

RTP VLF 80209 EM HS

Polyamide 66

RTP Company

Message:

Long Glass Fiber - Easy Molding - Heat Stabilized

General Information			
Filler / Reinforcement	Long glass fiber, 50% filler by weight		
Additive	heat stabilizer		
Features	Good formability		
	Thermal Stability		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.57	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.10 - 0.30	%	ASTM D955
Moisture Content	0.20	%	
Primary Additive	50	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	15900	MPa	ASTM D638
Tensile Strength	259	MPa	ASTM D638
Tensile Elongation (Yield)	2.0 - 3.0	%	ASTM D638
Flexural Modulus	15200	MPa	ASTM D790
Flexural Strength	400	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	480	J/m	ASTM D256
Unnotched Izod Impact (3.20 mm)	1500	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	260	°C	ASTM D648
1.8 MPa, not annealed	249	°C	ASTM D648
Flammability	Nominal Value	Test Method	
Flame Rating (1.50 mm, ** Values per RTP Company testing.)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Drying Time	2.0 - 4.0	hr	
Dew Point	-17.8	°C	
Processing (Melt) Temp	271 - 299	°C	

Mold Temperature	65.6 - 124	°C
Injection Pressure	34.5 - 124	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 0.200 in (5 mm) minimum, in feed section, Screw diameter 0.65 - 0Desiccant Type Dryer Required.

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