

Zenite® SEA20N

Polyphenylene Sulfide
Celanese Corporation

Message:

ZENITE® SEA20N is a 40% mineral filled grade. It offers excellent surface appearance, low warpage, and excellent dimensional stability. Application for this grade is compact camera module, and other thin, small electronic parts

General Information			
Filler / Reinforcement	Mineral filler, 40% filler by weight		
Features	Good dimensional stability		
	Low warpage		
	Excellent appearance		
Uses	Electrical/Electronic Applications		
	Camera application		

Physical	Nominal Value	Unit	Test Method
Density	1.77	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow	0.76	%	ISO 294-4
Flow	0.25	%	ISO 294-4

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	105	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	4.2	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	10000	MPa	ISO 178
Flexural Stress (23°C)	126	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.5	kJ/m ²	ISO 179/1eA

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	220	°C	ISO 75-2/A
Melting Temperature ¹	330	°C	ISO 11357-3

Injection	Nominal Value	Unit
Drying Temperature	150	°C
Drying Time	6.0	hr
Rear Temperature	310 - 320	°C
Middle Temperature	320 - 330	°C
Front Temperature	330 - 350	°C
Nozzle Temperature	330 - 340	°C
Processing (Melt) Temp	335 - 345	°C

Mold Temperature	80 - 140	°C
Injection Pressure	50.0 - 150	MPa
Injection Rate	Moderate-Fast	
Holding Pressure	50.0 - 150	MPa

Injection instructions

Zone 4 Temperature: 330 to 350°C

NOTE

1. 10°C/min

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