

**TES J-1305/40**

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

Molding Parameters:

The dry temperature at 16 hours is 250°F.

For 2-zone machines, the rear temperature is 600-640°F, and the front temperature is 580-600°F.

**General**

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight
Features	• Chemically Coupled • Flame Retardant • High Strength
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.68		ASTM D792
Molding Shrinkage - Flow	1.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.020	%	ASTM D570
<b>Mechanical</b>			
Tensile Modulus	2.20E+6	psi	ASTM D638
Tensile Strength (Yield)	24000	psi	ASTM D638
Tensile Elongation (Yield)	1.3	%	ASTM D638
Flexural Modulus	2.10E+6	psi	ASTM D790
Flexural Strength (Yield)	33500	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (73°F, 0.125 in)	1.7	ft-lb/in	ASTM D256
<b>Hardness</b>			
Rockwell Hardness (M-Scale)	93		ASTM D785
<b>Thermal</b>			
Deflection Temperature Under Load (264 psi, Unannealed)	500	°F	ASTM D648

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	325	°F
Drying Time	4.0	hr
Suggested Max Moisture	0.020	%
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

