

# RTP 1302 TFE 20

Polyphenylene Sulfide

RTP Company

Message:

Warning: The status of this material is 'Commercial: Limited Issue'  
The data for this material has not been recently verified.  
Please contact RTP Company for current information prior to specifying this grade.  
-Preliminary Product Data per RTP Co.-

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Additive	PTFE lubricant (20%)		
Features	Lubrication		
RoHS Compliance	Contact manufacturer		
Appearance	Black		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.60	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.50	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.020	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8270	MPa	ASTM D638
Tensile Strength	55.2	MPa	ASTM D638
Tensile Elongation (Break)	1.0	%	ASTM D638
Flexural Modulus	6890	MPa	ASTM D790
Flexural Strength	89.6	MPa	ASTM D790
Compressive Strength	62.1	MPa	ASTM D695
Coefficient of Friction			ASTM D1894
With Metal-Dynamic	0.12		ASTM D1894
With metal-static	0.10		ASTM D1894
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	53	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	160	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	260	°C	ASTM D648

1.8 MPa, not annealed	232	°C	ASTM D648
CLTE - Flow	3.2E-5	cm/cm/°C	ASTM D696
Thermal Conductivity	0.30	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength	14	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	3.40		ASTM D150
Dissipation Factor (1 MHz)	1.0E-3		ASTM D150
Flammability	Nominal Value	Unit	Test Method
Flame Rating	V-0		UL 94

#### Additional Information

Mold Shrinkage, Linear-Flow, ASTM D-955, 0.25in.: 7mil/in.Wear Factor, K, ASTM D-3702: 95E-10in<sup>3</sup>/min/ft/lb/hrCoefficient of Friction, Dynamic, ASTM D-3702: 0.12Coefficient of Friction, Static, ASTM D-3702: 0.10The wear factor and coefficient of friction were both tested on a Falex Model No.6 Wear Testing Machine at 50 FPM, 2000 PV, against C1018 steel of hardness 15-25 Rockwell C, 14-17 micro smoothness.

Injection	Nominal Value	Unit
Drying Temperature	149	°C
Drying Time	6.0	hr
Suggested Max Moisture	0.040	%
Suggested Max Regrind	20	%
Rear Temperature	302 - 343	°C
Middle Temperature	302 - 343	°C
Front Temperature	302 - 343	°C
Mold Temperature	149 - 177	°C
Injection Pressure	103 - 138	MPa
Clamp Tonnage	6.9 - 11	kN/cm <sup>2</sup>

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#### Recommended distributors for this material

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