



Standard Classification System for Reinforced and Filled Poly(Phenylene Sulfide) (PPS) Injection Molding and Extrusion Materials Using ASTM Methods¹

This standard is issued under the fixed designation D 4067; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This classification system covers reinforced and filled poly(phenylene sulfide) materials suitable for injection molding and extrusion.

1.2 This classification system is not intended for the selection of materials, but only as a means to call out plastic materials to be used for the manufacture of parts. The selection of these materials shall be made by personnel with expertise in the plastics field where the environment, inherent properties of the materials, performance of the parts, part design, manufacturing process, and economics are considered.

1.3 The properties included in this classification system are those required to identify the compositions covered. If necessary, other requirements identifying particular characteristics important to specific applications shall be designated by using the suffixes given in Section 5 or Classification System D 4000.

1.4 The values stated in SI units are to be regarded as the standard.

1.5 This precautionary statement pertains only to the test method portion of this classification system, Section 12. *This standard does not purport to address all of the safety concerns associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

NOTE 1—There is no known ISO equivalent to this standard.

2. Referenced Documents

2.1 ASTM Standards:²

D 256 Test Methods for Determining the Izod Pendulum

¹ This classification system is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.15 on Thermoplastic Materials.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For Annual Book of ASTM Standards volume information, refer to the standard's Document Summary page on the ASTM website.

Impact Resistance of Plastics²

D 618 Practice for Conditioning Plastics for Testing²

D 638 Test Method for Tensile Properties of Plastics²

D 648 Test Method for Deflection Temperature of Plastics Under Flexural Load in the Edgewise Position²

D 790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials²

D 792 Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement²

D 883 Terminology Relating to Plastics²

D 1238 Test Method for Melt Flow Rates of Thermoplastics by Extrusion Plastometer²

D 1600 Terminology for Abbreviated Terms Relating to Plastics²

D 1898 - 68(1989) Practice for Sampling of Plastics³

D 3418 Test Method for Transition Temperatures of Polymers by Differential Scanning Calorimetry²

D 3641 Practice for Injection Molding Test Specimens of Thermoplastic Molding and Extrusion Materials²

D 3835 Test Method for Determination of Properties of Polymeric Materials by Means of a Capillary Rheometer²

D 3892 Practice for Packaging/Packing of Plastics²

D 4000 Classification System for Specifying Plastic Materials²

D 5630 Test Method for Ash Content in Plastics²

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specification²

E 595 Test Method for Total Mass Loss and Collected Volatile Condensable Materials from Outgassing in a Vacuum Environment²

E 662 Test Method for Specific Optical Density of Smoke Generated by Solid Materials²

2.2 Military Standards:⁴

MIL-P-46174 (MR) Plastic Molding Material, Polyphenylene Sulfide, Glass Fiber Reinforced

³ Discontinued; see 1997 Annual Book of ASTM Standards, Vol 08.01.

⁴ Available from Standardization Documents, Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

*A Summary of Changes section appears at the end of this standard.

TABLE A Physical Property Requirements

Designation Order	Property/ASTM Test Method	Units	0	1	2	3	4	5	6	7	8	9
1	Tensile strength, min D 638^A	MPa ^B	<i>C</i>	60	80	110	120	130	160	180	200	<i>D</i>
2	Flexural modulus, min D 790^E	MPa ^B	<i>C</i>	7 000	10 000	12 000	14 000	17 000	20 000	23 000	26 000	<i>D</i>
3	Izod impact strength, min D 256^F	J/m ^G	<i>C</i>	28	40	52	70	80	90	100	110	<i>D</i>
4	Flexural strength, min D 790^E	MPa ^B	<i>C</i>	85	105	135	165	195	225	255	285	<i>D</i>
5	Density, min D 792	g/cm ³	<i>C</i>	1.40	1.50	1.60	1.70	1.80	1.90	2.00	2.10	<i>D</i>

^A Type I specimens, 3.18 mm thickness, crosshead speed of 5 mm/min.

^B MPa × 145 = psi.

^C Unspecified.

^D Specific value (must be shown).

