FORTRON® FX40T1

Polyphenylene sulfide

Fortron® FX40T1 is an unreinforced, impact-modified high toughness poly(phenylene sulfide)

Product information

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

Typical mechanical properties

Tensile modulus	352000	psi	ISO 527-1/-2
Tensile stress at break, 50mm/min	6960	psi	ISO 527-1/-2
Flexural modulus	406000	psi	ISO 178
Flexural stress at 3.5%	12300	psi	ISO 178
Charpy notched impact strength, 23°C	23.8	ftlb/in²	ISO 179/1eA
Charpy notched impact strength, -30°C	4.76	ftlb/in²	ISO 179/1eA
Poisson's ratio	0.411		

Injection

Drying Recommended	yes	
Drying Temperature	266	°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	248	°F
Min. mold temperature	176	°F
Max. mold temperature	320	°F
Hold pressure range	4350 - 10200	psi
Back pressure	508	psi

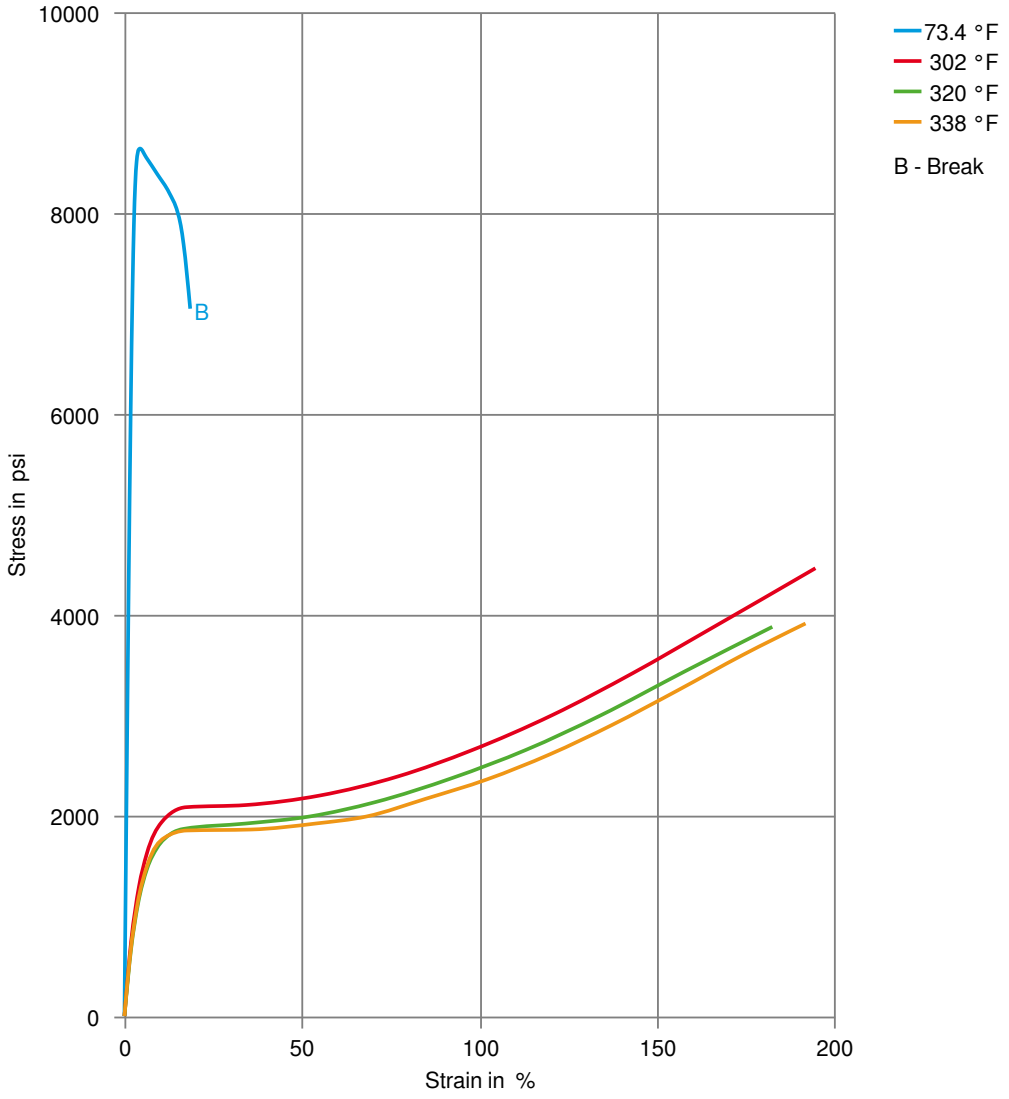
Characteristics

Processing	Injection Molding, Extrusion, Blow Molding
Special characteristics	High impact or impact modified

