



**Product Data Sheet &  
General Processing Conditions**

**RTP 4005 UP  
Polyphthalamide (PPA)  
Glass Fiber  
Ultra Performance**

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

<b>PERMANENCE</b>		<b>STANDARD</b>
Primary Additive	30 %	
Density	1.44 g/cm <sup>3</sup>	ISO 1183
<b>MECHANICAL</b>		
Impact Strength, Izod Unnotched, 4 mm thickness	75 kJ/m <sup>2</sup>	ISO 180/1U
Tensile Strength	210 MPa	ISO 527
Tensile Elongation	2.5 %	ISO 527
Tensile Modulus	12500 MPa	ISO 527
Flexural Strength	310 MPa	ISO 178
Flexural Modulus	11000 MPa	ISO 178

**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**

Injection Pressure	70 - 125 MPa
Injection Pressure	680 - 1240 bar
Melt Temperature	300 - 330 °C
Mold Temperature	135 - 160 °C
Drying	4 - 6 hrs @ 105 °C
Moisture Content	0.05 %
Dew Point	-30 °C

**PROCESSING NOTES**

Desiccant Type Dryer Required.