

RTP VLF 84007

Polyphthalamide

RTP Company

Message:

Long Glass Fiber - Heat Stabilized

General Information			
Filler / Reinforcement	Long glass fiber, 40% filler by weight		
Additive	heat stabilizer		
Features	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	0.050	%	
Primary Additive	40	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	15200	MPa	ASTM D638
Tensile Strength	228	MPa	ASTM D638
Tensile Elongation (Yield)	1.5 - 2.5	%	ASTM D638
Flexural Modulus	14500	MPa	ASTM D790
Flexural Strength	324	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	290	J/m	ASTM D256
Unnotched Izod Impact (3.20 mm)	820	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	277	°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	121	°C	
Drying Time	4.0	hr	
Dew Point	-31.7	°C	
Processing (Melt) Temp	304 - 329	°C	
Mold Temperature	135 - 163	°C	
Injection Pressure	68.9 - 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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