

HiFill® PPS/I GF40 TL15 BK001

Techmer Polymer Modifiers - *Polyphenylene Sulfide*

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight
Additive	• Lubricant
Features	• Lubricated
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.77		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3 to 4.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.20E+6	psi	ASTM D638
Tensile Strength (Yield)	19500	psi	ASTM D638
Tensile Strength (Break)	19000	psi	ASTM D638
Tensile Elongation (Break)	1.2	%	ASTM D638
Flexural Modulus	1.95E+6	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.2	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	300	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	570 to 610	°F
Middle Temperature	580 to 630	°F
Front Temperature	590 to 640	°F
Nozzle Temperature	600 to 645	°F
Processing (Melt) Temp	575 to 640	°F
Mold Temperature	230 to 325	°F
Injection Rate	Slow	
Back Pressure	0.00 to 100	psi
Screw Speed	Slow	

