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Ponciplastics.com



## Product Data Sheet & General Processing Conditions

### RTP 1311 Polyphenylene Sulfide (PPS) Glass Fiber

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

| PERMANENCE                                   | English      | SI Metric | ASTM TEST |
|----------------------------------------------|--------------|-----------|-----------|
| Primary Additive                             | 60 %         | 60 %      |           |
| Specific Gravity                             | 1.89         | 1.89      | D 792     |
| Molding Shrinkage<br>1/8 in (3.2 mm) section | 0.0010 in/in | 0.10 %    | D 955     |

#### 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 | 7.0 ft-lbs/in              | 374 J/m   | D 4812 |
| Tensile Strength                  | 20000 psi                  | 138 MPa   | D 638  |
| Tensile Elongation                | 0.9 %                      | 0.9 %     | D 638  |
| Tensile Modulus                   | 3.70 x 10 <sup>6</sup> psi | 25512 MPa | D 638  |
| Flexural Strength                 | 30000 psi                  | 207 MPa   | D 790  |
| Flexural Modulus                  | 3.20 x 10 <sup>6</sup> psi | 22064 MPa | D 790  |

#### THERMAL

|                                                |               |              |        |
|------------------------------------------------|---------------|--------------|--------|
| Deflection Temperature<br>@ 264 psi (1820 kPa) | 510 °F        | 266 °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 | 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 %         |