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**Product Data Sheet &
General Processing Conditions**

**RTP 4009 UP
Polyphthalamide (PPA)
Glass Fiber
Ultra Performance**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE		STANDARD
Primary Additive	50 %	
Density	1.64 g/cm ³	ISO 1183
MECHANICAL		
Impact Strength, Izod		
Notched, 4 mm thickness	15 kJ/m ²	ISO 180/1A
Unnotched, 4 mm thickness	70 kJ/m ²	ISO 180/1U
Tensile Strength	285 MPa	ISO 527
Tensile Elongation	2.2 %	ISO 527
Tensile Modulus	20000 MPa	ISO 527
Flexural Strength	440 MPa	ISO 178
Flexural Modulus	18500 MPa	ISO 178

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

Injection Pressure	70 - 125 MPa
Injection Pressure	680 - 1240 bar
Melt Temperature	300 - 330 °C
Mold Temperature	135 - 160 °C
Drying	4 - 6 hrs @ 105 °C
Moisture Content	0.05 %
Dew Point	-30 °C

PROCESSING NOTES

Desiccant Type Dryer Required.