

## TES J-1305/40

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<br>• Asia Pacific • Latin America |
| Filler / Reinforcement | • Glass Fiber, 40% Filler by Weight   |
| Features               | • Chemically Coupled • Flame Retardant • High Strength                            |
| RoHS Compliance        | • RoHS Compliant  |
| Forms                  | • Pellets   |
| Processing Method      | • Injection Molding   |

### Properties <sup>1</sup>

| Physical  | Nominal Value | Unit              | Test Method |
|---|---------------|-------------------|-------------|
| Density / Specific Gravity                              | 1.68          | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow                                | 0.10          | %                 | ASTM D955   |
| Water Absorption (24 hr)                                | 0.020         | %                 | ASTM D570   |
| Mechanical  | Nominal Value | Unit              | Test Method |
| Tensile Modulus   | 15200         | MPa               | ASTM D638   |
| Tensile Strength (Yield)                                | 165           | MPa               | ASTM D638   |
| Tensile Elongation (Yield)                              | 1.3           | %                 | ASTM D638   |
| Flexural Modulus  | 14500         | MPa               | ASTM D790   |
| Flexural Strength (Yield)                               | 231           | MPa               | ASTM D790   |
| Impact  | Nominal Value | Unit              | Test Method |
| Notched Izod Impact (23°C, 3.18 mm)                     | 91            | J/m               | ASTM D256   |
| Hardness  | Nominal Value | Unit              | Test Method |
| Rockwell Hardness (M-Scale)                             | 93            |                   | ASTM D785   |
| Thermal   | Nominal Value | Unit              | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed) | 260           | °C                | ASTM D648   |

### Processing Information

| Injection              | Nominal Value | Unit |
|------------------------|---------------|------|
| Drying Temperature     | 163           | °C   |
| Drying Time            | 4.0           | hr   |
| Suggested Max Moisture | 0.020         | %    |
| Rear Temperature       | 288 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   |

