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**Product Data Sheet &
General Processing Conditions**

**RTP 1400 A-300
Polyethersulfone (PES)**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.37	1.37	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0070 - 0.0090 in/in	0.70 - 0.90 %	D 955
Water Absorption, 24 hrs @ 23°C	0.430 %	0.430 %	D 570

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.0 ft-lbs/in	53 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	12000 psi	83 MPa	D 638
Tensile Elongation	50.0 %	50.0 %	D 638
Tensile Modulus	0.38 x 10 ⁶ psi	2620 MPa	D 638
Flexural Strength	18000 psi	124 MPa	D 790
Flexural Modulus	0.40 x 10 ⁶ psi	2758 MPa	D 790

ELECTRICAL

Volume Resistivity	> 1E16 ohm.cm	> 1E16 ohm.cm	D 257
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THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	400 °F	204 °C	D 648
@ 66 psi (455 kPa)	405 °F	207 °C	D 648
Ignition Resistance*			
Flammability**	V-0 @ 1/32 in	V-0 @ 0.8 mm	D 3801

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

	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.