

RTP 204F

Polyamide 12

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.
-Preliminary Product Data per RTP Co.-

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 25% filler by weight		
RoHS Compliance	Contact manufacturer		
Appearance	Black		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.35	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	109		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6210	MPa	ASTM D638
Tensile Strength	100	MPa	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	4830	MPa	ASTM D790
Flexural Strength	145	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	140	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	800	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	168	°C	ASTM D648
1.8 MPa, not annealed	163	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms · cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Additional Information			

Mold Shrinkage, Linear-Flow, ASTM D-955, 0.25 in.: 5.5 mil/in. Tensile Elongation, ASTM D-638: 5-7%

Injection	Nominal Value	Unit
Drying Temperature	79.4	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.10	%
Suggested Max Regrind	20	%
Rear Temperature	221 - 254	°C
Middle Temperature	221 - 254	°C
Front Temperature	221 - 254	°C
Mold Temperature	37.8 - 65.6	°C
Injection Pressure	68.9 - 103	MPa

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