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Product Data Sheet & General Processing Conditions

RTP 4401 High Temperature Nylon (HTN) Glass Fiber

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	10 %	10 %	
Specific Gravity	1.26	1.26	D 792
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0040 - 0.0050 in/in	0.40 - 0.50 %	D 955
Water Absorption, 24 hrs @ 23°C	0.500 %	0.500 %	D 570

MECHANICAL

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	0.7 ft-lbs/in	37 J/m	D 256
unnotched 1/8 in (3.2 mm) section	5.0 ft-lbs/in	267 J/m	D 4812
Tensile Strength	13000 psi	90 MPa	D 638
Tensile Elongation	1.0 - 2.0 %	1.0 - 2.0 %	D 638
Tensile Modulus	0.75 x 10 ⁶ psi	5171 MPa	D 638
Flexural Strength	21000 psi	145 MPa	D 790
Flexural Modulus	0.70 x 10 ⁶ psi	4826 MPa	D 790
Hardness			
Rockwell, R	124	124	D 785

THERMAL

Deflection Temperature			
@ 264 psi (1820 kPa)	450 °F	232 °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

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	590 - 650 °F	310 - 343 °C
Mold Temperature	275 - 325 °F	135 - 163 °C
Drying	4 hrs @ 175 °F	4 hrs @ 79 °C
Moisture Content	0.10 %	0.10 %
Dew Point	-40 °F	-40 °C

PROCESSING NOTES

Desiccant Type Dryer Required.