



**Product Data Sheet &
General Processing Conditions**

**RTP 2199 X 132987 NS
Polyetherimide (PEI)
No Subs**



PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.27	1.27	D 792
Melt Flow Rate @ 337 °C, / 6.6 kg	17.80 g/10 min	17.80 g/10 min	D 1238
Molding Shrinkage 1/8 in (3.2 mm) section	0.0050 - 0.0070 in/in	0.50 - 0.70 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.6 ft-lbs/in	32 J/m	D 256
unnotched 1/8 in (3.2 mm) section	25.0 ft-lbs/in	1335 J/m	D 4812
Tensile Strength	16000 psi	110 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.52 x 10 ⁶ psi	3585 MPa	D 638
Flexural Strength	24000 psi	165 MPa	D 790
Flexural Modulus	0.50 x 10 ⁶ psi	3448 MPa	D 790

THERMAL

Ignition Resistance*			
Flammability	V-2 @ 1/32 in	V-2 @ 0.8 mm	UL94
Flammability	V-0 @ 1/8 in	V-0 @ 3.0 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	12000 - 18000 psi	83 - 124 MPa
Melt Temperature	670 - 750 °F	354 - 399 °C
Mold Temperature	275 - 350 °F	135 - 177 °C
Drying	4 hrs @ 300 °F	4 hrs @ 149 °C
Moisture Content	0.04 %	0.04 %
Dew Point	-20 °F	-29 °C

PROCESSING NOTES

Desiccant Type Dryer Required.