

HiFill® PPS/F GF40

 Techmer Polymer Modifiers - *Polyphenylene Sulfide*
General Information
General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
RoHS Compliance	• RoHS Compliant
Appearance	• Colors Available
Forms	• Pellets

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.67		ASTM D792
Molding Shrinkage - Flow (0.125 in)	1.0E-3 to 2.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.020	%	ASTM D570
Mechanical			
Tensile Strength	23000	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	2.00E+6	psi	ASTM D790
Flexural Strength	32000	psi	ASTM D790
Impact			
Notched Izod Impact	1.6	ft·lb/in	ASTM D256
Flammability			
Flame Rating			UL 94
0.06 in	V-0		
0.13 in	V-0		

Processing Information

	Nominal Value	Unit
Injection		
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

