Product Data Sheet &
General Processing Conditions

EMI 961
Polysulfone (PSU)
Stainless Steel Fiber
Electrically Conductive
EMI/RFI/ESD Protection

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	10 %	10 %	
Specific Gravity	1.35	1.35	D 792
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0050 - 0.0070 in/in	0.50 - 0.70 %	D 955
MECHANICAL			
Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	1.0 ft-lbs/in	53 J/m	D 256
unnotched 1/8 in (3.2 mm) section	10.0 ft-lbs/in	534 J/m	D 4812
Tensile Strength	10000 psi	69 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.40 x 10^6 psi	2758 MPa	D 638
Flexural Strength	14000 psi	97 MPa	D 790
Flexural Modulus	0.38 x 10^6 psi	2620 MPa	D 790
ELECTRICAL			
Volume Resistivity	< 1E2 ohm.cm	< 1E2 ohm.cm	D 257
Surface Resistivity	< 1E5 ohm/sq	< 1E5 ohm/sq	D 257
Surface Resistance	< 1E4 ohm	< 1E4 ohm	ESD STM11.11

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.
Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	10000 - 20000 psi	69 - 138 MPa
Melt Temperature	630 - 675 °F	332 - 357 °C
Mold Temperature	200 - 300 °F	93 - 149 °C
Drying	4 hrs @ 275 °F	4 hrs @ 135 °C
Moisture Content	< 0.15 %	< 0.15 %
Dew Point	-25 °F	-32 °C

PROCESSING NOTES

Use a reverse barrel profile. Remove hopper magnets. Allow 4 - 5 shots to properly disperse the conductive fibers. The surface finish should have a silver streaking appearance, not clumps.
Remove hopper magnets.

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This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a “trial and error” basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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