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Ponciplastics.com



Product Data Sheet & General Processing Conditions

RTP 1307 MS 5 Polyphenylene Sulfide (PPS)

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	40 %	40 %	
Specific Gravity	1.75	1.75	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0020 in/in	0.20 %	D 955
Water Absorption, 24 hrs @ 23°C	0.020 %	0.020 %	D 570

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.7 ft-lbs/in	91 J/m	D 256
unnotched 1/8 in (3.2 mm) section	8.0 ft-lbs/in	427 J/m	D 4812
Tensile Strength Break	23500 psi	162 MPa	D 638
Tensile Elongation Break	1.5 %	1.5 %	D 638
Tensile Modulus	2.40 x 10 ⁶ psi	16548 MPa	D 638
Flexural Strength	34000 psi	234 MPa	D 790
Flexural Modulus	2.30 x 10 ⁶ psi	15858 MPa	D 790
Hardness Rockwell, R	123	123	D 785

THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	505 °F	263 °C	D 648
Ignition Resistance* Flammability**	V-0 @ 1/32 in	V-0 @ 0.8 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	585 - 625 °F	307 - 329 °C
Mold Temperature	275 - 350 °F	135 - 177 °C
Drying	6 hrs @ 300 °F	6 hrs @ 149 °C
Moisture Content	0.04 %	0.04 %