

HiFill® PPS/F GF40 L WT319

Techmer Polymer Modifiers - Polyphenylene Sulfide

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Appearance	• White
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.71		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3 to 6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.30E+6	psi	ASTM D638
Tensile Strength (Yield)	18000	psi	ASTM D638
Tensile Strength (Break)	18000	psi	ASTM D638
Tensile Elongation (Break)	1.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	275	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	580 to 610	°F
Middle Temperature	590 to 620	°F
Front Temperature	600 to 630	°F
Nozzle Temperature	610 to 640	°F
Processing (Melt) Temp	585 to 645	°F
Mold Temperature	250 to 325	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Moderate	

