

RTP 1387 TFE 5

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, 40% filler by weight		
Additive	PTFE lubricant (5%)		
Features	Lubrication		
RoHS Compliance	Contact manufacturer		
Appearance	Black		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.50	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.070	%	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	34500	MPa	ASTM D638
Tensile Strength	159	MPa	ASTM D638
Tensile Elongation (Yield)	0.50	%	ASTM D638
Flexural Modulus	24100	MPa	ASTM D790
Flexural Strength	241	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	53	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	270	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
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.Tensile Elongation, ASTM D-638: 0-1%The value listed as flammability, UL 94, was tested in accordance with RTP test standards.		
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	°C
Injection Pressure	68.9 - 103	MPa
Clamp Tonnage	6.9 - 11	kN/cm ²

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