



**Product Data Sheet &
General Processing Conditions**

**RTP 1399 X 128638
Polyphenylene Sulfide (PPS)
Thermally Conductive
Electrically Insulative**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.80	1.80	D 792
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	10000 psi	69 MPa	D 638
Tensile Elongation	< 1.0 %	< 1.0 %	D 638
Tensile Modulus	4.00 x 10 ⁶ psi	27580 MPa	D 638
Flexural Strength	16000 psi	110 MPa	D 790
Flexural Modulus	3.50 x 10 ⁶ psi	24132 MPa	D 790
ELECTRICAL			
Dielectric Strength, S/T, in oil	394 VPM	15.5 kV/mm	D 149
Surface Resistivity	> 1E14 ohm/sq	> 1E14 ohm/sq	D 257
THERMAL			
Ignition Resistance*			
Flammability**	V-0 @ 1/16 in	V-0 @ 1.5 mm	D 3801
Thermal Conductivity			
Through-plane	6.94 (BTU.in)/(hr.ft ² .°F)	1.00 W/(m.K)	E 1530
In-plane	41.66 (BTU.in)/(hr.ft ² .°F)	6.00 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 %