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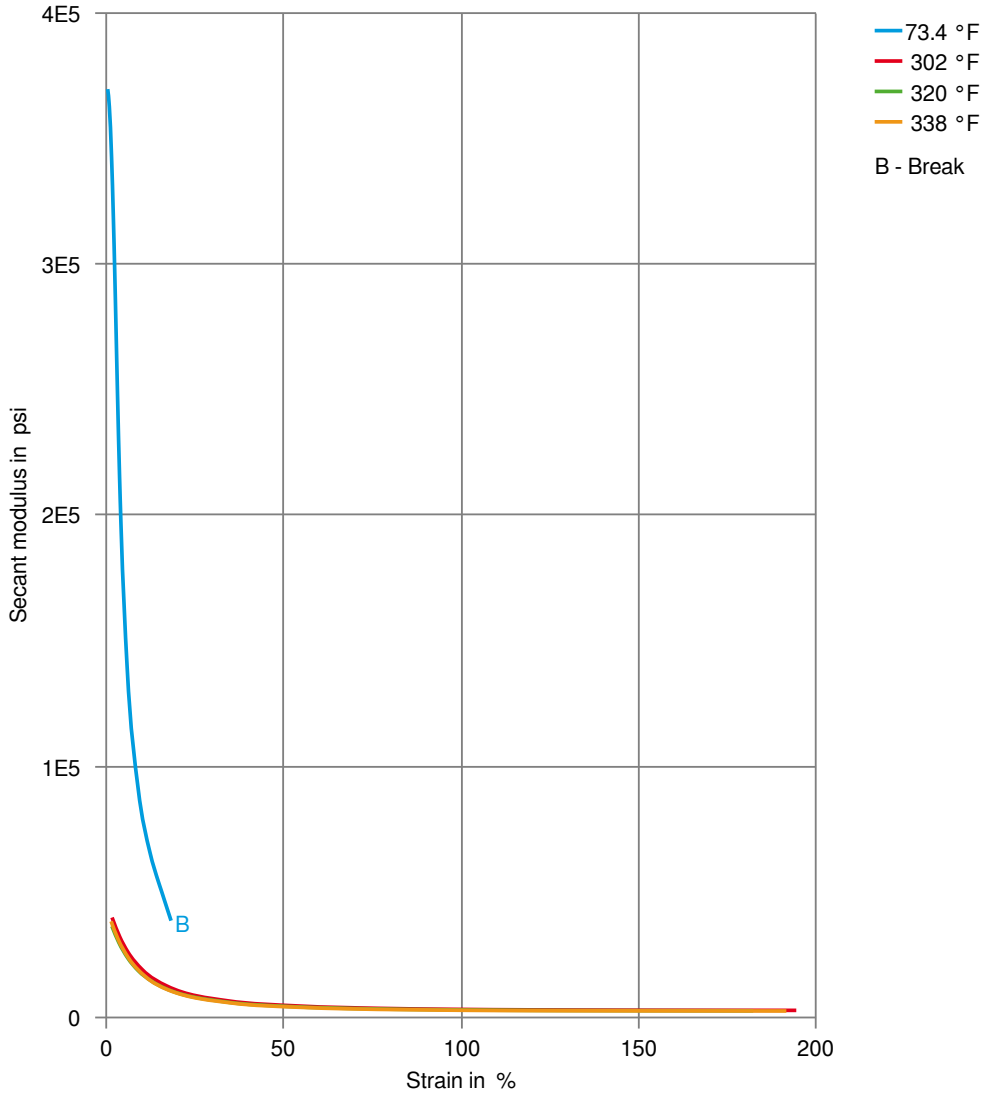
Stress-strain



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Secant modulus-strain



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