Star L

Star L PPS D93F

DESCRIPTION Star L PPS D93F is a PTFE / Aramid Fiber Lubricated PPS, Injection Molding Grade (EXPERIMENTAL GRADE)

PROPERTY (1)	UNIT	STANDARD	TYPICAL VALUE (1) Dry As Moulded
PHYSICAL			
Density	g/cm^3	ASTM D 792	1.44
Mold Shrinkage, flow (4mm thickness)	%	E2P Method	0.9 - 1.1
MECHANICAL			
Flexural Modulus	MPa	ISO 178	4400
Flexural Stress	MPa	ISO 178	91
Tensile Strain, break	%	ISO 527	1.2
Tensile Stress, yield	MPa	ISO 527	50
IMPACT			
Izod Impact, notched 80*10*4 +23°C	kJ/m^2	ISO 180/1A	1.5
Izod Impact, unnotched 80*10*4 +23°C	kJ/m^2	ISO 180/1U	9
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	°C	ISO 75/Af	120
Melting Point DSC	°C	ISO 3146	283

CRLab 1331671 LR4111

(1) Typical values for natural color unless specified otherwide. Do no constitute a specification. Significant variations are possible for colors

EUROSTAR Engineering Plastics, ZI - Rue de la Ferme Saint Ladre, BP2, F / 95471 Fosses Cedex, Tél : + 33 1 34 47 47 00, Fax : + 33 1 34 47 47 18

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PARAMETER	Setting	Unit
Mold Temperature	135 - 165	°C
Barrel - Zone 1 Temperature	310 - 320	°C
Barrel - Zone 2 Temperature	310 - 320	°C
Barrel - Zone 3 Temperature	310 - 320	°C
Barrel - Zone 4 Temperature	310 - 320	°C
Drying Temperature	130°C	°C
Drying Time	3-4 hours	hrs

PROCESSING PARAMETERS : see above typical molding conditions.
DRYING : is not essential when material is delivered in sealed bags with moisture content below 0.2 %.
BARRELS, SCREWS, MOULDS : use wear resisting steel or alloy such as bimetallic cylinders, nitrided screws.
USE OF REGRIND : the properties of the component should be checked in order to ascertain the maximum acceptable level of regrind.
SAFETY : please refer to Material Safety Datasheet.

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