



**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**

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
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 <sup>6</sup> psi	26201 MPa	D 638
Flexural Strength	36000 psi	248 MPa	D 790
Flexural Modulus	3.40 x 10 <sup>6</sup> psi	23443 MPa	D 790

**ELECTRICAL**

Volume Resistivity	< 1E3 ohm.cm	< 1E3 ohm.cm	D 257
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**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**

	<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 %