

Magnablend® PPS/F 0328

Techmer Polymer Modifiers - *Polyphenylene Sulfide*

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Lubricant • Strontium Ferrite
Features	• Lubricated
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	3.28		ASTM D792
Molding Shrinkage - Flow	0.010	in/in	ASTM D955
Water Absorption (24 hr)	0.20	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7000	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	1.90E+6	psi	ASTM D790
Flexural Strength	12300	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.50	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	3.5	ft·lb/in	ASTM D4812
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	400	°F	ASTM D648
CLTE - Flow	1.8E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+10	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.016 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	325	°F
Drying Time	4.0	hr
Rear Temperature	550 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

