



Fortron® 4332L6

Celanese Corporation - Polyphenylene Sulfide

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General Information

Product Description

Fortron 4332L6 is a glass fiber/mineral filled injection molding grade, which is intended for applications requiring improved tensile and flexural properties, when compared to other GF/MIN reinforced PPS grades. The recommended processing parameters are similar to the standard grades.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass/Mineral		
RoHS Compliance	• Contact Manufacturer		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.95	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	0.30 to 0.70	%	
Flow	0.20 to 0.60	%	
Water Absorption (Saturation, 73°F)	0.020	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3.12E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	23200	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.2	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	3.05E+6	psi	ISO 178
Flexural Stress (73°F)	37700	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	4.8	ft·lb/in ²	ISO 179/1eA
Charpy Unnotched Impact Strength (73°F)	14	ft·lb/in ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	518	°F	ISO 75-2/A
Heat Deflection Temperature (1160 psi, Unannealed)	428	°F	ISO 75-2/C
CLTE - Flow	7.8E-6	in/in/°F	ISO 11359-2
CLTE - Transverse	1.7E-5	in/in/°F	ISO 11359-2

Processing Information

Injection	Nominal Value	Unit
Processing (Melt) Temp	608 to 644	°F
Mold Temperature	284	°F
Injection Rate	Moderate	
Screw L/D Ratio	15.0:1.0 to 25.0:1.0	

Notes

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