

Thin Wall Mold Ability

PPS has comparatively excellent mold flow ability comparing to other engineering polymers. However, thin wall mold ability under 0.5mm is frequently required in actual molded parts.

Fig.1 is showing evaluation data of DIC-PPS main four grades by the bar-flow mold (thickness: 0.25 to 1.0mm).

As the result, practical mold flow of each grade is as follows;

For wall thickness: 0.3mm

Maximum mold flow length for FZ-1140 and FZ-2140: 20mm

Maximum mold flow for FZ-3600 and FZ-6600: 15mm

However, these values may vary depend on cavity design, gate design, injection condition and machine.

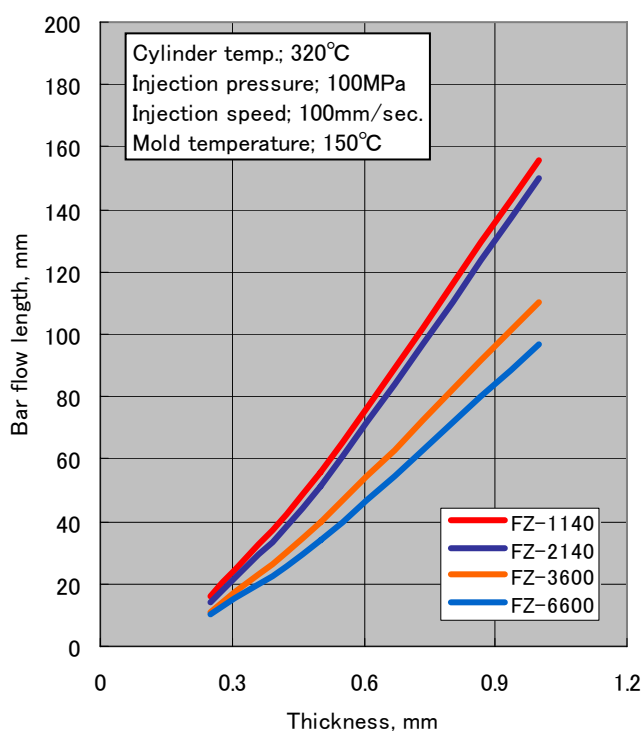


Fig.1 Thin wall flow ability.



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