

**Plaslube® PPS-1305/TF/20/NAT**

 Techmer Polymer Modifiers - *Polyphenylene Sulfide*
**General Information**
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Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Additive	• PTFE Lubricant: 20%
Features	• Lubricated • Wear Resistant
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.47		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7500	psi	ASTM D638
Tensile Elongation (Yield)	2.5	%	ASTM D638
Flexural Modulus	490000	psi	ASTM D790
Flexural Strength (Yield)	12000	psi	ASTM D790
Coefficient of Friction (vs. Steel - Static)	0.30		ASTM D1894
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	0.70	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	236	°F	ASTM D648

**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

