



**Product Data Sheet &
General Processing Conditions**

**RTP 4008 A
(Hot Water Moldable) Polyphthalamide
(PPA)
Glass Fiber**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	45 %	45 %	
Specific Gravity	1.57	1.57	D 792
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0020 - 0.0030 in/in	0.20 - 0.30 %	D 955
Water Absorption, 24 hrs @ 23°C	0.200 %	0.200 %	D 570

MECHANICAL

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	1.8 ft-lbs/in	96 J/m	D 256
unnotched 1/8 in (3.2 mm) section	15.0 ft-lbs/in	801 J/m	D 4812
Tensile Strength	32000 psi	221 MPa	D 638
Tensile Elongation	2.0 %	2.0 %	D 638
Tensile Modulus	2.30 x 10 ⁶ psi	15858 MPa	D 638
Flexural Strength	45000 psi	310 MPa	D 790
Flexural Modulus	2.10 x 10 ⁶ psi	14480 MPa	D 790
Hardness			
Rockwell, R	125	125	D 785

ELECTRICAL

Volume Resistivity	> 1E15 ohm.cm	> 1E15 ohm.cm	D 257
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THERMAL

Deflection Temperature			
@ 264 psi (1820 kPa)	530 °F	277 °C	D 648
Ignition Resistance*			
Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635

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 - 15000 psi	69 - 103 MPa
Melt Temperature	625 - 650 °F	329 - 343 °C
Mold Temperature	150 - 325 °F	66 - 163 °C
Drying	4 - 6 hrs @ 225 °F	4 - 6 hrs @ 107 °C
Moisture Content	0.10 %	0.10 %
Dew Point	-20 °F	-29 °C

PROCESSING NOTES

Desiccant Type Dryer Required.