



**Product Data Sheet &  
General Processing Conditions**

**RTP PA66 HI 30 GF BLK  
Nylon 6/6 (PA)  
Value Product  
Glass Fiber  
Impact Modified  
Heat Stabilized**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

| <b>PERMANENCE</b>         |                        | <b>STANDARD</b> |
|---------------------------|------------------------|-----------------|
| Density                   | 1.32 g/cm <sup>3</sup> | ISO 1183        |
| Shrinkage, 4 mm Thickness |                        |                 |
| Flow direction            | 0.20 - 0.40 %          | ISO 294-4       |

**MECHANICAL**

|                           |                      |            |
|---------------------------|----------------------|------------|
| Impact Strength, Izod     |                      |            |
| Notched, 4 mm thickness   | 15 kJ/m <sup>2</sup> | ISO 180/1A |
| Unnotched, 4 mm thickness | 55 kJ/m <sup>2</sup> | ISO 180/1U |
| Tensile Strength          | 120 MPa              | ISO 527    |
| Tensile Elongation        | 3.0 - 6.0 %          | ISO 527    |
| Tensile Modulus           | 8800 MPa             | ISO 527    |
| Flexural Strength         | 200 MPa              | ISO 178    |
| Flexural Modulus          | 7300 MPa             | ISO 178    |

**THERMAL**

|                      |             |          |
|----------------------|-------------|----------|
| 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 - 125 MPa   |
| Injection Pressure | 680 - 1240 bar |
| Melt Temperature   | 275 - 300 °C   |
| Mold Temperature   | 65 - 105 °C    |
| Drying             | 4 hrs @ 80 °C  |
| Moisture Content   | 0.20 %         |
| Dew Point          | -25 °C         |

**PROCESSING NOTES**

Desiccant Type Dryer Required.

This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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