



**Product Data Sheet &
General Processing Conditions**

**RTP 4099 X 117359 D
Polyphthalamide (PPA)
LDS Platable
Glass Fiber
Mineral**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.59	1.59	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0040 in/in	0.40 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.0 ft-lbs/in	53 J/m	D 256
unnotched 1/8 in (3.2 mm) section	10.0 ft-lbs/in	534 J/m	D 4812
Tensile Strength	16500 psi	114 MPa	D 638
Tensile Elongation	2.0 %	2.0 %	D 638
Tensile Modulus	1.50 x 10 ⁶ psi	10342 MPa	D 638
Flexural Strength	24500 psi	169 MPa	D 790
Flexural Modulus	1.40 x 10 ⁶ psi	9653 MPa	D 790

ELECTRICAL

Dielectric Constant, 1 MHz, Dry	3.9	3.9	D 150
Dissipation Factor, 1 MHz, Dry	0.0200	0.0200	D 150

THERMAL

Deflection Temperature @ 66 psi (455 kPa)	535 °F	279 °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	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.