



Edgetek™ XP9242701

Polyphenylene Sulfide

Key Characteristics

General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Carbon Fiber, 10% Filler by Weight • Glass Fiber, 30% Filler by Weight
Forms	• Pellets
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.65	1.65	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 Strength	37400 psi	258 MPa	ASTM D638
Flexural Modulus	2.61E+6 psi	18000 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Charpy Notched Impact Strength	1.12 ft-lb/in	60.0 J/m	ASTM D256
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed	509 °F	265 °C	ASTM D648
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	< 1.0E+9 ohms	< 1.0E+9 ohms	ASTM D257
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.06 in (1.6 mm))	HB	HB	UL 94

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	266 to 302 °F	130 to 150 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Rear Temperature	518 to 536 °F	270 to 280 °C
Middle Temperature	554 to 626 °F	290 to 330 °C
Front Temperature	554 to 626 °F	290 to 330 °C
Nozzle Temperature	536 to 608 °F	280 to 320 °C
Mold Temperature	248 to 302 °F	120 to 150 °C
Injection Pressure	10200 to 14500 psi	70.0 to 100 MPa
Holding Pressure	7250 to 11600 psi	50.0 to 80.0 MPa
Back Pressure	145 to 363 psi	1.00 to 2.50 MPa
Screw Speed	80 to 120 rpm	80 to 120 rpm

Injection Notes

Injection Speed: 50 to 80%
Holding Time: 3 to 9 sec
Injection Time: 1 to 3 sec
Cycle Time: 18 to 70 sec

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Notes

¹ Typical values are not to be construed as specifications.

CONTACT INFORMATION

Americas

United States - Avon Lake
+1 440 930 1000

United States - McHenry
+1 815 385 8500

Asia

China - Guangzhou
+86 20 8732 7260

China - Shenzhen
+86 755 2969 2888

China - Suzhou
+86 512 6823 24 38

China - Suzhou
+86 512 6265 2600

Hong Kong -
+852 2690 5332

Taiwan - Yonghe City,
+886 9396 99740, +886 2929 1849

Europe

Germany - Gaggenau
+49 7225 6802 0

Spain - Barbastro (Huesca)
+34 974 310 314



Beyond Polymers.

Better Business Solutions.™

www.polyone.com

PolyOne Americas

33587 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

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