Celanese
The chemistry inside innovation™

FORTRON® 1132L4

Polyphenylene sulfide

Product information

Resin Identification	PPS-GF30	ISO 1043
Part Marking Code	>PPS-GF30<	ISO 11469

Typical mechanical properties

Tensile stress at break, 50mm/min	25400	psi	ISO 527-1/-2
Tensile strain at break, 50mm/min	2	%	ISO 527-1/-2
Flexural modulus	1.74E6	psi	ISO 178
Flexural strength	37700	psi	ISO 178
Izod notched impact strength, 23°C	4.42	ftlb/in²	ISO 180/1A

Thermal properties

Melting temperature, 10°C/min	536	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	500	°F	ISO 75-1/-2

Physical/Other properties

Water absorption, 2mm	0.02	%	Sim. to ISO 62
Density	0.057	lb/in³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	212	°F
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.02	%
Melt Temperature Optimum	626	°F
Min. melt temperature	590	°F
Max. melt temperature	644	°F
Max. screw tangential speed	0.2 - 0.3	m/s
Mold Temperature Optimum	302	°F
Min. mold temperature	284	°F
Max. mold temperature	320	°F
Hold pressure range	4350 - 10200	psi

Characteristics

Processing	Injection Molding
Special characteristics	Flame retardant

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