

**Plaslube® J-1305/30/TF/15**

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

<b>General</b>			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight		
Additive	• PTFE Lubricant: 15%		
Features	• Chemical Resistant	• High Strength	• Self Lubricating
	• Flame Retardant	• Lubricated	
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		
Processing Method	• Injection Molding		

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

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.65		ASTM D792
Molding Shrinkage - Flow	2.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.020	%	ASTM D570
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	1.60E+6	psi	ASTM D638
Tensile Strength (Yield)	19000	psi	ASTM D638
Tensile Elongation (Yield)	1.5	%	ASTM D638
Flexural Modulus	1.40E+6	psi	ASTM D790
Flexural Strength (Yield)	26000	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (73°F, 0.125 in)	1.3	ft·lb/in	ASTM D256
Unnotched Izod Impact (73°F, 0.125 in)	7.0	ft·lb/in	ASTM D4812
<b>Hardness</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Rockwell Hardness (M-Scale)	77		ASTM D785
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (66 psi, Unannealed)	525	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	500	°F	ASTM D648

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
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

