



**Product Data Sheet &
General Processing Conditions**

**RTP 1400 GB 30
Polyethersulfone (PES)
Glass Bead**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	30 %	30 %	
Specific Gravity	1.56	1.56	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0080 in/in	0.80 %	D 955
MECHANICAL			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.8 ft-lbs/in	43 J/m	D 256
unnotched 1/8 in (3.2 mm) section	5.5 ft-lbs/in	294 J/m	D 4812
Tensile Strength	10000 psi	69 MPa	D 638
Tensile Elongation	2.5 %	2.5 %	D 638
Tensile Modulus	0.60 x 10 ⁶ psi	4137 MPa	D 638
Flexural Strength	17000 psi	117 MPa	D 790
Flexural Modulus	0.60 x 10 ⁶ psi	4137 MPa	D 790

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

	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.