# Celstran® PPS-AF35-01-

## Celanese Corporation - Polyphenylene Sulfide

Tuesday, November 5, 2019

### General Information

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|---|---|---|---|
| **Product Description** | | | |
| PPS with 35% aramid fiber by weight | | | |
| **General** | | | |
| Material Status | • Commercial: Active | | |
| Availability | • Asia Pacific | • Europe | • North America |
| Filler / Reinforcement | • Aramid Fiber, 35% Filler by Weight | | |
| RoHS Compliance | • Contact Manufacturer | | |

### ASTM & ISO Properties [1]

| Physical | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Density | 1.35 | g/cm³ | ISO 1183 |
| **Mechanical** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Modulus | 1.28E+6 | psi | ISO 527-2/1A |
| Tensile Stress (Break) | 11200 | psi | ISO 527-2/1A/5 |
| Tensile Strain (Break) | 1.4 | % | ISO 527-2/1A/5 |
| Flexural Modulus (73°F) | 1.23E+6 | psi | ISO 178 |
| Flexural Stress (73°F) | 20300 | psi | ISO 178 |
| **Impact** | **Nominal Value** | **Unit** | **Test Method** |
| Charpy Notched Impact Strength (73°F) | 4.3 | ft·lb/in² | ISO 179/1eA |
| **Thermal** | **Nominal Value** | **Unit** | **Test Method** |
| Heat Deflection Temperature (264 psi, Unannealed) | 500 | °F | ISO 75-2/A |

### Processing Information

| Injection | Nominal Value | Unit |
|---|---|---|
| Drying Temperature | 266 to 284 | °F |
| Drying Time | 3.0 to 4.0 | hr |
| Suggested Max Moisture | 0.020 | % |
| Hopper Temperature | 158 to 176 | °F |
| Rear Temperature | 545 to 563 | °F |
| Middle Temperature | 554 to 572 | °F |
| Front Temperature | 563 to 581 | °F |
| Nozzle Temperature | 554 to 572 | °F |
| Processing (Melt) Temp | 572 to 590 | °F |
| Mold Temperature | 284 to 320 | °F |

**Injection Notes**

Feeding zone temperature: 20 to 50°C

Zone4 temperature: 300 to 310°C

### Notes

[1] Typical properties: these are not to be construed as specifications.