

Latigray 80-03 CWG/850

Polyphenylene Sulfide

LATI S.p.A.

Message:

Radiopaque compound based on Polyphenylene Sulphide (PPS). Metallic filler. Glass fibres.

General Information			
Filler / Reinforcement	Glass Fiber		
	Metallic		
Features	Radiopaque		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	5.38	g/cm ³	ISO 1183
Molding Shrinkage ¹			ISO 294-4
Across Flow : 2.00 mm	0.60 to 0.90	%	
Flow : 2.00 mm	0.40 to 0.60	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	14000	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	85.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	1.1	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ² (23°C)	5.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ³ (23°C)	15	kJ/m ²	ISO 179/1eU
Notched Izod Impact ⁴ (23°C)	50	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	275	°C	ISO 75-2/B
1.8 MPa, Unannealed	250	°C	ISO 75-2/A
Vicat Softening Temperature	255	°C	ISO 306/B50
Additional Information	Nominal Value	Unit	Test Method
Half Value Thickness			Internal Method
-- ⁵	680.0	µm	
-- ⁶	520.0	µm	
Injection	Nominal Value	Unit	
Drying Temperature	130 to 140	°C	
Drying Time	3.0	hr	
Processing (Melt) Temp	290 to 310	°C	
Mold Temperature	130 to 140	°C	

Injection Rate	Moderate-Fast
NOTE	
1.	at 60 Mpa of cavity pressure
2.	80x10x4 mm
3.	80x10x4 mm
4.	63.5x12.7x3.2 mm
5.	120 kV
6.	80 kV

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