Product Data Sheet &
General Processing Conditions

RTP 1399 X 115071 D
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	1.60	1.60	D 792
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0020 - 0.0030 in/in	0.20 - 0.30 %	D 955
MECHANICAL			
Tensile Strength	17000 psi	117 MPa	D 638
Tensile Elongation	0.8 %	0.8 %	D 638
Tensile Modulus	2.00 x 10^6 psi	13790 MPa	D 638
Flexural Strength	27000 psi	186 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 - 1E4 ohm/sq	1E3 - 1E4 ohm/sq	D 257
Surface Resistance	1E2 - 1E3 ohm	1E2 - 1E3 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 %