



**Product Data Sheet &
General Processing Conditions**

**RTP 4408 HS L
High Temperature Nylon (HTN)
Glass Fiber
Heat Stabilized
Lubricated**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	45 %	45 %	
Specific Gravity	1.56	1.56	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0020 in/in	0.20 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	2.2 ft-lbs/in	117 J/m	D 256
unnotched 1/8 in (3.2 mm) section	22.0 ft-lbs/in	1175 J/m	D 4812
Tensile Elongation	2.0 - 3.0 %	2.0 - 3.0 %	D 638
Tensile Modulus	2.10 x 10 ⁶ psi	14480 MPa	D 638
Flexural Strength	47000 psi	324 MPa	D 790
Flexural Modulus	2.00 x 10 ⁶ psi	13790 MPa	D 790
Hardness Rockwell, R	125	125	D 785

THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	505 °F	263 °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 - 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.