



**Product Data Sheet &
General Processing Conditions**

**RTP 299 X 117593 C
Nylon 6/6 (PA)
Glass Fiber
Flame Retardant
Halogen Free**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	25 %	25 %	
Specific Gravity	1.39	1.39	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0020 - 0.0040 in/in	0.20 - 0.40 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.6 ft-lbs/in	85 J/m	D 256
unnotched 1/8 in (3.2 mm) section	15.0 ft-lbs/in	801 J/m	D 4812
Tensile Strength	19000 psi	131 MPa	D 638
Tensile Elongation	2.0 - 4.0 %	2.0 - 4.0 %	D 638
Tensile Modulus	1.10 x 10 ⁶ psi	7584 MPa	D 638
Flexural Strength	30000 psi	207 MPa	D 790
Flexural Modulus	1.40 x 10 ⁶ psi	9653 MPa	D 790

THERMAL

Ignition Resistance*			
Flammability**	V-0 @ 1/32 in	V-0 @ 0.8 mm	D 3801
Glow Wire Ignitability Temperature**	775 °C @ 1/32 in	775 °C @ 0.8 mm	IEC 60695-2-13

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.

* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

** Values per RTP Company testing.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	10000 - 18000 psi	69 - 124 MPa
Melt Temperature	530 - 570 °F	277 - 299 °C
Mold Temperature	150 - 225 °F	66 - 107 °C
Drying	4 hrs @ 175 °F	4 hrs @ 79 °C
Moisture Content	0.20 %	0.20 %
Dew Point	0 °F	-18 °C

PROCESSING NOTES

Desiccant Type Dryer Required.