

FORTRON® FX530T4

Polyphenylene sulfide

FORTRON(R) FX530T4 is a 30% glass filled, impact modified grade for injection molding with good thermal shock resistance

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Resin Identification Part Marking Code	PPS-GF30 >PPS-GF30<		ISO 1043 ISO 11469
Typical mechanical properties			
Tensile modulus	10000	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	140	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2	%	ISO 527-1/-2
Flexural modulus	9700	MPa	ISO 178
Flexural strength	200	MPa	ISO 178
Charpy notched impact strength, 23°C	10	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C		kJ/m²	ISO 179/1eA
Poisson's ratio	0.34 ^[C]		
[C]: Calculated			
Thermal properties			
Temperature of deflection under load, 1.8 MPa	260	°C	ISO 75-1/-2

Electrical properties

Volume resistivity	1E14 ^[OT]	Ohm.m	IEC 62631-3-1
Volume resistivity, at high temperature		Ohm.m	IEC 62631-3-1
Temperature	180 ^[OT]	°C	
Surface resistivity	1E11 ^[OT]	Ohm	IEC 62631-3-2
Surface resistivity, at high temperature	1E11 ^[OT]		IEC 62631-3-2
Temperature	180 ^[OT]	-	
Electric strength	21 ^[OT]	kV/mm	IEC 60243-1
Electric strength, Direct Current	40 ^[OT]	kV/mm	IEC 60243-2
Electric strength, DC, high temperature	34 ^[OT]	kV/mm	IEC 60243-2
Temperature	180 ^[OT]	°C	
Comparative tracking index, 100 drops	125 ^[OT]		IEC 60112
[OT]: One time tested			

Physical/Other properties

Density	1500 kg/m ³	ISO 1183
Density	1300 Kg/III	100 11

Injection

Drying Recommended	yes	
Drying Temperature	130	°C
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.02	%
Melt Temperature Optimum	330	°C
Min. melt temperature	310	°C
Max. melt temperature	340	°C
Screw tangential speed	0.2 - 0.3	m/s

Printed: 2024-09-05 Page: 1 of 2

Revised: 2024-06-13 Source: Celanese Materials Database



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Mold Temperature Optimum150 °CMin. mould temperature140 °CMax. mould temperature160 °CHold pressure range30 - 70 MPaBack pressure3 MPa

Additional information

Processing Notes

Pre-Drying

Pre-drying conditions:

FORTRON PPS should, in principle, be pre-dried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be = $-30\,^{\circ}$ C. The time between drying and processing should be as short as possible.

Printed: 2024-09-05 Page: 2 of 2

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