

TES J-1300/40

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		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.64	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.10 to 0.20	%	ASTM D955
Water Absorption (24 hr)	0.030	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	138	MPa	ASTM D638
Tensile Elongation (Yield)	3.3	%	ASTM D638
Flexural Modulus	13100	MPa	ASTM D790
Flexural Strength (Yield)	228	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.35 mm)	100	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	260	°C	ASTM D648
Flammability	Nominal Value	Test Method	
Flame Rating	V-0	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	163	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	293 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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