Fortron® FX515T1

Celanese Corporation - Polyphenylene Sulfide

Tuesday, November 5, 2019

General Information

Product Description

Fortron® FX515T1 is a 15% glass filled, impact modified PPS grade

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight		
Additive	• Impact Modifier		
Features	• Impact Modified		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.37	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	0.30	%	
Flow	0.60	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	870000	psi	ISO 527-2/1A
Tensile Stress (Break)	14500	psi	ISO 527-2/1A/5
Tensile Strain (Break)	2.1	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	841000	psi	ISO 178
Flexural Stress (73°F)	21800	psi	ISO 178
Flexural Strain at Break	3.1	%	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (73°F)	4.8	ft·lb/in²	ISO 179/1eA
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (264 psi, Unannealed)	428	°F	ISO 75-2/A

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	579 to 590	°F
Middle Temperature	595 to 601	°F
Front Temperature	595 to 601	°F
Nozzle Temperature	570 to 590	°F
Mold Temperature	241 to 250	°F
Injection Rate	Slow-Moderate	
Back Pressure	< 508	psi

Injection Notes

Feeding zone temperature: 66 to 71°C

Zone4 temperature: 299 to 310°C

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Notes

[1] Typical properties: these are not to be construed as specifications.