Product Data Sheet &
General Processing Conditions

EMI 1361
Polyphenylene Sulfide (PPS)
Stainless Steel Fiber
Electrically Conductive
EMI/RFI/ESD Protection

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	10 %	10 %	
Specific Gravity	1.45	1.45	D 792
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0120 - 0.0160 in/in	1.20 - 1.60 %	D 955
MECHANICAL			
Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	0.6 ft-lbs/in	32 J/m	D 256
unnotched 1/8 in (3.2 mm) section	3.0 ft-lbs/in	160 J/m	D 4812
Tensile Strength	8500 psi	59 MPa	D 638
Tensile Elongation	1.0 - 2.0 %	1.0 - 2.0 %	D 638
Tensile Modulus	0.60 x 10^6 psi	4137 MPa	D 638
Flexural Strength	16000 psi	110 MPa	D 790
Flexural Modulus	0.60 x 10^6 psi	4137 MPa	D 790
ELECTRICAL			
Volume Resistivity	< 1.0 ohm.cm	< 1.0 ohm.cm	D 257
Surface Resistivity	< 1E6 ohm/sq	< 1E6 ohm/sq	D 257
Surface Resistance	< 1E5 ohm	< 1E5 ohm	ESD STM11.11

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.
Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	585 - 615 °F	307 - 324 °C
Mold Temperature	275 - 350 °F	135 - 177 °C
Drying	6 hrs @ 300 °F	6 hrs @ 149 °C
Moisture Content	0.04 %	0.04 %

PROCESSING NOTES

Use a reverse barrel profile. Remove hopper magnets. Allow 4 - 5 shots to properly disperse the conductive fibers. The surface finish should have a silver streaking appearance, not clumps.