



**Product Data Sheet &
General Processing Conditions**

**RTP 1399 X 128625
Polyphenylene Sulfide (PPS)
Thermally Conductive
Electrically Insulative**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
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Specific Gravity	1.78	1.78	D 792
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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	19000 psi	131 MPa	D 638
Tensile Elongation	1.0 %	1.0 %	D 638
Tensile Modulus	2.85 x 10 ⁶ psi	19651 MPa	D 638
Flexural Strength	28000 psi	193 MPa	D 790
Flexural Modulus	2.75 x 10 ⁶ psi	18961 MPa	D 790

ELECTRICAL

Surface Resistivity	> 1E12 ohm/sq	> 1E12 ohm/sq	D 257
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THERMAL

Deflection Temperature			
@ 264 psi (1820 kPa)	520 °F	271 °C	D 648
Ignition Resistance*			
Flammability**	V-0 @ 1/16 in	V-0 @ 1.5 mm	D 3801
Thermal Conductivity			
Through-plane	6.25 (BTU.in)/(hr.ft ² .°F)	0.90 W/(m.K)	E 1530
In-plane	17.36 (BTU.in)/(hr.ft ² .°F)	2.50 W/(m.K)	E 1461-92

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

	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 %