

HiFill® PPS/F GF/M35 X

 Techmer Polymer Modifiers - *Polyphenylene Sulfide*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber\Mineral, 35% Filler by Weight
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.62		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.030	%	ASTM D570
Mechanical			
Tensile Strength (Yield)	18000	psi	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	1.55E+6	psi	ASTM D790
Flexural Strength (Yield)	26000	psi	ASTM D790
Impact			
Notched Izod Impact (0.125 in)	1.4	ft-lb/in	ASTM D256
Hardness			
Rockwell Hardness (R-Scale)	100		ASTM D785
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	540	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	500	°F	ASTM D648
CLTE - Flow	1.1E-5	in/in/°F	ASTM D696
Electrical			
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	560	V/mil	ASTM D149
Flammability			
Flame Rating	V-0		UL 94

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

