



**Product Data Sheet &
General Processing Conditions**

**RTP 2183
Polyetherimide (PEI)
Carbon Fiber**

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	0.0005 in/in	0.05 %	D 955
Water Absorption, 24 hrs @ 23°C	0.200 %	0.200 %	D 570

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.4 ft-lbs/in	75 J/m	D 256
unnotched 1/8 in (3.2 mm) section	12.0 ft-lbs/in	641 J/m	D 4812
Tensile Strength	32000 psi	221 MPa	D 638
Tensile Elongation	< 2.0 %	< 2.0 %	D 638
Tensile Modulus	2.40 x 10 ⁶ psi	16548 MPa	D 638
Flexural Strength	39000 psi	269 MPa	D 790
Flexural Modulus	2.10 x 10 ⁶ psi	14480 MPa	D 790

ELECTRICAL

Volume Resistivity	< 1E4 ohm.cm	< 1E4 ohm.cm	D 257
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THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	405 °F	207 °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

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	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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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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