



**CP14-N0001**

**Polyphenylene Sulfide**

40% Glass Fiber Reinforcement

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Physical	Method	Typical Value	Units
Specific Gravity	ASTM D792	1.65	
Mold Shrink, with Flow	ASTM D955	0.002	in/in

**Impact**

Notched Izod Impact (.125 in) 73°F	ASTM D256	1.5	ft-lbs/in
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**Mechanical**

Tensile Strength @ Yield	ASTM D638	21,000	psi
Tensile Elongation @ Break	ASTM D638	1.1	%
Flexural Strength @ Yield	ASTM D790	30,000	psi
Flexural Modulus	ASTM D790	1,900,000	psi

**Thermal**

Deflection Temperature Under Load 264 psi	ASTM D648	505	°F
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**Flammability**

Flame Rating (.0625 in)	UL 94	V-0, 5VA	
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Information provided is based on typical values from reliable procedures. Values are based on natural or black materials unless otherwise noted. No guarantees or warranties of any kind are expressed or implied. Users are responsible for determining the suitability of the product for their intended application.

**Recommended Processing Parameters**

Drying Temperature	275°F
Drying Time	3.0 - 4.0 Hours
Suggested Maximum Moisture Content	0.02%
Rear Temperature	550 - 570 °F
Middle Temperature	590 - 610 °F
Front Temperature	620 - 640 °F
Nozzle Temperature	590 - 630 °F
Processing (Melt) Temperature	620 - 640 °F
Mold Temperature	280 - 320 °F

CPPT recommended processing parameters are meant to serve as guidelines only and are not intended to be used for specification purposes. Conditions should be adjusted to optimize material performance with the equipment part design and tooling.