

**Electrafil® J-1305/CF/40 NATL**

 Techmer Polymer Modifiers - *Polyphenylene Sulfide*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.49		ASTM D792
Molding Shrinkage - Flow			ASTM D955
24 hr	2.7E-3	in/in	
48 hr	3.3E-4	in/in	
Molding Shrinkage - Across Flow			ASTM D955
24 hr	4.7E-4	in/in	
48 hr	5.3E-4	in/in	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5.50E+6	psi	ASTM D638
Tensile Strength (Yield)	21000	psi	ASTM D638
Tensile Elongation (Break)	0.50	%	ASTM D638
Flexural Modulus	500000	psi	ASTM D790
Flexural Strength	30000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.85	ft·lb/in	ASTM D256

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	1.0	hr
Rear Temperature	550 to 565	°F
Middle Temperature	550 to 570	°F
Front Temperature	570 to 590	°F
Nozzle Temperature	570 to 590	°F
Processing (Melt) Temp	570 to 630	°F
Mold Temperature	190	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

