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**Product Data Sheet &
General Processing Conditions**

**ESD C 1380
Polyphenylene Sulfide (PPS)
Carbon Fiber
ESD Protection
Electrically Conductive**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.53	1.53	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0001 - 0.0015 in/in	0.01 - 0.15 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.9 ft-lbs/in	48 J/m	D 256
unnotched 1/8 in (3.2 mm) section	4.5 ft-lbs/in	240 J/m	D 4812
Tensile Strength	22500 psi	155 MPa	D 638
Tensile Elongation	1.0 - 2.0 %	1.0 - 2.0 %	D 638
Tensile Modulus	2.50 x 10 ⁶ psi	17238 MPa	D 638
Flexural Strength	30000 psi	207 MPa	D 790
Flexural Modulus	2.40 x 10 ⁶ psi	16548 MPa	D 790

ELECTRICAL

Volume Resistivity	< 1E3 ohm.cm	< 1E3 ohm.cm	D 257
Surface Resistivity	< 1E6 ohm/sq	< 1E6 ohm/sq	D 257
Surface Resistance	< 1E5 ohm	< 1E5 ohm	ESD STM11.11
Static Decay MIL-PRF-81705D, 5kV to 50 V, 12% RH	< 2.00 s	< 2.00 s	FTMS101C 4046.1

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.

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	275 - 350 °F	135 - 177 °C
Drying	6 hrs @ 300 °F	6 hrs @ 149 °C
Moisture Content	0.04 %	0.04 %