

Edgetek™ SF-10CF/000 BK001

Polyphenylene Sulfide

PolyOne Corporation

Message:

Edgetek™SF-10CF/000 BK001 is a polyphenylene sulfide (PPS) product, which contains a 10% carbon fiber reinforced material. It can be processed by injection molding and is available in the Asia-Pacific region. The main characteristics are: flame retardant/rated flame.

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 10% filler by weight		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.38	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.20 - 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	100	MPa	ASTM D638
Flexural Modulus ²	8500	MPa	ASTM D790
Flexural Strength ³	155	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	40	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	230	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+3 - 1.0E+8	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	140 - 150	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	320 - 330	°C	
Middle Temperature	320 - 330	°C	
Front Temperature	320 - 330	°C	
Mold Temperature	140 - 160	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	5.0 mm/min		
2.	1.3 mm/min		
3.	1.3 mm/min		

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