



**Product Data Sheet &  
General Processing Conditions**

**RTP 1502-65D  
Polyether-Ester Block Copolymer (TEEE/COPE)  
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                             | 15 %                  | 15 %             |                  |
| Specific Gravity                             | 1.33                  | 1.33             | D 792            |
| Molding Shrinkage<br>1/8 in (3.2 mm) section | 0.0037 - 0.0043 in/in | 0.37 - 0.43 %    | D 955            |

**MECHANICAL**

|  |                            |          |        |
|--|----------------------------|----------|--------|
| Impact Strength, Izod<br>notched 1/8 in (3.2 mm) section | 6.7 ft-lbs/in              | 358 J/m  | D 256  |
| unnotched 1/8 in (3.2 mm) section                        | 21.1 ft-lbs/in             | 1127 J/m | D 4812 |
| Tensile Strength   | 6250 psi                   | 43 MPa   | D 638  |
| Tensile Elongation                                       | > 10.0 %                   | > 10.0 % | D 638  |
| Tensile Modulus  | 0.23 x 10 <sup>6</sup> psi | 1586 MPa | D 638  |
| Flexural Strength  | 7050 psi                   | 49 MPa   | D 790  |
| Flexural Modulus   | 0.19 x 10 <sup>6</sup> psi | 1310 MPa | D 790  |
| Hardness<br>Shore D, instantaneous                       | 68                         | 68       | D 2240 |

**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**

|                    | <b>English</b>     | <b>SI Metric</b>   |
|--------------------|--------------------|--------------------|
| Injection Pressure | 10000 - 15000 psi  | 69 - 103 MPa       |
| Melt Temperature   | 410 - 460 °F       | 210 - 238 °C       |
| Mold Temperature   | 70 - 100 °F        | 21 - 38 °C         |
| Drying             | 2 - 4 hrs @ 220 °F | 2 - 4 hrs @ 104 °C |
| Moisture Content   | < 0.10 %           | < 0.10 %           |

**PROCESSING NOTES**

Desiccant Type Dryer Required.