

Star L PPS D93F

Polyphenylene Sulfide
Eurostar Engineering Plastics

Message:

Star L PPS D93F is a PTFE / Aramide Lubricated, PPS Injection Molding Resin

General Information			
Additive	PTFE + Aramid Resin Lubricant		
Features	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.44	g/cm ³	ASTM D792
shrinkage-Flow (4.00 mm)	0.90 - 1.1	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	50.0	MPa	ISO 527-2
Tensile Strain (Break)	1.2	%	ISO 527-2
Flexural Modulus	4400	MPa	ISO 178
Flexural Stress	91.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	1.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	9.0	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ¹ (1.8 MPa, Unannealed, 64.0 mm Span)	120	°C	ISO 75-2/Af
Melting Temperature (DSC)	283	°C	ISO 3146
Injection	Nominal Value	Unit	
Drying Temperature	130	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	310 - 320	°C	
Middle Temperature	310 - 320	°C	
Front Temperature	310 - 320	°C	
Mold Temperature	135 - 165	°C	
Injection instructions			
Zone 4 Temperature: 310 to 320°C			
NOTE			
1.	80x10x4 mm		

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