

TECHNICAL DATA AND PROCESS SHEET

20% PTFE LUBRICATED POLYPHENYLENE SULFIDE

INLUBE PPSTF20

TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
PHYSICAL			
SPECIFIC GRAVITY	1.46	-	ASTM D792
WATER ABSORPTION	0.04	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	1.1-1.5	%	
MECHANICAL			
TENSILE STRENGTH, BRK	9,000	psi	ASTM D638
TENSILE ELONGATION	3-5%	%	ASTM D638
FLEXURAL MODULUS	450,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	0.8	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	221	°F	ASTM D648
PROCESSING			
DRYING TEMPERATURE	300	°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	

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