

**InLube® PPSTF20**
*Americhem - Polyphenylene Sulfide*
**General Information**
**Product Description**

20% PTFE LUBRICATED POLYPHENYLENE SULFIDE

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• PTFE Lubricant: 20%		
Features	• Branched Polymer Structure • Chemical Resistant	• Good Mold Release • Low Friction	• Lubricated • Wear Resistant
Uses	• Aerospace Applications • Connectors • Consumer Applications • Electrical/Electronic Applications	• Engineering Parts • Industrial Applications • Industrial Parts • Metal Replacement	• Military/Defense Applications • Oil/Gas Applications • Outdoor Applications • Semiconductor Applications
Forms	• Pellets		
Processing Method	• Injection Molding		

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.46		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.011 to 0.015	in/in	ASTM D955
Water Absorption (Equilibrium)	0.040	%	ASTM D570
<b>Mechanical</b>			
Tensile Strength (Break)	9000	psi	ASTM D638
Tensile Elongation (Break)	3.0 to 5.0	%	ASTM D638
Flexural Modulus	450000	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact	0.80	ft·lb/in	ASTM D256
<b>Thermal</b>			
Deflection Temperature Under Load (264 psi, Unannealed)	221	°F	ASTM D648

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	300	°F
Drying Time	4.0	hr
Processing (Melt) Temp	600 to 630	°F
Mold Temperature	275 to 350	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm
Vent Depth	3.0E-4 to 5.0E-4	in

