

**Electrafil® PPS GF23 IM BK**

 Techmer Polymer Modifiers - *Polyphenylene Sulfide*
**General Information**
**General**

Material Status	<ul style="list-style-type: none"> <li>Commercial: Active <sup>1</sup></li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Filler / Reinforcement	<ul style="list-style-type: none"> <li>Glass Fiber, 23% Filler by Weight</li> </ul>
Additive	<ul style="list-style-type: none"> <li>Impact Modifier</li> </ul>
Features	<ul style="list-style-type: none"> <li>Conductive</li> <li>High Impact Resistance</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Black</li> </ul>
Forms	<ul style="list-style-type: none"> <li>Pellets</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

**Properties <sup>2</sup>**

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.53		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.020	%	ASTM D570
<b>Mechanical</b>			
Tensile Strength (Break)	14000	psi	ASTM D638
Tensile Elongation (Break)	3.7	%	ASTM D638
Flexural Modulus	1.70E+6	psi	ASTM D790
Flexural Strength	19000	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (73°F, 0.125 in)	1.6	ft·lb/in	ASTM D256
<b>Hardness</b>			
Rockwell Hardness (R-Scale)	120		ASTM D785
<b>Thermal</b>			
Deflection Temperature Under Load (66 psi, Unannealed)	510	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	495	°F	ASTM D648
CLTE - Flow	1.1E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
Surface Resistivity	1.0E+3 to 1.0E+5	ohms	ASTM D257
Volume Resistivity	1.0E+3 to 1.0E+5	ohms·cm	ASTM D257
<b>Flammability</b>			
Flame Rating (0.016 in)	V-0		UL 94

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
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

**Notes**
<sup>1</sup> false product.

<sup>2</sup> Typical properties: these are not to be construed as specifications.
