

HiFill® J-1300/40

Techmer Polymer Modifiers - Polyphenylene Sulfide

Product Description

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

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight
RoHS Compliance	• RoHS Compliant
Forms	• Pellets

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.64		ASTM D792
Molding Shrinkage - Flow	1.0E-3 to 2.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.030	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	20000	psi	ASTM D638
Tensile Elongation (Yield)	3.3	%	ASTM D638
Flexural Modulus	1.90E+6	psi	ASTM D790
Flexural Strength (Yield)	33000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.250 in)	1.9	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	500	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	325	°F
Drying Time	4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	560 to 580	°F
Middle Temperature	600 to 650	°F
Front Temperature	590 to 630	°F
Nozzle Temperature	600 to 630	°F
Processing (Melt) Temp	615 to 640	°F
Mold Temperature	265 to 325	°F

