

# RTP 199 X 70836 A

Polypropylene

RTP Company

Message:

Warning: The status of this material is 'Commercial: Limited Issue'  
The data for this material has not been recently verified.  
Please contact RTP Company for current information prior to specifying this grade.

General Information			
Filler / Reinforcement	Long glass fiber, 40% filler by weight		
Features	Chemical coupling		
RoHS Compliance	Contact manufacturer		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.21	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.10 - 0.30	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8900	MPa	ISO 527-2
Tensile Stress (Yield)	120	MPa	ISO 527-2
Tensile Strain (Break)	1.5 - 2.5	%	ISO 527-2
Flexural Modulus	8500	MPa	ISO 178
Flexural Stress	179	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact <sup>1</sup>	21	kJ/m <sup>2</sup>	ISO 180/1A
Unnotched Izod Impact Strength <sup>2</sup>	28	kJ/m <sup>2</sup>	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	155	°C	ISO 75-2/A
Flammability	Nominal Value	Unit	Test Method
Burning Rate <sup>3</sup> (2.00 mm)	< 100	mm/min	ISO 3795
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Processing (Melt) Temp	190 - 230	°C	
Mold Temperature	30.0 - 65.0	°C	
Injection Pressure	70.0 - 105	MPa	
Injection instructions			

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.

NOTE	
1.	4 mm thickness
2.	4 mm thickness
3.	Values per RTP Company testing.

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Recommended distributors for this material


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