

INSTRUC PPSLGFMIN65

Polyphenylene Sulfide

Infinity LTL Engineered Compounds

Message:

65% GLASS FIBER/MINERAL REINFORCED, LINEAR POLYPHENYLE E SULFIDE

General Information			
Filler / Reinforcement	Glass\Mineral,65% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	2.00	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.10 to 0.30	%	ASTM D955
Water Absorption (Equilibrium)	0.020	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	131	MPa	ASTM D638
Tensile Elongation (Break)	1.0 to 3.0	%	ASTM D638
Flexural Modulus	19300	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	59	J/m	ASTM D256
Unnotched Izod Impact	240	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	266	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	149	°C	
Drying Time	4.0	hr	
Processing (Melt) Temp	321 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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Recommended distributors for this material

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