RTP 1390

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	Carbon fiber reinforced material, 55% filler by weight		
Features	Good wear resistance		
	Heat resistance, high		
	Flame retardancy		
RoHS Compliance	Contact manufacturer		
Appearance	Black		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.54	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.050	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.020	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	123		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	46200	MPa	ASTM D638
Tensile Strength (Yield)	98.6	MPa	ASTM D638
Tensile Elongation (Yield)	0.50	%	ASTM D638
Flexural Modulus	38600	MPa	ASTM D790
Flexural Strength	221	MPa	ASTM D790
Compressive Strength	190	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	43	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	130	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	260	°C	ASTM D648

CLTE - Flow	1.3E-5	cm/cm/°C	ASTM D696
Thermal Conductivity	0.61	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+5	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.59 mm)	V-0		UL 94
Additional Information			

Mold Shrinkage, Linear-Flow, ASTM D-955, 0.25in.: 1mil/in.The value listed as flammability, UL 94, was tested in accordance with RTP test standards.RTP 1380 Series materials are carbon fiber polyphenylene sulfide materials. They are characterized by excellent physical properties, high moduli, heat resistance and are inherently flame retardant.

Injection	Nominal Value	Unit
Drying Temperature	149	°C
Drying Time	6.0	hr
Suggested Max Moisture	0.040	%
Suggested Max Regrind	20	%
Rear Temperature	285 - 343	°C
Middle Temperature	285 - 343	°C
Front Temperature	285 - 343	°C
Mold Temperature	65.6 - 177	℃
Injection Pressure	68.9 - 103	MPa
Back Pressure	0.345 - 0.689	MPa
Screw Speed	60 - 90	rpm
Clamp Tonnage	6.9 - 11	kN/cm²

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