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Product Data Sheet & General Processing Conditions

RTP 1385 TFE 13 SI 2 Polyphenylene Sulfide (PPS) Carbon Fiber Reinforced PTFE & Silicone Lubricated

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	30 %	30 %	
Specific Gravity	1.53	1.53	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0005 in/in	0.05 %	D 955
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	7.0 ft-lbs/in	374 J/m	D 4812
Tensile Strength	25000 psi	172 MPa	D 638
Tensile Elongation	< 1.0 %	< 1.0 %	D 638
Tensile Modulus	3.80 x 10 ⁶ psi	26201 MPa	D 638
Flexural Strength	36000 psi	248 MPa	D 790
Flexural Modulus	3.40 x 10 ⁶ psi	23443 MPa	D 790
ELECTRICAL			
Volume Resistivity	< 1E3 ohm.cm	< 1E3 ohm.cm	D 257
THERMAL			
Deflection Temperature @ 264 psi (1820 kPa)	500 °F	260 °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 %