



Edgetek™ SF-30GF/000 NC005

Polyphenylene Sulfide

Key Characteristics

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

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.56	1.56	ASTM D792
Molding Shrinkage - Flow	2.0E-3 to 8.0E-3 in/in	0.20 to 0.80 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	20300 psi	140 MPa	ASTM D638
Tensile Elongation ² (Break)	1.5 %	1.5 %	ASTM D638
Flexural Modulus ³	1.60E+6 psi	11000 MPa	ASTM D790
Flexural Strength ³	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)	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	
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 (0.0630 in (1.60 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

Copyright © 2015 PolyOne Corporation. PolyOne makes no representations, guarantees, or warranties of any kind with respect to the Information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the Information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the Information. PolyOne makes no warranties or guarantees respecting suitability of either PolyOne's products or the Information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the Information and/or use or handling of any product. POLYONE MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the Information or products reflected by the Information. This data sheet shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner.

Notes¹ 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)**CONTACT INFORMATION****Americas**United States - Avon Lake
+1 440 930 1000United States - McHenry
+1 815 385 8500**Asia**China - Guangzhou
+86 20 8732 7260China - Shenzhen
+86 755 2969 2888China - Suzhou
+86 512 6823 24 38China - Suzhou
+86 512 6265 2600Hong Kong -
+852 2690 5332Taiwan - Yonghe City,
+886 9396 99740, +886 2929 1849**Europe**Germany - Gaggenau
+49 7225 6802 0Spain - Barbastro (Huesca)
+34 974 310 314*Beyond Polymers.**Better Business Solutions.™*

www.polyone.com

PolyOne Americas33587 Walker Road
Avon Lake, Ohio 44012
United States
+1 440 930 1000
+1 866 POLYONE**PolyOne Asia**No. 88 Guoshoujing Road
Z.J Hi-tech Park, Pudong
Shanghai, 201203, China
+86 21 5080 1188**PolyOne Europe**6 Giällewee
+352 269 050 35

Copyright ©, 2015 PolyOne Corporation. PolyOne makes no representations, guarantees, or warranties of any kind with respect to the Information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the Information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the Information. PolyOne makes no warranties or guarantees respecting suitability of either PolyOne's products or the Information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the Information and/or use or handling of any product. POLYONE MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the Information or products reflected by the Information. This data sheet shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner.