

RTP 1387 D TFE 10

Polyphenylene Sulfide

RTP Company

Message:

Carbon Fiber - PTFE Lubricated - Preliminary Data

General Information			
Filler / Reinforcement	Carbon Fiber,40% Filler by Weight		
Additive	PTFE Lubricant (10%)		
Features	Lubricated		
RoHS Compliance	Contact Manufacturer		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.57	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.050 to 0.10	%	ASTM D955
Moisture Content	0.040	%	
Primary Additive	40	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	34500	MPa	ASTM D638
Tensile Strength	172	MPa	ASTM D638
Tensile Elongation (Yield)	0.50 to 1.5	%	ASTM D638
Flexural Modulus	27600	MPa	ASTM D790
Flexural Strength	262	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	64	J/m	ASTM D256
Unnotched Izod Impact (3.20 mm)	320	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	260	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	< 1.0E+3	ohms · cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm, ** Values per RTP Company testing.)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	149	°C	
Drying Time	6.0	hr	
Processing (Melt) Temp	307 to 329	°C	
Mold Temperature	135 to 177	°C	
Injection Pressure	68.9 to 103	MPa	

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