

# RTP 1309 UP

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."

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 50% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.77	g/cm <sup>3</sup>	ISO 1183
Moisture Content	0.040	%	
Primary Additive	50	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (Injection Molded)	20000	MPa	ISO 527-2
Tensile Stress	195	MPa	ISO 527-2
Tensile Strain (Yield, Injection Molded)	1.5	%	ISO 527-2
Flexural Modulus (Injection Molded)	18500	MPa	ISO 178
Flexural Stress (Injection Molded)	295	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact <sup>1</sup> (Injection Molded)	10	kJ/m <sup>2</sup>	ISO 180/1A
Unnotched Izod Impact Strength <sup>2</sup> (Injection Molded)	60	kJ/m <sup>2</sup>	ISO 180/1U
Additional Information	Nominal Value	Unit	
Data listed is for natural or black colored materials. Pigments can affect properties.			
Injection	Nominal Value	Unit	
Drying Temperature	150	°C	
Drying Time	6.0	hr	
Dew Point	-25.0	°C	
Processing (Melt) Temp	305 - 330	°C	
Mold Temperature	135 - 175	°C	
Injection Pressure	70.0 - 105	MPa	
NOTE			
1.	4mm thickness		
2.	4mm thickness		

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