

# INELEC PPSCF30

Polyphenylene Sulfide

Infinity LTL Engineered Compounds

Message:

30% CARBON FIBER REINFORCED POLYPHENYLENE SULFIDE

| General Information                                     |                                   |                   |             |
|---------------------------------------------------------|-----------------------------------|-------------------|-------------|
| Filler / Reinforcement                                  | Carbon Fiber,30% Filler by Weight |                   |             |
| Processing Method                                       | Injection Molding                 |                   |             |
| Physical                                                | Nominal Value                     | Unit              | Test Method |
| Specific Gravity                                        | 1.45                              | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow (3.18 mm)                      | 0.10 to 0.20                      | %                 | ASTM D955   |
| Water Absorption (Equilibrium)                          | 0.040                             | %                 | ASTM D570   |
| Mechanical                                              | Nominal Value                     | Unit              | Test Method |
| Tensile Strength (Break)                                | 193                               | MPa               | ASTM D638   |
| Tensile Elongation (Break)                              | 1.0 to 2.0                        | %                 | ASTM D638   |
| Flexural Modulus                                        | 24100                             | MPa               | ASTM D790   |
| Impact                                                  | Nominal Value                     | Unit              | Test Method |
| Notched Izod Impact                                     | 69                                | J/m               | ASTM D256   |
| Unnotched Izod Impact                                   | 320 to 430                        | J/m               | ASTM D256   |
| Thermal                                                 | Nominal Value                     | Unit              | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed) | 268                               | °C                | ASTM D648   |
| Electrical                                              | Nominal Value                     | Unit              | Test Method |
| Surface Resistivity                                     | 1.0E+2 to 1.0E+4                  | ohms              | ASTM D257   |
| 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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