

TES J-1305/40

Polyphenylene Sulfide
Techmer Engineered Solutions

Message:

Molding Parameters:
The dry temperature at 16 hours is 250°F.
For 2-zone machines, the rear temperature is 600-640°F, and the front temperature is 580-600°F.

General Information			
Filler / Reinforcement	Glass Fiber,40% Filler by Weight		
Features	Chemically Coupled		
	Flame Retardant		
	High Strength		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.68	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.10	%	ASTM D955
Water Absorption (24 hr)	0.020	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	93		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	15200	MPa	ASTM D638
Tensile Strength (Yield)	165	MPa	ASTM D638
Tensile Elongation (Yield)	1.3	%	ASTM D638
Flexural Modulus	14500	MPa	ASTM D790
Flexural Strength (Yield)	231	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	91	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	260	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	163	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
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

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