



## Edgetek™ SF-30GF/000 RS NC

### Polyphenylene Sulfide

#### Key Characteristics

Product Description	
30% Glass Fiber Reinforced PPS Compound	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

#### Technical Properties <sup>1</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.57	1.57	ASTM D792
Molding Shrinkage - Flow	3.0E-3 to 8.0E-3 in/in	0.30 to 0.80 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength <sup>2</sup>	21800 psi	150 MPa	ASTM D638
Tensile Elongation <sup>2</sup> (Break)	2.0 %	2.0 %	ASTM D638
Flexural Modulus <sup>3</sup>	1.67E+6 psi	11500 MPa	ASTM D790
Flexural Strength <sup>3</sup>	30500 psi	210 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm)	1.5 ft-lb/in	80 J/m	
Unnotched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm)	9.4 ft-lb/in	500 J/m	
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	509 °F	265 °C	
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	1.0E+15 ohms	1.0E+15 ohms	ASTM D257
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.031 in (0.8 mm))	V-0	V-0	Internal Method

#### Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	284 to 302 °F	140 to 150 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Rear Temperature	572 to 608 °F	300 to 320 °C
Middle Temperature	572 to 608 °F	300 to 320 °C
Front Temperature	572 to 608 °F	300 to 320 °C
Mold Temperature	284 to 320 °F	140 to 160 °C

Injection Notes

Injection Pressure: MED-HIGH  
Hold Pressure: MED-HIGH  
Screw Speed: MODERATE  
Back Pressure: LOW

Notes

<sup>1</sup> Typical values are not to be construed as specifications.

<sup>2</sup> 0.20 in/min (5.0 mm/min)

<sup>3</sup> 0.051 in/min (1.3 mm/min)



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