



Fortron® 1115E7

Celanese Corporation - Polyphenylene Sulfide

Tuesday, November 5, 2019

General Information

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Water Absorption (Saturation, 73°F)	0.020	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	11600	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.2	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.02E+6	psi	ISO 178
Flexural Stress (73°F)	17800	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	2.4	ft-lb/in ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ²	536	°F	ISO 11357-3

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	68 to 86	°F
Rear Temperature	554 to 572	°F
Middle Temperature	590 to 608	°F
Front Temperature	626 to 644	°F
Nozzle Temperature	590 to 626	°F
Processing (Melt) Temp	626 to 644	°F
Mold Temperature	284 to 320	°F
Injection Rate	Fast	
Back Pressure	< 435	psi

Injection Notes

Feeding zone temperature: 60 to 80°C
Zone4 temperature: 330 to 340°C
Hot runner temperature: 330 to 340°C

Notes

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

² 10°C/min