

TECACOMP PPS XS black 1014862 - Compounds

Chemical Designation

PPS (Polyphenylensulfide)

Colour

black

Density

1.5 g/cm³

Fillers

carbon fibres, graphite

Mechanical properties	parameter	value	unit	norm	comment
Tensile strength	5 mm/min	135	MPa	DIN EN ISO 527-1	
Modulus of elasticity (tensile test)	5 mm/min	18500	MPa	DIN EN ISO 527-1	
Elongation at break (tensile test)	5 mm/min	0,5	%	DIN EN ISO 527-1	
Impact strength (Charpy)		20	kJ/m ²	DIN EN ISO 179-1eU	
Thermal properties	parameter	value	unit	norm	comment
Glass transition temperature		90	°C	DIN 53765	
Melting temperature		280	°C	DIN 53765	
Service temperature	short term	260	°C	-	
Service temperature	long term	230	°C	-	
Thermal expansion (CLTE)	longitudinal (at 23 - 55 °C)	10	10 ⁻⁶ K ⁻¹	DIN EN ISO 11359-1;2	
Thermal expansion (CLTE)	transverse (at 23 - 55 °C)	20	10 ⁻⁶ K ⁻¹	DIN EN ISO 11359-1;2	
Thermal expansion (CLTE)	longitudinal (at 150 - 250 °C)	30	10 ⁻⁶ K ⁻¹	DIN EN ISO 11359-1;2	
Thermal expansion (CLTE)	transverse (at 150 - 250 °C)	60	10 ⁻⁶ K ⁻¹	DIN EN ISO 11359-1;2	
Other properties	parameter	value	unit	norm	comment
Molding shrinkage	transverse	0,86	%	DIN EN ISO 294-4	
Molding shrinkage	longitudinal	0,33	%	DIN EN ISO 294-4	
Bulk density		0,66	g/cm ³	EN ISO 60	
Processing parameter	parameter	value	unit	norm	comment
Cylinder/processing temperature		285 - 330	°C	-	
Mould temperature		130 - 160	°C	-	
Material temperature		300 - 340	°C	-	

→ This material can be processed as a thermoplastic taking the normal technical provisions into account. The above mentioned information refers exclusively to the injection moulding process.

→ Processing should be carried out as gently as possible, in order to maintain the maximum fibre length in the component. Back pressure and injection rate should be adjusted to the component geometry accordingly. The optimum processing temperature depends upon the respective geometry of the moulded part and can be different from machine to machine.

Pre-drying	parameter	value	unit	norm	comment
Permissible residual moisture content		< 0,05	%	-	
Drying temperature		140 - 150	°C	-	
Drying time		4 - 6	h	-	

→ To achieve optimum mechanical properties, it is recommended to pre-dry the material with the above mentioned parameters.

→ Information on storage and shelf life: The granules must be stored in dry, normally tempered rooms and in closed containers. For moisture-sensitive materials, the granules must be sealed airtight. Protection against direct sunlight must be guaranteed. The granules are usually subject to the requirements of no shelf life limitation. Shelf Life may be limited by some additives.

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