

# INLUBE PPSTF18SI2

Polyphenylene Sulfide  
Infinity LTL Engineered Compounds

Message:  
18% PTFE/2% SILICONE LUBRICATED POLYPHPHENYLENE SULFIDE

General Information			
Additive	PTFE Lubricant (18%)		
	Silicone Lubricant (2%)		
Features	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.1 to 1.5	%	ASTM D955
Water Absorption (Equilibrium)	0.040	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	62.1	MPa	ASTM D638
Tensile Elongation (Break)	3.0 to 5.0	%	ASTM D638
Flexural Modulus	3100	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	43	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	105	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	149	°C	
Drying Time	4.0	hr	
Processing (Melt) Temp	316 to 332	°C	
Mold Temperature	135 to 177	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	7.6E-3 to 0.013	mm	

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