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**Product Data Sheet &
General Processing Conditions**

**RTP 1503-55D HS
Polyether-Ester Block Copolymer
(TEEE/COPE)
Glass Fiber
Heat Stabilized**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	20 %	20 %	
Specific Gravity	1.35	1.35	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0016 - 0.0026 in/in	0.16 - 0.26 %	D 955

MECHANICAL

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	6.4 ft-lbs/in	342 J/m	D 256
unnotched 1/8 in (3.2 mm) section	20.6 ft-lbs/in	1100 J/m	D 4812
Tensile Strength	6250 psi	43 MPa	D 638
Tensile Elongation	9.5 %	9.5 %	D 638
Tensile Modulus	0.29 x 10 ⁶ psi	2000 MPa	D 638
Flexural Strength	7400 psi	51 MPa	D 790
Flexural Modulus	0.24 x 10 ⁶ psi	1655 MPa	D 790
Hardness			
Shore D, instantaneous	66	66	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

	English	SI Metric
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.