



Product Data Sheet & General Processing Conditions

RTP 1385 Polyphenylene Sulfide (PPS) Carbon Fiber

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	STANDARD
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Primary Additive	30 %	
Density	1.45 g/cm ³	ISO 1183
Water Absorption, 24 hrs @ 23°C	0.10 %	ISO 62

MECHANICAL

Impact Strength, Izod		
Notched, 4 mm thickness	5 kJ/m ²	ISO 180/1A
Unnotched, 4 mm thickness	17 kJ/m ²	ISO 180/1U
Tensile Strength	200 MPa	ISO 527
Tensile Elongation	0.5 - 1.0 %	ISO 527
Tensile Modulus	29000 MPa	ISO 527
Flexural Strength	270 MPa	ISO 178
Flexural Modulus	21000 MPa	ISO 178

ELECTRICAL

Volume Resistivity	< 1E3 ohm.cm	IEC 60093
Surface Resistivity	< 1E5 ohm	IEC 60093

THERMAL

Heat Deflection Temperature		
@ 1.80 MPa	268 °C	ISO 75
Ignition Resistance*		
Flammability**	V-0 @ 1.5 mm	ISO 1210

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.

** Values per RTP Company testing.

GENERAL PROCESSING FOR INJECTION MOLDING
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Injection Pressure	70 - 105 MPa
Injection Pressure	680 - 1030 bar
Melt Temperature	305 - 330 °C
Mold Temperature	135 - 175 °C
Drying	6 hrs @ 150 °C
Moisture Content	0.04 %
Dew Point	-25 °C

PROCESSING NOTES

This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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