

HiFill® PPS 0334 A

 Techmer Polymer Modifiers - *Polyphenylene Sulfide*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Features	• High Density
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	3.44		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.020	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	13000	psi	ASTM D638
Tensile Elongation (Break)	1.0	%	ASTM D638
Flexural Modulus	1.80E+6	psi	ASTM D790
Flexural Strength	20000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	0.70	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	536	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	510	°F	ASTM D648
CLTE - Flow	9.0E-6	in/in/°F	ASTM D696
Thermal Conductivity	12	Btu-in/hr/ft ² /°F	ASTM C177
RTI Elec (0.06 in)	428	°F	UL 746B
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+4 to 1.0E+6	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.016 in		V-0	
0.04 in		5VA	

Processing Information

Injection	Nominal Value	Unit
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

