



**Product Data Sheet &
General Processing Conditions**

**RTP 1399 X 137162 L
Polyphenylene Sulfide (PPS)
Thermally Conductive
Electrically Conductive**



PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.70	1.70	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	8600 psi	59 MPa	D 638
Tensile Elongation	< 1.0 %	< 1.0 %	D 638
Tensile Modulus	2.10 x 10 ⁶ psi	14480 MPa	D 638
Flexural Strength	13500 psi	93 MPa	D 790
Flexural Modulus	2.30 x 10 ⁶ psi	15858 MPa	D 790

ELECTRICAL

Volume Resistivity	< 1E4 ohm.cm	< 1E4 ohm.cm	D 257
Surface Resistivity	< 1E6 ohm/sq	< 1E6 ohm/sq	D 257

THERMAL

Deflection Temperature			
@ 264 psi (1820 kPa)	> 450 °F	> 232 °C	D 648
Ignition Resistance*			
Flammability	V-0 @ 1/16 in	V-0 @ 1.5 mm	UL94
Thermal Conductivity			
Through-plane	13.88 (BTU.in)/(hr.ft ² .°F)	2.00 W/(m.K)	E 1530
In-plane	138.88 (BTU.in)/(hr.ft ² .°F)	20.01 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.

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	300 - 375 °F	149 - 191 °C
Drying	6 hrs @ 300 °F	6 hrs @ 149 °C
Moisture Content	0.04 %	0.04 %