



**Product Data Sheet &
General Processing Conditions**

**RTP 1399 X 128637 B
Polyphenylene Sulfide (PPS)
Thermally Conductive
Electrically Conductive**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
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Specific Gravity	1.63	1.63	D 792
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MECHANICAL

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	0.5 ft-lbs/in	27 J/m	D 256
unnotched 1/8 in (3.2 mm) section	1.5 ft-lbs/in	80 J/m	D 4812
Tensile Strength	6500 psi	45 MPa	D 638
Tensile Elongation	< 1.0 %	< 1.0 %	D 638
Tensile Modulus	1.75 x 10 ⁶ psi	12066 MPa	D 638
Flexural Strength	10500 psi	72 MPa	D 790
Flexural Modulus	1.75 x 10 ⁶ psi	12066 MPa	D 790

ELECTRICAL

Volume Resistivity	< 1E2 ohm.cm	< 1E2 ohm.cm	D 257
Surface Resistivity	< 1E4 ohm/sq	< 1E4 ohm/sq	D 257

THERMAL

Deflection Temperature			
@ 264 psi (1820 kPa)	460 °F	238 °C	D 648
Ignition Resistance*			
Flammability**	V-0 @ 1/16 in	V-0 @ 1.5 mm	D 3801
Thermal Conductivity			
Through-plane	20.83 (BTU.in)/(hr.ft ² .°F)	3.00 W/(m.K)	E 1530
In-plane	152.77 (BTU.in)/(hr.ft ² .°F)	22.01 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 %