**Product Data Sheet & General Processing Conditions**

**RTP 199 X 155657 C**
Polypropylene (PP)
Cellulose Fiber
30% Renewable Resource Content*
High Flow
Preliminary Datasheet

*Based on % of total compound weight

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

<table>
<thead>
<tr>
<th>PERMANENCE</th>
<th>English</th>
<th>SI Metric</th>
<th>ASTM TEST</th>
</tr>
</thead>
<tbody>
<tr>
<td>Specific Gravity</td>
<td>1.04</td>
<td>1.04</td>
<td>D 792</td>
</tr>
<tr>
<td>Molding Shrinkage</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1/8 in (3.2 mm) section</td>
<td>0.0020 - 0.0080 in/in</td>
<td>0.20 - 0.80 %</td>
<td>D 955</td>
</tr>
</tbody>
</table>

**MECHANICAL**

- Impact Strength, Izod
  - notched 1/8 in (3.2 mm) section: 1.0 ft-lbs/in, 53 J/m, D 256
  - unnotched 1/8 in (3.2 mm) section: 7.0 ft-lbs/in, 374 J/m, D 4812
- Tensile Strength: 6000 psi, 41 MPa, D 638
- Tensile Elongation: 4.0 %, D 638
- Tensile Modulus: 0.50 x 10^6 psi, 3448 MPa, D 638
- Flexural Strength: 10000 psi, 69 MPa, D 790
- Flexural Modulus: 0.50 x 10^6 psi, 3448 MPa, D 790

**THERMAL**

- Deflection Temperature
  @ 66 psi (455 kPa): 280 °F, 138 °C, D 648

**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.

**GENERAL PROCESSING FOR INJECTION MOLDING**

<table>
<thead>
<tr>
<th></th>
<th>English</th>
<th>SI Metric</th>
</tr>
</thead>
<tbody>
<tr>
<td>Injection Pressure</td>
<td>10000 - 15000 psi</td>
<td>69 - 103 MPa</td>
</tr>
<tr>
<td>Melt Temperature</td>
<td>340 - 400 °F</td>
<td>171 - 204 °C</td>
</tr>
<tr>
<td>Mold Temperature</td>
<td>90 - 150 °F</td>
<td>32 - 66 °C</td>
</tr>
<tr>
<td>Drying</td>
<td>4 hrs @ 175 °F</td>
<td>4 hrs @ 79 °C</td>
</tr>
</tbody>
</table>

**PROCESSING NOTES**

Process at lowest temperature possible to prevent fiber degradation. Do not exceed 400 degrees Fahrenheit

3 Jan 2020 BJG

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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