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	180	MPa	ISO 527-1/-2
Tensile strain at break, 50mm/min	2	%	ISO 527-1/-2
Flexural modulus	12000	MPa	ISO 178
Flexural strength	260	MPa	ISO 178
Izod notched impact strength, 23°C	9.3	kJ/m²	ISO 180/1A

Thermal properties

Melting temperature, 10°C/min	280	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	260	°C	ISO 75-1/-2

Physical/Other properties

Water absorption, 2mm	0.02	%	Sim. to ISO 62
Density	1580	kg/m³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	100	°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	150	°C
Min. mould temperature	140	°C
Max. mould temperature	160	°C
Hold pressure range	30 - 70	MPa

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