



**Product Data Sheet &  
General Processing Conditions**

**RTP 2100  
Polyetherimide (PEI)**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.27	1.27	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0080 in/in	0.80 %	D 955
Water Absorption, 24 hrs @ 23°C	0.250 %	0.250 %	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	25.0 ft-lbs/in	1335 J/m	D 4812
Tensile Strength	15800 psi	109 MPa	D 638
Tensile Elongation	6.0 - 10.0 %	6.0 - 10.0 %	D 638
Tensile Modulus	0.48 x 10 <sup>6</sup> psi	3310 MPa	D 638
Flexural Strength	21000 psi	145 MPa	D 790
Flexural Modulus	0.48 x 10 <sup>6</sup> psi	3310 MPa	D 790

**ELECTRICAL**

Dielectric Strength, S/T, in oil	500 VPM	19.7 kV/mm	D 149
Dielectric Constant, 1 MHz, Dry	3.2	3.2	D 150
Dissipation Factor, 1 MHz, Dry	0.0040	0.0040	D 150
Volume Resistivity	> 1E12 ohm.cm	> 1E12 ohm.cm	D 257

**THERMAL**

Deflection Temperature @ 264 psi (1820 kPa)	392 °F	200 °C	D 648
@ 66 psi (455 kPa)	410 °F	210 °C	D 648
Ignition Resistance* Flammability**	V-0 @ 1/16 in	V-0 @ 1.5 mm	D 3801
Coefficient of Linear Thermal Expansion Flow Direction	3.1 x 10 <sup>-5</sup> /°F	5.6 x 10 <sup>-5</sup> /°C	E 831
Thermal Conductivity Through-plane	1.50 (BTU.in)/(hr.ft <sup>2</sup> .°F)	0.22 W/(m.K)	E 1530

**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**

	<b>English</b>	<b>SI Metric</b>
Injection Pressure	12000 - 18000 psi	83 - 124 MPa
Melt Temperature	670 - 750 °F	354 - 399 °C
Mold Temperature	275 - 350 °F	135 - 177 °C
Drying	4 hrs @ 300 °F	4 hrs @ 149 °C
Moisture Content	0.04 %	0.04 %
Dew Point	-20 °F	-29 °C

**PROCESSING NOTES**

Desiccant Type Dryer Required.

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This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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