# Fortron® DEV FX530T4

## Celanese Corporation - Polyphenylene Sulfide

Tuesday, November 5, 2019

### General Information

| | | | |
|---|---|---|---|
| **Product Description** | | | |
| FORTRON(R) DEV FX530T4 is a 30% glass filled, impact modified grade for injection molding | | | |
| **General** | | | |
| Material Status | • Experimental: Active | | |
| Availability | • Africa & Middle East<br>• Asia Pacific | • Europe<br>• Latin America | • North America |
| Filler / Reinforcement | • Glass Fiber, 30% Filler by Weight | | |
| Additive | • Impact Modifier | | |
| Features | • Impact Modified | | |
| Processing Method | • Injection Molding | | |

### ASTM & ISO Properties [1]

| Physical | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Density | 1.50 | g/cm³ | ISO 1183 |
| **Mechanical** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Modulus | 1.45E+6 | psi | ISO 527-2/1A |
| Tensile Stress (Break) | 21800 | psi | ISO 527-2/1A/5 |
| Tensile Strain (Break) | 2.1 | % | ISO 527-2/1A/5 |
| Flexural Modulus (73°F) | 1.45E+6 | psi | ISO 178 |
| Flexural Stress (73°F) | 30500 | psi | ISO 178 |
| **Impact** | **Nominal Value** | **Unit** | **Test Method** |
| Charpy Notched Impact Strength (73°F) | 4.5 | 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 | 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

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### Notes

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

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