



**Product Data Sheet &
General Processing Conditions**

**RTP 1399 X 115071 B
Polyphenylene Sulfide (PPS)
Glass Fiber
Carbon Nanotube
ESD Protection**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	30 %	30 %	
Specific Gravity	1.59	1.59	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0020 - 0.0030 in/in	0.20 - 0.30 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.3 ft-lbs/in	69 J/m	D 256
unnotched 1/8 in (3.2 mm) section	6.5 ft-lbs/in	347 J/m	D 4812
Tensile Strength	19000 psi	131 MPa	D 638
Tensile Elongation	1.0 %	1.0 %	D 638
Tensile Modulus	2.00 x 10 ⁶ psi	13790 MPa	D 638
Flexural Strength	30000 psi	207 MPa	D 790
Flexural Modulus	1.80 x 10 ⁶ psi	12411 MPa	D 790

ELECTRICAL

Volume Resistivity	< 1E2 ohm.cm	< 1E2 ohm.cm	D 257
Surface Resistivity	1E3 - 1E5 ohm/sq	1E3 - 1E5 ohm/sq	D 257
Surface Resistance	1E2 - 1E4 ohm	1E2 - 1E4 ohm	ESD STM11.11
Static Decay	< 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 %