

## Technical Data Sheet

**Schulatec PPS TFF 5040 N1 NAT**

Polyphenylene Sulfide

**Product Description**

40% glass fibre reinforced PPS compound with low wear properties

**Processing Method** Injection Molding

<b>Typical Properties</b>	<b>Nominal Value</b>	<b>Units</b>	<b>Test Method</b>
<b>Physical</b>			
Melt Volume Flow Rate, (300 °C/5.0 kg)	24	cm <sup>3</sup> /10 min	ISO 1133
Density, (Method A)	1.69	g/cm <sup>3</sup>	ISO 1183
<b>Mechanical</b>			
Tensile Strain at Break, (Type 1A, 5 mm/min)	1.5	%	ISO 527-2
Flexural Modulus	15100	MPa	ISO 178
Tensile Stress at Break, (Type 1A, 5 mm/min)	155	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	14400	MPa	ISO 527-1
Flexural Stress	280	MPa	ISO 178
<b>Impact</b>			
Charpy Impact Strength - Notched, (Type 1, Edgewise, Notch A)	8.5	kJ/m <sup>2</sup>	ISO 179
Charpy Impact Strength - Unnotched	38	kJ/m <sup>2</sup>	ISO 179-1/1eU
<b>Thermal</b>			
Deflection Temperature Under Load Annealed (1.80 MPa), (Flatwise)	265	°C	ISO 75-2/A
<b>Electrical</b>			
Comparative Tracking Index (CTI)	175	V	IEC 60112
<b>Flammable</b>			
Burning Rate			
(2.00 mm)	0.0	mm/min	FMVSS 302
(2.00 mm)	0.0	mm/min	ISO 3795
Glow Wire Flammability Index, (1.5 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature, (1.5 sec)	850	°C	IEC 60695-2-13
<b>UL Information</b>			
Flame Rating, (1.5 mm)	V-0		UL 94

<b>Injection Parameters</b>	<b>Nominal Value</b>	<b>Units</b>
Drying Time	3.0 to 4.0	hr
Drying Temperature, (Dry Air Dryer)	130 to 140	°C
Screw Speed	40 to 100	rpm
Processing (Melt) Temp	300 to 330	°C
Mold Temperature	135 to 145	°C