



Edgetek™ SF-40GF/000 BLACK

Polyphenylene Sulfide

Key Characteristics

General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight
Appearance	• Black
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	2.0E-3 in/in	0.20 %	ASTM D955
Molding Shrinkage - Across Flow	6.0E-3 in/in	0.60 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	22500 psi	155 MPa	ASTM D638
Flexural Modulus ³	1.89E+6 psi	13000 MPa	ASTM D790
Flexural Strength ³	29700 psi	205 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)	2.0 ft-lb/in	110 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)	500 °F	260 °C	
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.030 in (0.75 mm))	V-0	V-0	UL 94

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

Notes

¹ Typical values are not to be construed as specifications.

² 0.20 in/min (5.0 mm/min)

³ 0.051 in/min (1.3 mm/min)