



**Product Data Sheet &
General Processing Conditions**

**RTP 1385
Polyphenylene Sulfide (PPS)
Carbon Fiber**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE **STANDARD**

Primary Additive	30 %	
Density	1.45 g/cm ³	ISO 1183
Water Absorption, 24 hrs @ 23°C	0.10 %	ISO 62

MECHANICAL

Impact Strength, Izod		
Notched, 4 mm thickness	5 kJ/m ²	ISO 180/1A
Unnotched, 4 mm thickness	17 kJ/m ²	ISO 180/1U
Tensile Strength	200 MPa	ISO 527
Tensile Elongation	0.5 - 1.0 %	ISO 527
Tensile Modulus	29000 MPa	ISO 527
Flexural Strength	270 MPa	ISO 178
Flexural Modulus	21000 MPa	ISO 178

ELECTRICAL

Volume Resistivity	< 1E3 ohm.cm	IEC 60093
Surface Resistivity	< 1E5 ohm	IEC 60093

THERMAL

Heat Deflection Temperature		
@ 1.80 MPa	268 °C	ISO 75
Ignition Resistance*		
Flammability**	V-0 @ 1.5 mm	ISO 1210

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

Injection Pressure	70 - 105 MPa
Injection Pressure	680 - 1030 bar
Melt Temperature	305 - 330 °C
Mold Temperature	135 - 175 °C
Drying	6 hrs @ 150 °C
Moisture Content	0.04 %
Dew Point	-25 °C