

TECHNICAL DATA AND PROCESS SHEET

15% PTFE LUBRICATED POLYPHENYLENE SULFIDE

INLUBE PPSTF15

TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
PHYSICAL			
SPECIFIC GRAVITY	1.44	-	ASTM D792
WATER ABSORPTION	0.04	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	1.1-1.4	%	ASTM D955
MECHANICAL			
TENSILE STRENGTH, BRK	9,000	psi	ASTM D638
TENSILE ELONGATION	3-5%	%	ASTM D638
FLEXURAL MODULUS	450,000	psi	ASTM D790
IZOD IMPACT, NOTHCED	0.8	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	270	°F	ASTM D648
PROCESSING			
DRYING TEMPERATURE	250	°F	
DRYING TIME	4	hrs	
MELT TEMPERATURE	600-630	°F	
MOLD TEMPERATURE	275-350	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0003-0.0005	in	

3/7/11 DJV

<p>This information is based on our experience to date and we believe it to be reliable. It is intended only as a guide for use at your discretion and risk. We cannot guarantee favorable results and assume no liability in connection with its use of the products described. Each user bears full responsibility for making it's own determination as to the suitability of the product described. None of this information is to be taken as a license to operate under, or recommendation to infringe any patents</p>
