



**Product Data Sheet &  
General Processing Conditions**

**RTP 1400 AG-330  
Polyethersulfone (PES)  
Glass Fiber**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Primary Additive	30 %	30 %	
Specific Gravity	1.58	1.58	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0020 in/in	0.20 %	D 955
<b>MECHANICAL</b>			
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	12.0 ft-lbs/in	641 J/m	D 4812
Tensile Strength	20000 psi	138 MPa	D 638
Tensile Elongation	2.5 %	2.5 %	D 638
Tensile Modulus	1.30 x 10 <sup>6</sup> psi	8964 MPa	D 638
Flexural Strength	28000 psi	193 MPa	D 790
Flexural Modulus	1.20 x 10 <sup>6</sup> psi	8274 MPa	D 790
<b>ELECTRICAL</b>			
Volume Resistivity	> 1E12 ohm.cm	> 1E12 ohm.cm	D 257
<b>THERMAL</b>			
Deflection Temperature @ 264 psi (1820 kPa)	410 °F	210 °C	D 648
@ 66 psi (455 kPa)	420 °F	216 °C	D 648
Ignition Resistance* Flammability**	V-0 @ 1/16 in	V-0 @ 1.5 mm	D 3801
Coefficient of Linear Thermal Expansion Flow Direction	1.6 x 10 <sup>-5</sup> /°F	2.9 x 10 <sup>-5</sup> /°C	E 831
Transverse Direction	5.2 x 10 <sup>-5</sup> /°F	9.4 x 10 <sup>-5</sup> /°C	E 831

**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.

\*\* Values per RTP Company testing.

**GENERAL PROCESSING FOR INJECTION MOLDING**

	<b>English</b>	<b>SI Metric</b>
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.