

HiFill® PPS GF/M65 BK

Polyphenylene Sulfide

Techmer Engineered Solutions

Message:

HiFill® PPS GF/M65 BK is a Polyphenylene Sulfide (PPS) product filled with 65% glass\mineral. It can be processed by injection molding and is available in North America. Primary characteristic: flame rated.

General Information			
Filler / Reinforcement	Glass\Mineral,65% Filler by Weight		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.90	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.040	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	124	MPa	ASTM D638
Tensile Elongation (Break)	0.50	%	ASTM D638
Flexural Modulus	17900	MPa	ASTM D790
Flexural Strength	188	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	69	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	282	°C	
1.8 MPa, Unannealed	271	°C	
CLTE - Flow	2.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength ¹	22	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating	V-0		UL 94
Injection	Nominal Value	Unit	
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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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