

Starglas OC004

Polyphenylene Sulfide

Eurostar Engineering Plastics

Message:

Starglas OC004 is a 20 % Carbon Fiber Reinforced PPS Injection Molding Resin

General Information			
Filler / Reinforcement	Carbon Fiber,20% Filler by Weight		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.39	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.15	%	Internal Method
Water Absorption (23°C, 24 hr)	0.040	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	16600	MPa	ISO 527-2/1
Tensile Stress (Break)	144	MPa	ISO 527-2/5
Tensile Strain (Break)	1.1	%	ISO 527-2/5
Flexural Modulus ¹	15100	MPa	ISO 178
Flexural Stress ²			ISO 178
-- ³	194	MPa	
-- ⁴	193	MPa	
Flexural Strain at Break ⁵	1.5	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁶ (23°C)	5.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁷ (23°C)	25	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁸			
0.45 MPa, Unannealed, 64.0 mm Span	275	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	235	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	1.3E-5	cm/cm/°C	
Transverse : 23 to 60°C	5.5E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	10 to 1.0E+3	ohms	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	120 to 150	°C	
Drying Time	4.0	hr	
Rear Temperature	305 to 315	°C	
Middle Temperature	320 to 330	°C	

Front Temperature	330 to 345	°C
Processing (Melt) Temp	315 to 320	°C
Mold Temperature	140 to 165	°C

NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	
3.	Yield	
4.	Break	
5.	2.0 mm/min	
6.	80*10*4	
7.	80*10*4	
8.	80*10*4	

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