Technical Data Sheet

Schulatec PPS GFM 65

Polyphenylene Sulfide
LyondellBasell Industries
Engineering Plastics

Product Description
Glass fibre and mineral filled PPS compound for general purpose

General	
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.95 g/cm³	1.95 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (300°c/5.0 Kg)	15 cm³/10min	15 cm³/10min	ISO 1133
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	2.47E+6 psi	17000 MPa	ISO 527-1/1A/1
Tensile Stress (Break)	21000 psi	145 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.2 %	1.2 %	ISO 527-2/1A/5
Flexural Modulus	2.80E+6 psi	19300 MPa	ISO 178
Flexural Stress	34800 psi	240 MPa	ISO 178
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength	2.9 ft·lb/in²	6.0 kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength	9.5 ft·lb/in²	20 kJ/m²	ISO 179/1eU
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ISO 75-2/Af
264 Psi (1.8 Mpa), Annealed	509 °F	265 °C	
Electrical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Electric Strength [1]			IEC 60243-1
73°f (23°c), 0.0394 In (1.00 Mm), In Oil	660 V/mil	26 kV/mm	
Comparative Tracking Index	175 V	175 V	IEC 60112
Flammability	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Burning Rate [2]			
0.0787 In (2.00 Mm)	0.0 in/min	0.0 mm/min	ISO 3795
0.0787 In (2.00 Mm)	0.0 in/min	0.0 mm/min	FMVSS 302
Flame Rating (0.06 In (1.5 Mm))	V-0	V-0	UL 94
Glow Wire Flammability Index			IEC 60695-2-12
0.06 In (1.5 Mm)	1760 °F	960 °C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.06 In (1.5 Mm)	1560 °F	850 °C	

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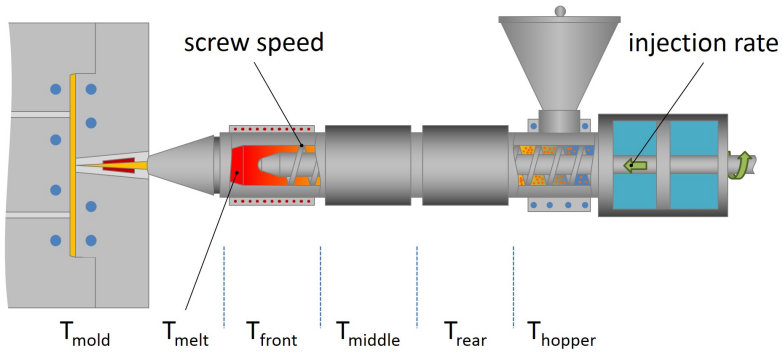

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature - Dry Air Dryer	266 to 284 °F	130 to 140 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Processing (Melt) Temp	572 to 626 °F	300 to 330 °C
Mold Temperature	275 to 293 °F	135 to 145 °C
Screw Speed	40 to 100 rpm	40 to 100 rpm

Notes

[1] 2000 V/sec

[2] Self-Extinguishing

Notes

These are typical property values not to be construed as specification limits.