

Infino XP-2140C

Lotte Chemical Corporation - Polyphenylene Sulfide

General Information

General	
Filler / Reinforcement	• Glass Fiber
Uses	• Automotive Applications • Connectors

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.66		ASTM D792
Density (Natural)	1.66	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (316°C/5.0 kg)	55	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (316°C/5.0 kg)	83	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	2.7E-3 to 3.3E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	3.2E-3 to 3.9E-3	in/in	ASTM D955
Ash Content	40	%	ASTM D5630
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	996000	psi	ASTM D638
Tensile Modulus	1.65E+6	psi	ISO 527-1/5
Tensile Strength ² (Yield)	27000	psi	ASTM D638
Tensile Stress (Yield)	26100	psi	ISO 527-2/5
Tensile Strength ² (Break)	25600	psi	ASTM D638
Tensile Stress (Break)	26100	psi	ISO 527-2/5
Tensile Elongation ² (Break)	3.0	%	ASTM D638
Tensile Strain (Break)	2.7	%	ISO 527-2/5
Flexural Modulus ³	1.85E+6	psi	ASTM D790
Flexural Modulus ⁴	1.94E+6	psi	ISO 178
Flexural Strength ³	38400	psi	ASTM D790
Flexural Stress ⁴	37700	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	6.2	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	1.8	ft·lb/in	
73°F, 0.250 in	1.6	ft·lb/in	
Notched Izod Impact Strength ⁵ (73°F)	5.2	ft·lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Rockwell Hardness (R-Scale)	121		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	540	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	541	°F	

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Annealed, 0.157 in	541	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	518	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	513	°F	ISO 75-2/A
Deflection Temperature Under Load 264 psi, Annealed, 0.157 in	522	°F	ISO 75-2/A
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.04 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	248	°F
Hot Air Dryer	43	°F
Drying Time		
Desiccant Dryer	4.0	hr
Hot Air Dryer	120	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	554	°F
Middle Temperature	554 to 572	°F
Front Temperature	590 to 608	°F
Nozzle Temperature	626	°F
Mold Temperature	248 to 302	°F
Injection Pressure	7110 to 18500	psi
Back Pressure	142 to 284	psi
Screw Speed	30 to 70	rpm

Injection Notes

Hot Runner Temperature: 330°C

Notes

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

² 0.20 in/min

³ 0.11 in/min

⁴ 0.079 in/min

⁵ 4mm