



**Product Data Sheet &
General Processing Conditions**

**RTP 1481 TFE 10
Polyethersulfone (PES)
Carbon Fiber
PTFE Lubricated**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	10 %	10 %	
Specific Gravity	1.45	1.45	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0010 - 0.0030 in/in	0.10 - 0.30 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.1 ft-lbs/in	59 J/m	D 256
unnotched 1/8 in (3.2 mm) section	10.0 ft-lbs/in	534 J/m	D 4812
Tensile Strength	21000 psi	145 MPa	D 638
Tensile Elongation	1.5 - 3.0 %	1.5 - 3.0 %	D 638
Tensile Modulus	1.40 x 10 ⁶ psi	9653 MPa	D 638
Flexural Strength	30000 psi	207 MPa	D 790
Flexural Modulus	1.30 x 10 ⁶ psi	8964 MPa	D 790

ELECTRICAL

Volume Resistivity	1E3 - 1E6 ohm.cm	1E3 - 1E6 ohm.cm	D 257
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THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	425 °F	218 °C	D 648
Ignition Resistance* Flammability**	V-0 @ 1/16 in	V-0 @ 1.5 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.