

ES-3-204

- **Outline:** ES-3-204 is a glass fiber 30% reinforced polyphenylene sulfide compound with reduced flash and improved flexibility compared to conventional grades.
- **Color:** Black and Natural (Brown).

Processing Parameters

Injection Molding	Typical Value	Unit
Drying Temperature	130 to 140	°C
Drying Time	3 to 4	hrs
Nozzle Temperature	295 to 300	°C
Zone 1 Temperature	305 to 315	°C
Zone 2 Temperature	300 to 320	°C
Zone 3 Temperature	285 to 290	°C
Injection Pressure	60 to 120	Mpa
Injection Speed	Medium	-
Mold Temperature	130 to 150	°C
Holding Pressure	50 to 90	Mpa
Injection Time	3 to 5	s
Cooling Time	5 to 15	s



Please refer to Material Safety Data Sheet for safety precautions prior to use. The information contained in this data sheet is based on tests or research DIC Corporation ('DIC') believes to be reliable, but no warranty is given by DIC concerning the accuracy or completeness thereof. The supply of the information does not release the recipient from the obligation to test the products as to their suitability for the intended applications and processes. DIC has no liability for any consequence of the application, processing or use of the information or the products. Information concerning the application of the products is not and should not be construed as a warranty as to non-infringement of intellectual property for a particular application.