

INSTRUC PPSBGF30

Polyphenylene Sulfide

Infinity LTL Engineered Compounds

Message:

30% GLASS FIBER REINFORCED BRANCHED POLYPHENYLENE SULFIDE

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.57	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 3.18 mm	0.20 to 0.40	%	
Across Flow : 3.18 mm	0.40 to 0.70	%	
Water Absorption (Equilibrium)	0.030	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	13100	MPa	ASTM D638
Tensile Strength (Break)	131	MPa	ASTM D638
Tensile Elongation (Break)	1.0 to 3.0	%	ASTM D638
Flexural Modulus	11000	MPa	ASTM D790
Flexural Strength	172	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	69	J/m	ASTM D256
Unnotched Izod Impact	430	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	260	°C	ASTM D648
CLTE - Flow	2.3E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	149	°C	
Drying Time	4.0	hr	
Processing (Melt) Temp	321 to 332	°C	
Mold Temperature	135 to 177	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	7.6E-3 to 0.013	mm	

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