

LNP™ THERMOTUF™ OX96685 compound

Polyphenylene Sulfide

SABIC Innovative Plastics

Message:

LNP* THERMOTUF* OX96685 is a compound based on PPS resin containing proprietary fillers. Added feature of this grade is: Impact Modified.

Also known as: LNP* THERMOTUF* Compound PDX-O-96685

Product reorder name: OX96685

General Information			
Filler / Reinforcement	Proprietary packing		
Additive	Impact modifier		
Features	Impact modification		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow: 24 hours	0.95	%	ASTM D955
Transverse flow: 24 hours	0.82	%	ASTM D955
Water Absorption			
24 hr, 50% RH	0.030	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.050	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6180	MPa	ASTM D638
--	6110	MPa	ISO 527-2/1
Tensile Strength			
Fracture ²	94.0	MPa	ASTM D638
Fracture	92.0	MPa	ISO 527-2/5
Tensile Strain			
Yield	2.6	%	ISO 527-2/5
Fracture ³	2.6	%	ASTM D638
Fracture	2.7	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁴	5290	MPa	ASTM D790
-- ⁵	5360	MPa	ISO 178
Flexural Stress			
--	133	MPa	ISO 178
Yield, 50.0mm span ⁶	134	MPa	ASTM D790
Fracture, 50.0mm span ⁷	131	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			

23°C	110	J/m	ASTM D256
23°C ⁸	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	550	J/m	ASTM D4812
23°C ⁹	33	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	17.6	J	ASTM D3763
--	4.36	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	269	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ¹⁰	263	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	203	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹¹	174	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ASTM D696
Flow: -30 to 30°C	4.2E-5	cm/cm/°C	ASTM D696
Lateral: -30 to 30°C	6.9E-5	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	121 - 149	°C	
Drying Time	4.0	hr	
Rear Temperature	304 - 316	°C	
Middle Temperature	321 - 332	°C	
Front Temperature	332 - 343	°C	
Processing (Melt) Temp	316 - 321	°C	
Mold Temperature	138 - 166	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	1.3 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		
11.	80*10*4 mm		

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