

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

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

Typical mechanical properties

Tensile modulus	6000 MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	100 MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.1 %	ISO 527-1/-2
Flexural modulus	5800 MPa	ISO 178
Flexural strength	150 MPa	ISO 178
Flexural strain at failure	3.1 %	ISO 178
Charpy impact strength, 23°C	40 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	10 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.35 ^[C]	

[C]: Calculated

Thermal properties

Temperature of deflection under load, 1.8 MPa	220 °C	ISO 75-1/-2
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Physical/Other properties

Density	1370 kg/m ³	ISO 1183
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Injection

Drying Recommended	yes
Drying Temperature	130 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	≤0.02 %
Melt Temperature Optimum	330 °C
Min. melt temperature	310 °C
Max. melt temperature	340 °C
Screw tangential speed	0.2 - 0.3 m/s
Mold Temperature Optimum	120 °C
Min. mould temperature	80 °C
Max. mould temperature	160 °C
Hold pressure range	30 - 70 MPa
Back pressure	3.5 MPa
Ejection temperature	196 °C

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Characteristics

Processing	Injection Moulding, 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.

Automotive

OEM
Renault

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