



**Product Data Sheet &  
General Processing Conditions**

**RTP 1307 TFE 15  
Polyphenylene Sulfide (PPS)  
Glass Fiber Reinforced  
PTFE Lubricated**

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

| <b>PERMANENCE</b>                            | <b>English</b> | <b>SI Metric</b> | <b>ASTM TEST</b> |
|--|----------------|------------------|------------------|
| Primary Additive                             | 40 %           | 40 %             |                  |
| Specific Gravity                             | 1.78           | 1.78             | D 792            |
| Molding Shrinkage<br>1/8 in (3.2 mm) section | 0.0010 in/in   | 0.10 %           | D 955            |

**MECHANICAL**

|  |                            |             |        |
|--|----------------------------|-------------|--------|
| Impact Strength, Izod<br>notched 1/8 in (3.2 mm) section | 1.4 ft-lbs/in              | 75 J/m      | D 256  |
| unnotched 1/8 in (3.2 mm) section                        | 8.0 ft-lbs/in              | 427 J/m     | D 4812 |
| Tensile Strength   | 19000 psi                  | 131 MPa     | D 638  |
| Tensile Elongation                                       | 1.0 - 2.0 %                | 1.0 - 2.0 % | D 638  |
| Tensile Modulus  | 2.20 x 10 <sup>6</sup> psi | 15169 MPa   | D 638  |
| Flexural Strength  | 28000 psi                  | 193 MPa     | D 790  |
| Flexural Modulus   | 2.00 x 10 <sup>6</sup> psi | 13790 MPa   | D 790  |

**THERMAL**

|  |               |              |        |
|--|---------------|--------------|--------|
| Deflection Temperature<br>@ 264 psi (1820 kPa) | 500 °F        | 260 °C       | D 648  |
| Ignition Resistance*<br>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**

|                    | <b>English</b>    | <b>SI Metric</b> |
|--------------------|-------------------|------------------|
| 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 %           |