



Edgetek™ SF-30GF/15T NATURAL

Polyphenylene Sulfide

Key Characteristics

| Product Description | |
|--|--|
| 30% Glass Fiber Reinforced and 15% PTFE Lubricated PPS Compounds | |
| General | |
| Material Status | • Commercial: Active |
| Regional Availability | • Asia Pacific |
| Filler / Reinforcement | • Glass Fiber, 30% Filler by Weight • PTFE Micropowder, 15% Filler by Weight |
| Appearance | • Natural Color |
| Processing Method | • Injection Molding |

Technical Properties ¹

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|--|-------------------------|--------------------|-------------|
| Density / Specific Gravity | 1.68 | 1.68 | ASTM D792 |
| Molding Shrinkage - Flow | 1.0E-3 to 3.0E-3 in/in | 0.10 to 0.30 % | ASTM D955 |
| Mechanical | Typical Value (English) | Typical Value (SI) | Test Method |
| Tensile Modulus | 1.60E+6 psi | 11000 MPa | ASTM D638 |
| Tensile Strength | 19600 psi | 135 MPa | ASTM D638 |
| Flexural Modulus | 1.60E+6 psi | 11000 MPa | ASTM D790 |
| Flexural Strength | 25400 psi | 175 MPa | ASTM D790 |
| Impact | Typical Value (English) | Typical Value (SI) | Test Method |
| Notched Izod Impact 73°F (23°C), 0.126 in (3.20 mm) | 2.1 ft-lb/in | 110 J/m | ASTM D256 |
| Thermal | Typical Value (English) | Typical Value (SI) | Test Method |
| Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm) | 500 °F | 260 °C | ASTM D648 |
| Flammability | Typical Value (English) | Typical Value (SI) | Test Method |
| Flame Rating | | | UL 94 |
| 0.030 in (0.75 mm) | V-0 | V-0 | |
| 0.06 in (1.5 mm) | V-0 | V-0 | |
| 0.12 in (3.0 mm) | V-0 | V-0 | |

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 | 608 to 626 °F | 320 to 330 °C |
| Middle Temperature | 608 to 626 °F | 320 to 330 °C |
| Front Temperature | 608 to 626 °F | 320 to 330 °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