



**Product Data Sheet &
General Processing Conditions**

**RTP 1387 HEC
Polyphenylene Sulfide (PPS)
Nickel-Coated Carbon Fiber
Electrically Conductive
EMI/RFI/ESD Protection**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	40 %	40 %	
Specific Gravity	1.67	1.67	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0000 - 0.0010 in/in	0.00 - 0.10 %	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	6.0 ft-lbs/in	320 J/m	D 4812
Tensile Strength	25000 psi	172 MPa	D 638
Tensile Elongation	0.5 - 1.0 %	0.5 - 1.0 %	D 638
Tensile Modulus	3.25 x 10 ⁶ psi	22409 MPa	D 638
Flexural Strength	35000 psi	241 MPa	D 790
Flexural Modulus	2.90 x 10 ⁶ psi	19996 MPa	D 790

ELECTRICAL

Volume Resistivity	< 1 ohm.cm	< 1 ohm.cm	D 257
Surface Resistivity	< 1E4 ohm/sq	< 1E4 ohm/sq	D 257
Surface Resistance	< 1E3 ohm	< 1E3 ohm	ESD STM11.11
Static Decay MIL-PRF-81705D, 5kV to 50 V, 12% RH	< 2.00 s	< 2.00 s	FTMS101C 4046.1

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.

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 %

PROCESSING NOTES

Remove hopper magnets.