




**Product Data Sheet &  
General Processing Conditions**

**RTP 2199 X 132987 NS  
Polyetherimide (PEI)  
No Subs**  


**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
Melt Flow Rate @ 337 °C, / 6.6 kg	17.80 g/10 min	17.80 g/10 min	D 1238
Molding Shrinkage 1/8 in (3.2 mm) section	0.0050 - 0.0070 in/in	0.50 - 0.70 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.6 ft-lbs/in	32 J/m	D 256
unnotched 1/8 in (3.2 mm) section	25.0 ft-lbs/in	1335 J/m	D 4812
Tensile Strength	16000 psi	110 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.52 x 10 <sup>6</sup> psi	3585 MPa	D 638
Flexural Strength	24000 psi	165 MPa	D 790
Flexural Modulus	0.50 x 10 <sup>6</sup> psi	3448 MPa	D 790

**THERMAL**

Ignition Resistance*			
Flammability	V-2 @ 1/32 in	V-2 @ 0.8 mm	UL94
Flammability	V-0 @ 1/8 in	V-0 @ 3.0 mm	UL94

**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.

**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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RTP COMPANY • 580 EAST FRONT STREET • WINONA, MN 55987 • 507-454-6900