

## TECHNICAL DATA AND PROCESS SHEET

### 30% GLASS FIBER REINFORCED LINEAR POLYPHENYLENE SULFIDE

#### INSTRUC PPSLGF30

#### TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
<b>PHYSICAL</b>			
SPECIFIC GRAVITY	1.56	-	ASTM D792
WATER ABSORPTION	0.03	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.2-0.4	%	
MOLD SHRINKAGE, X-FLOW 0.125"	0.7-0.9	%	
<b>MECHANICAL</b>			
TENSILE MODULUS	1,800,000	psi	ASTM D638
TENSILE STRENGTH, BRK	20,300	psi	ASTM D638
TENSILE ELONGATION	1-3	%	ASTM D638
FLEXURAL MODULUS	1,600,000	psi	ASTM D790
FLEXURAL STRENGTH	25,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	1.9	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	9.0	ft-lb/in	ASTM D256
<b>THERMAL</b>			
HDTUL @ 66 PSI	530	°F	ASTM D648
HDTUL @ 264 PSI	500	°F	ASTM D648
CLTE – FLOW	$1.3 \times 10^{-5}$	in/in/°F	ASTM D696
FLAMMABILITY	V-0 @ 1.5mm		
<b>PROCESSING</b>			
DRYING TEMPERATURE	300	°F	
DRYING TIME	4	hrs	
MELT TEMPERATURE	610-630	°F	
MOLD TEMPERATURE	275-350	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0003-0.0005	in	

5/18/10 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>
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