EnTor 340GF
PPS

Product Description
40% glass fiber reinforced PPS, good for water contact applications

General Properties	
Appearance	Natural
Processing Methods	Injection Molding
Applications	Automotive, industrial, water contact

Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ISO 527/2/1A	27,500	psi	190	MPa
Tensile Modulus	ISO 527/2/1A	2,030,528	psi	14004	MPa
Tensile Elongation at Break	ISO 527/2/1A	2	%	2	%
Flexural Modulus	ISO 178	1,945,000	psi	13,414	MPa
Flexural Strength	ISO 178	40,000	psi	276	MPa
Notched Izod Impact (73°F)	ISO 180	2.5	ft-lb/in	134	J/m

Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ISO 1183	1.66	g/cm^3	1.66	g/cm^3
Mold Shrink - Flow: 0.126 in (3.20 mm)	Internal	0.2-0.5	%	0.2-0.5	%
Flame Rating 0.030	UL 94	V-0		V-0	

Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 264 psi	ISO 75	496	°F	258	°C

Injection Molding	Value	
Drying Temperature	300 - 325	°F
Drying Time	4.00	hrs
Maximum Drying Time	7.0	hrs
Suggested Maximum Moisture	0.02	%
Suggested Shot Size	25 - 75	%
Rear Barrel Temperatures	560 - 580	°F
Middle Barrel Temperatures	590 - 610	°F
Front Barrel Temperatures	620 - 650	°F
Nozzle Temperature	620 - 650	°F
Melt (processing) Temperatures	600 - 650	°F
Mold Temperatures	275 - 350	°F
Back Pressure	0 - 50	psi
Screw speed	50 - 100	rpm
Vent Depth	0.0015 - 0.0030	in