^E Tangent modulus of elasticity. Test specimens are 3.18 by 12.7 mm and tested with a crosshead speed of 1.3 mm/min ± 50 % with a span to depth ratio of 16:1.

^F Test specimens are 3.18 mm thick with a notch radius of 0.25 mm and tested by Method A.

^G J/m × 18.73 × 10⁻³ = ft-lbf/in.

MIL-M-24519 Molding Plastics, Electrical, Thermoplastic
2.3 *ISO Standard*.⁵

ISO 527-2 Plastics—Determination of Tensile Properties—
Part 2: Test Conditions for Moulding and Extrusion
Plastics

3. Terminology

3.1 Definitions:

3.1.1 The definitions used in this classification system are in accordance with Terminology **D 883** and Terminology **D 1600**.

4. Classification

4.1 There is currently no group, class, or grade distinction and no basic property table is given.

NOTE 2—Where no basic property table exists, the generic family designation will be followed by three zeros, for example: PPS 000.

4.1.1 Table A shall be used to specify the physical property requirements that shall be shown by a six-character designation. The designation shall consist of the letter A and the five digits comprising the cell numbers for the property requirements in the order as they appear in Table A.

4.1.1.1 The values listed are necessary to include the range of properties available in existing materials. However, this does not imply that every possible combination of properties exists or can be obtained with the current state of technology.

4.2 A single letter shall be used to indicate the major category of the reinforcement, along with two numbers that indicate the percentage of additive(s) by mass, with the tolerances as tabulated below:

Category	Material	Tolerance (Based on the total mass)
C	Carbon and graphite fiber-reinforced	±2 percentage points
G	Glass-reinforced ≤15 % glass content	±2 percentage points
	>15 % glass content	±3 percentage points
L	Lubricants (such as PTFE, graphite, silicone, and molybdenum disulfide) or lubricants with fillers/reinforcements	By agreement between the supplier and the user.
M	Mineral-reinforced	±2 percentage points
R	Reinforced-combination/mixtures of reinforcements or other fillers/reinforcements.	±3 percentage points based on the total reinforcement.

NOTE 3—This part of the system uses the type and percentage of additive to designate the modification of the basic material. To facilitate

⁵ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

this designation, the type and percentage of additive can be shown on the supplier's technical data sheet unless it is proprietary in nature. If necessary, additional requirements shall be indicated by the use of the suffix part of the system, as given in Section 5. Special agreements on tolerances may be needed below 5 % levels.

NOTE 4—An example of this classification system for a poly(phenylene sulfide) material is as follows: The designation PPS000G40A42043 would indicate the following material requirements from Table A:

PPS000	=	poly(phenylene sulfide) material,
G40	=	glass-reinforced at 40 % nominal level,
A	=	Table A physical property requirements,
4	=	tensile strength, min 120 MPa,
2	=	flexural modulus, min 10 000 MPa,
0	=	Izod impact strength, unspecified,
4	=	flexural strength, min 165 MPa, and
3	=	density, min 1.60 g/cm ³ .

If no properties are specified, the designation would be PPS000G40A00000.

5. Suffixes

5.1 When additional requirements are needed that are not covered by the basic requirements or cell table requirements, they shall be indicated through the use of suffixes. Electrical, flammability or other requirements shall be designated by the appropriate suffix from Table 3 of Classification System **D 4000**.

5.1.1 If applicable, heat deflection temperature shall be designated using the following suffix:

Y = Heat deflection temperature as designated by the following digits:

First Digit

1 = Test Method **D 648**, 1820 kPa

Second Digit

1 = minimum of 260°C

2 = other minimum temperature (°C) - specify

NOTE 5—Heat treating the test specimens at 260°C for 4 h is permitted to achieve high heat deflection temperatures.

6. Basic Requirements

6.1 Basic requirements from Table A, as they apply, are always in effect unless superseded by specific suffix requirements, which always take precedence.

7. General Requirements

7.1 The plastics composition shall be uniform and shall conform to the requirements specified herein. The color and form of the material shall be as agreed upon between the supplier and the user.