



**Product Data Sheet &  
General Processing Conditions**

**RTP 4099 X 94115  
Polyphthalamide (PPA)  
Impact Modified  
Glass Fiber  
Heat Stabilized**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Primary Additive	15 %	15 %	
Specific Gravity	1.20	1.20	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0040 - 0.0070 in/in	0.40 - 0.70 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	3.5 ft-lbs/in	187 J/m	D 256
unnotched 1/8 in (3.2 mm) section	14.0 ft-lbs/in	747 J/m	D 4812
Tensile Strength	11000 psi	76 MPa	D 638
Tensile Elongation	4.0 - 6.0 %	4.0 - 6.0 %	D 638
Tensile Modulus	0.60 x 10 <sup>6</sup> psi	4137 MPa	D 638
Flexural Strength	17000 psi	117 MPa	D 790
Flexural Modulus	0.60 x 10 <sup>6</sup> psi	4137 MPa	D 790

**THERMAL**

Deflection Temperature @ 264 psi (1820 kPa)	322 °F	161 °C	D 648
@ 66 psi (455 kPa)	519 °F	271 °C	D 648

**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**

	<b>English</b>	<b>SI Metric</b>
Injection Pressure	10000 - 18000 psi	69 - 124 MPa
Melt Temperature	550 - 575 °F	288 - 302 °C
Mold Temperature	250 - 300 °F	121 - 149 °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.