

# HiFill® PPS/F GF10

Polyphenylene Sulfide

Techmer Engineered Solutions

## Message:

HiFill® PPS/F GF10 is a Polyphenylene Sulfide (PPS) product filled with 10% glass fiber. It can be processed by injection molding and is available in North America. Primary characteristic: flame rated.

General Information			
Filler / Reinforcement	Glass Fiber, 10% Filler by Weight		
Appearance	Colors Available Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.50	%	ASTM D955
Water Absorption (24 hr)	0.020	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	124		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	75.8	MPa	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	5380	MPa	ASTM D790
Flexural Strength	112	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	277	°C	
1.8 MPa, Unannealed	238	°C	
CLTE - Flow	1.8E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms · cm	ASTM D257
Dielectric Strength <sup>1</sup>	15	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Injection	Nominal Value	Unit	Test Method
Drying Temperature	163	°C	
Drying Time	4.0	hr	

Rear Temperature	288 to 304	°C
Middle Temperature	316 to 343	°C
Front Temperature	310 to 332	°C
Nozzle Temperature	316 to 332	°C
Processing (Melt) Temp	324 to 338	°C
Mold Temperature	129 to 163	°C

#### NOTE

1. Method A (Short-Time)

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#### Recommended distributors for this material

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