

Edgetek™ SF-30GF/15T NATURAL

Polyphenylene Sulfide

PolyOne Corporation

Message:

30% Glass Fiber Reinforced and 15% PTFE Lubricated PPS Compounds

General Information			
UL YellowCard	E76261-101440205		
Filler / Reinforcement	PTFE ultra fine powder, 15% packing by weight Glass fiber reinforced material, 30% filler by weight		
Appearance	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.68	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.10 - 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11000	MPa	ASTM D638
Tensile Strength	135	MPa	ASTM D638
Flexural Modulus	11000	MPa	ASTM D790
Flexural Strength	175	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	260	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
0.75 mm	V-0		UL 94
1.5 mm	V-0		UL 94
3.0 mm	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	140 - 150	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	320 - 330	°C	
Middle Temperature	320 - 330	°C	
Front Temperature	320 - 330	°C	
Mold Temperature	140 - 160	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			

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