



**Product Data Sheet &
General Processing Conditions**

**RTP 199 X 123127 A
Polypropylene (PP)
Long Glass Fiber
Chemically Coupled
UV Stabilized**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE		STANDARD
Primary Additive	30 %	
Density	1.12 g/cm ³	ISO 1183
Shrinkage, 4 mm Thickness		
Flow direction	0.10 - 0.40 %	ASTM D 955

MECHANICAL		
Impact Strength, Izod		
Notched, 4 mm thickness	18 kJ/m ²	ISO 180/1A
Tensile Strength	100 MPa	ISO 527
Tensile Elongation	3.0 %	ISO 527
Tensile Modulus	7500 MPa	ISO 527
Flexural Strength	150 MPa	ISO 178
Flexural Modulus	8000 MPa	ISO 178

THERMAL		
Heat Deflection Temperature		
@ 1.80 MPa	155 °C	ISO 75
Ignition Resistance*		
Flammability**	HB @ 1.5 mm	ISO 1210

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

Injection Pressure	70 - 105 MPa
Injection Pressure	680 - 1030 bar
Melt Temperature	190 - 230 °C
Mold Temperature	30 - 65 °C
Drying	2 hrs @ 80 °C

PROCESSING NOTES

Use a reverse barrel profile. To maximize fiber length, the following injection barrel, screw, and tip designs should be followed. L/D ratio 16/1 - 22/1, Compression ratio 2:1, Flight depth 5 mm minimum, in feed section, Screw diameter 16.5 - 20 mm minimum, Compression section length 12 - 13 diameters, Check ring valve assembly - free flow type no restrictions, Nozzle orifice 6 mm diameter. Feed throat from hopper to machine must have sufficient opening to prevent bridging of long pellet composition.