FORTRON® FX530T4

Polyphenylene sulfide

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

Product information

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

Typical mechanical properties

Tensile modulus	1.45E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	21000	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	2	%	ISO 527-1/-2
Flexural modulus	1.41E6	psi	ISO 178
Flexural strength	29700	psi	ISO 178
Charpy notched impact strength, 23°C	4.76	ftlb/in²	ISO 179/1eA
Charpy notched impact strength, -30°C	4.28	ftlb/in²	ISO 179/1eA

Thermal properties

Temperature of deflection under load, 1.8 MPa	500	°F	ISO 75-1/-2

Electrical properties

Volume resistivity	1E14[OT]	Ohm.m	IEC 62631-3-1
Volume resistivity, at high temperature	4E9[OT]	Ohm.m	IEC 62631-3-1
Temperature	356[OT]	°F	
Surface resistivity	1E11[OT]	Ohm	IEC 62631-3-2
Surface resistivity, at high temperature	1E11[OT]	Ohm	IEC 62631-3-2
Temperature	356[OT]	°F	
Electric strength	533[OT]	kV/in	IEC 60243-1
Electric strength, Direct Current	1020[OT]	kV/in	IEC 60243-2
Electric strength, DC, high temperature	864[OT]	kV/in	IEC 60243-2
Temperature	356[OT]	°F	

[OT]: One time tested

Physical/Other properties

Density	0.0542	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

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Hold pressure range	4350 - 10200	psi
Back pressure	435	psi

Characteristics

Processing	Injection Molding
Special characteristics	High impact or impact modified

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 °C. The time between drying and processing should be as short as possible.

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