

Infino XP-2130A

Lotte Chemical Corporation - Polyphenylene Sulfide

General Information

General

| | |
|------------------------|--|
| Filler / Reinforcement | • Glass Fiber |
| Uses | • Automotive Applications • Connectors |

Properties¹

| Physical | Nominal Value | Unit | Test Method |
|--|-----------------|-----------------------|-------------|
| Density / Specific Gravity (Natural) | 1.65 | | ASTM D792 |
| Density (Natural) | 1.65 | g/cm ³ | ISO 1183 |
| Melt Mass-Flow Rate (MFR) (315°C/5.0 kg) | 115 | g/10 min | ASTM D1238 |
| Melt Mass-Flow Rate (MFR) (315°C/5.0 kg) | 115 | g/10 min | ISO 1133 |
| Molding Shrinkage - Flow (0.126 in) | 3.0E-3 to 0.012 | in/in | ASTM D955 |
| Molding Shrinkage - Across Flow (0.126 in) | 3.0E-3 to 0.012 | in/in | ASTM D955 |
| Molding Shrinkage | | | ISO 294-4 |
| Across Flow : 0.0787 in | 0.30 to 1.2 | % | |
| Flow : 0.0787 in | 0.30 to 1.2 | % | |
| Ash Content | | | |
| -- | 30 | % | ASTM D5630 |
| -- | 30 | % | ISO 3451 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus ² | 853000 | psi | ASTM D638 |
| Tensile Modulus | 1.16E+6 | psi | ISO 527-1/5 |
| Tensile Strength ² (Yield) | 19900 | psi | ASTM D638 |
| Tensile Stress (Yield) | 18600 | psi | ISO 527-2/5 |
| Tensile Strength ² (Break) | 18500 | psi | ASTM D638 |
| Tensile Stress (Break) | 16700 | psi | ISO 527-2/5 |
| Tensile Elongation ² (Break) | 3.0 | % | ASTM D638 |
| Tensile Strain (Break) | 3.0 | % | ISO 527-2/5 |
| Flexural Modulus ³ | 1.42E+6 | psi | ASTM D790 |
| Flexural Modulus ³ | 1.45E+6 | psi | ISO 178 |
| Flexural Strength ³ | 28400 | psi | ASTM D790 |
| Flexural Stress ³ | 27600 | psi | ISO 178 |
| Impact | Nominal Value | Unit | Test Method |
| Charpy Notched Impact Strength ⁴ (73°F) | 5.2 | ft·lb/in ² | ISO 179/1eA |
| Notched Izod Impact | | | ASTM D256 |
| 73°F, 0.125 in | 1.6 | ft·lb/in | |
| 73°F, 0.250 in | 1.5 | ft·lb/in | |
| Notched Izod Impact Strength ⁴ (73°F) | 5.2 | ft·lb/in ² | ISO 180/1A |
| Hardness | Nominal Value | Unit | Test Method |
| Rockwell Hardness (R-Scale) | 120 | | ASTM D785 |
| Rockwell Hardness (R-Scale) | 116 | | ISO 2039-2 |

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| Thermal | Nominal Value | Unit | Test Method |
|--|---------------|------|-------------|
| Deflection Temperature Under Load 66 psi, Unannealed, 0.252 in | 540 | °F | ASTM D648 |
| Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in | 552 | °F | ISO 75-2/B |
| Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in | 527 | °F | ASTM D648 |
| Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in | 527 | °F | ISO 75-2/A |
| Flammability | Nominal Value | Unit | Test Method |
| Flame Rating (0.030 in) | V-0 | | UL 94 |

Processing Information

| Injection | Nominal Value | Unit |
|------------------------|---------------|------|
| Drying Temperature | | |
| Desiccant Dryer | 248 | °F |
| Hot Air Dryer | 248 | °F |
| Drying Time | | |
| Desiccant Dryer | 2.0 to 4.0 | hr |
| Hot Air Dryer | 4.0 to 6.0 | hr |
| Suggested Max Moisture | < 0.050 | % |
| Rear Temperature | 536 to 554 | °F |
| Middle Temperature | 554 to 572 | °F |
| Front Temperature | 590 to 608 | °F |
| Nozzle Temperature | 608 | °F |
| Mold Temperature | 248 to 302 | °F |
| Injection Pressure | 7110 to 18500 | psi |
| Back Pressure | 71.1 to 284 | psi |
| Screw Speed | 50 to 150 | rpm |

Injection Notes

Hot Runner Temperature: 310°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 0.20 in/min

³ 0.11 in/min

⁴ 4mm