




**Product Data Sheet &
General Processing Conditions**

**RTP 299 X 63548
Nylon 6/6 (PA)
Unreinforced
Flame Retardant
Halogen Free
UL94 V-0**



PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.18	1.18	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0140 - 0.0180 in/in	1.40 - 1.80 %	D 955
Water Absorption, 24 hrs @ 23°C	0.950 %	0.950 %	D 570

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.7 ft-lbs/in	37 J/m	D 256
unnotched 1/8 in (3.2 mm) section	13.0 ft-lbs/in	694 J/m	D 4812
Tensile Strength	9500 psi	66 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.50 x 10 ⁶ psi	3448 MPa	D 638
Flexural Strength	16500 psi	114 MPa	D 790
Flexural Modulus	0.47 x 10 ⁶ psi	3241 MPa	D 790
Hardness Rockwell, R	118	118	D 785

ELECTRICAL

Volume Resistivity	> 1E15 ohm.cm	> 1E15 ohm.cm	D 257
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THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	170 °F	77 °C	D 648
@ 66 psi (455 kPa)	370 °F	188 °C	D 648
VICAT Softening Temperature 120 Å°C/h, 50 N	442 °F	228 °C	D 1525
Ignition Resistance*			
Flammability	V-0 @ 1/32 in	V-0 @ 0.8 mm	UL94
Glow Wire Ignitability Temperature	960 °C @ 1/32 in	960 °C @ 0.8 mm	IEC 60695-2-13
Glow Wire Flammability Index	960 °C @ 1/32 in	960 °C @ 0.8 mm	IEC 60695-2-12

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
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Injection Pressure	10000 - 18000 psi	69 - 124 MPa
Melt Temperature	470 - 530 °F	243 - 277 °C
Mold Temperature	150 - 225 °F	66 - 107 °C
Drying	4 hrs @ 175 °F	4 hrs @ 79 °C
Moisture Content	0.20 %	0.20 %
Dew Point	0 °F	-18 °C

PROCESSING NOTES

Desiccant Type Dryer Required.

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This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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