Product Data Sheet &
General Processing Conditions

RTP 1400 AG-230
Polyethersulfone (PES)
Glass Fiber
UL94 V-0

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	30 %	30 %	
Specific Gravity	1.60	1.60	D 792
Melt Flow Rate			
@ 385 °C, / 2.16 kg	13.00 - 16.00 g/10 min	13.00 - 16.00 g/10 min	D 1238
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0015 - 0.0030 in/in	0.15 - 0.30 %	D 955
Water Absorption, 24 hrs @ 23°C	0.400 %	0.400 %	D 570
MECHANICAL			
Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	1.5 ft-lbs/in	80 J/m	D 256
unnotched 1/8 in (3.2 mm) section	11.0 ft-lbs/in	587 J/m	D 4812
Tensile Strength	20000 psi	138 MPa	D 638
Tensile Elongation	3.0 - 4.0 %	3.0 - 4.0 %	D 638
Tensile Modulus	1.25 x 10^6 psi	8619 MPa	D 638
Flexural Strength	27500 psi	190 MPa	D 790
Flexural Modulus	1.15 x 10^6 psi	7929 MPa	D 790
Hardness			
Rockwell, R	123	123	D 785
ELECTRICAL			
Volume Resistivity	> 1E16 ohm.cm	> 1E16 ohm.cm	D 257
Surface Resistance	> 1E15 ohm	> 1E15 ohm	ESD STM11.11
THERMAL			
Deflection Temperature			
@ 264 psi (1820 kPa)	415 °F	213 °C	D 648
Ignition Resistance*			
Flammability	V-0 @ 1/32 in	V-0 @ 0.8 mm	UL94

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
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	650 - 710 °F	343 - 377 °C
Mold Temperature	275 - 350 °F	135 - 177 °C
Drying	6 hrs @ 300 °F	6 hrs @ 149 °C
Moisture Content	0.04 %	0.04 %
Dew Point	-25 °F	-32 °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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