



**Product Data Sheet &
General Processing Conditions**

**RTP 4099 X 94115
Polyphthalamide (PPA)
Impact Modified
Glass Fiber
Heat Stabilized**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	15 %	15 %	
Specific Gravity	1.20	1.20	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0040 - 0.0070 in/in	0.40 - 0.70 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	3.5 ft-lbs/in	187 J/m	D 256
unnotched 1/8 in (3.2 mm) section	14.0 ft-lbs/in	747 J/m	D 4812
Tensile Strength	11000 psi	76 MPa	D 638
Tensile Elongation	4.0 - 6.0 %	4.0 - 6.0 %	D 638
Tensile Modulus	0.60 x 10 ⁶ psi	4137 MPa	D 638
Flexural Strength	17000 psi	117 MPa	D 790
Flexural Modulus	0.60 x 10 ⁶ psi	4137 MPa	D 790

THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	322 °F	161 °C	D 648
@ 66 psi (455 kPa)	519 °F	271 °C	D 648

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 - 18000 psi	69 - 124 MPa
Melt Temperature	550 - 575 °F	288 - 302 °C
Mold Temperature	250 - 300 °F	121 - 149 °C
Drying	4 - 6 hrs @ 225 °F	4 - 6 hrs @ 107 °C
Moisture Content	0.05 %	0.05 %
Dew Point	-25 °F	-32 °C

PROCESSING NOTES

Desiccant Type Dryer Required.