RTP 199 X 70836 B

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, 50% filler by weight		
Features	Chemical coupling		
RoHS Compliance	Contact manufacturer		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.33	g/cm³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.10 - 0.30	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	11800	MPa	ISO 527-2/5
Tensile Stress (Yield)	132	MPa	ISO 527-2/5
Tensile Strain (Break)	2.0 - 2.5	%	ISO 527-2
Flexural Modulus	11700	MPa	ISO 178
Flexural Stress	205	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [1]	23	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength [2]	75	kJ/m²	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	160	°C	ISO 75-2/B
1.8 MPa, not annealed	155	°C	ISO 75-2/A
Flammability	**Nominal Value**		**Test Method**
Flame Rating (1.50 mm, Values per RTP Company testing.)	HB		ISO 1210
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

Recommended distributors for this material

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