



Plaslube® PPS/F CF30 TL15 BK

Techmer Polymer Modifiers - Polyphenylene Sulfide

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber, 30% Filler by Weight
Additive	• PTFE Lubricant
Features	• Low Friction • Lubricated • Wear Resistant
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.57		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.030	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	23000	psi	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	2.05E+6	psi	ASTM D790
Flexural Strength	25200	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.14		
vs. Steel - Static	0.11		
Wear Factor	70	10 ⁻¹⁰ in ³ ·min/ft·lb·hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	0.60	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	3.8	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	500	°F	ASTM D648
CLTE - Flow	8.0E-6	in/in/°F	ASTM D696
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 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

