

# China PPS hb-DL

Polyphenylene Sulfide

Sichuan Deyang Chemical Co., Ltd

## Message:

Low Chlorine type of PPS-hb. It is specially used in E/E industry which requires the chlorine content. PPS-hb is high rigidity crystalline polymer that offers high-temperature resistance, innoxious, flame resistance, radiation resistance, solvent resistance, electrical insulation, arc resistance, low water absorption, low mold shrinkage, good dimensional stability and radiation resistance. It's brittle. Therefore, it needs to be modified by some modifier. Owing to its high performance, it's widely used in medical, electronic/electric industry. Such as: rotproof sealed appliances, plugs, and contactors. It can be modified by different modifiers to make different PPS compounds.

General Information			
Features	Chlorine Free		
	Good dimensional stability		
	Rigidity, high		
	High crystallization		
	Insulation		
	Anti-arc		
	Anti-gamma radiation		
	Solvent resistance		
	Heat resistance, high		
	Low shrinkage		
	Non-toxic		
	Low or no water absorption		
	Flame retardancy		
Uses	Plug		
	Electrical/Electronic Applications		
	Home appliance components		
	Medical/nursing supplies		
Processing Method	Extrusion		
	Compression molding		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) <sup>1</sup> (315°C/5.0 kg)	< 100	g/10 min	Internal method
Water Absorption (Saturation)	< 0.50	%	Internal method
Chlorine Content		ppm	Internal method
Molecular weight-Weight Average <sup>2</sup>	> 300000		
Ash Content		%	Internal method
Compression Molding Temperature <sup>3</sup>	340 - 370	°C	

Injection	Nominal Value	Unit
Drying Temperature	100 - 105	°C
Drying Time	3.0	hr
Rear Temperature	220 - 260	°C
Middle Temperature	290 - 310	°C
Front Temperature	300 - 320	°C
Nozzle Temperature	290 - 300	°C
Processing (Melt) Temp	160 - 180	°C
Mold Temperature	60.0 - 80.0	°C
Injection Pressure	60.0 - 70.0	MPa
Injection Rate	Moderate	

#### Injection instructions

Processing time: 4 to 8hr

Extrusion	Nominal Value	Unit
Drying Temperature	100 - 105	°C
Drying Time	3.0	hr
Cylinder Zone 1 Temp.	160 - 200	°C
Cylinder Zone 2 Temp.	260 - 290	°C
Cylinder Zone 3 Temp.	280 - 300	°C
Adapter Temperature	265 - 275	°C

#### Extrusion instructions

Degree of vacuum: 0.09 Mpa

#### NOTE

1. 2.095 mm
2. Gel Chromatography  
Time: 10~15minPressure:  
7~10MpaHeat time:  
2~3hrDemoulding temperature:  
Natural cooling to normal  
temperature
- 3.

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