



**Product Data Sheet &
General Processing Conditions**

**RTP 1307 TFE 10
Polyphenylene Sulfide (PPS)
Glass Fiber Reinforced
PTFE Lubricated**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

| PERMANENCE | English | SI Metric | ASTM TEST |
|--|----------------|------------------|------------------|
| Primary Additive | 40 % | 40 % | |
| Specific Gravity | 1.74 | 1.74 | D 792 |
| Molding Shrinkage 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 | 1.5 ft-lbs/in | 80 J/m | D 256 |
| unnotched 1/8 in (3.2 mm) section | 8.0 ft-lbs/in | 427 J/m | D 4812 |
| Tensile Strength | 21000 psi | 145 MPa | D 638 |
| Tensile Elongation | 1.0 - 2.0 % | 1.0 - 2.0 % | D 638 |
| Tensile Modulus | 2.20 x 10 ⁶ psi | 15169 MPa | D 638 |
| Flexural Strength | 31000 psi | 214 MPa | D 790 |
| Flexural Modulus | 2.00 x 10 ⁶ psi | 13790 MPa | D 790 |

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 % |