

NEMCON H PPS DP183

Polyphenylene Sulfide
Ovation Polymers Inc.

Message:
Thermally conductive Polyphenylene Sulfide

General Information			
Features	Thermally Conductive		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.72	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (23°C)	8520	MPa	ASTM D638
Tensile Strength ² (Break, 23°C)	110	MPa	ASTM D638
Tensile Elongation ³ (Break, 23°C)	3.0	%	ASTM D638
Flexural Modulus ⁴ (23°C, 50.0 mm Span)	9910	MPa	ASTM D790
Flexural Strength ⁵ (Break, 23°C, 50.0 mm Span)	175	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	78	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Thermal Conductivity	Internal Method		
23°C ⁶	0.50 to 1.0	W/m/K	
23°C ⁷	5.0 to 8.0	W/m/K	
Injection	Nominal Value	Unit	
Drying Temperature	120 to 140	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	270 to 290	°C	
Middle Temperature	280 to 300	°C	
Front Temperature	290 to 310	°C	
Nozzle Temperature	300 to 320	°C	
Processing (Melt) Temp	290 to 320	°C	
Mold Temperature	125 to 150	°C	
Back Pressure	0.207 to 0.414	MPa	
Screw Speed	80 to 120	rpm	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	50 mm/min		

4.	1.3 mm/min
5.	1.3 mm/min
6.	Through Plane
7.	In Plane

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