FORTRON® FX515T1

Polyphenylene sulfide

Fortron® FX515T1 is a 15% glass filled, impact modified PPS grade with good impact resistance suitable for injection molding and food contact applications

Product information

Resin Identification	PPS-GF15		ISO 1043
Part Marking Code	>PPS-GF15<		ISO 11469

Rheological properties

Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.3	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	870000	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	14500	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.1	%	ISO 527-1/-2
Flexural modulus	841000	psi	ISO 178
Flexural strength	21800	psi	ISO 178
Flexural strain at failure	3.1	%	ISO 178
Charpy impact strength, 23°C	19	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23°C	4.76	ftlb/in²	ISO 179/1eA

Thermal properties

Temperature of deflection under load, 1.8 MPa	428	°F	ISO 75-1/-2

Physical/Other properties

Density	0.0495	lb/in³	ISO 1183

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
Ejection temperature	385	°F

Revised: 2026-09-08 Source: Celanese Materials Database

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Automotive

OEM	ADDITIONAL INFORMATION
Renault	UB02b, No Spec, Special Part Approval, See Your CE Account Manager.

Characteristics

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

Additional information

Processing Notes

Pre-Drying

Fortron should 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 deg C. the time between drying and processing should be as short as possible. Normal drying time is 3-4 hrs at 121 deg C but for drying overnight temp should be reduced to 90 deg C.

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