D 257
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**THERMAL**

Deflection Temperature @ 264 psi (1820 kPa)	500 °F	260 °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	575 - 625 °F	302 - 329 °C
Mold Temperature	275 - 325 °F	135 - 163 °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.