

Susteel® G-10

Polyphenylene Sulfide

TOSOH Corporation

Message:

Glass fiber and mineral filled / Standard grade

General Information			
UL YellowCard	E102861-218099		
Filler / Reinforcement	Glass\Mineral		
Features	Good Toughness		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.94	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (315°C/5.0 kg)	90	g/10 min	ASTM D1238
Molding Shrinkage			Internal Method
Flow	0.30	%	
Across Flow	0.60	%	
Water Absorption (Equilibrium)	> 0.020	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	116	MPa	ASTM D638
Tensile Elongation (Break)	0.60	%	ASTM D638
Flexural Modulus	20000	MPa	ASTM D790
Flexural Strength	221	MPa	ASTM D790
Tensile Weld Strength	39.0	MPa	ASTM D638
Bar Flow Length (1.00 mm)	125	mm	Internal Method
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	64	J/m	ASTM D256
Unnotched Izod Impact	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	> 260	°C	ASTM D648
Melting Temperature	285	°C	Internal Method
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+18	ohms · cm	ASTM D257
Dielectric Strength	15	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.90		ASTM D150

Dissipation Factor (1 MHz)	1.5E-3		ASTM D150
Arc Resistance	150	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Flame Rating	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120 to 150	°C	
Drying Time	2.0 to 5.0	hr	
Rear Temperature	270 to 300	°C	
Middle Temperature	270 to 300	°C	
Nozzle Temperature	290 to 330	°C	
Mold Temperature	135 to 150	°C	
Injection Pressure	50.0 to 150	MPa	
Injection Rate	Moderate-Fast		
Back Pressure	1.00 to 20.0	MPa	
Screw Speed	100 to 150	rpm	

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