



Fortron® FX32T4

Celanese Corporation - Polyphenylene Sulfide

Tuesday, November 5, 2019

General Information

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• Latin America
RoHS Compliance	• Contact Manufacturer		

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (310°C/2.16 kg)	28	g/10 min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.2	%	
Flow	1.2	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	305000	psi	ISO 527-2/1A
Tensile Stress (Break)	7250	psi	ISO 527-2/1A/50
Tensile Strain (Break)	30	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	3.3	ft-lb/in ²	
73°F	8.1	ft-lb/in ²	
Thermal	Nominal Value	Unit	Test Method
CLTE - Flow			ISO 11359-2
-22 to 158°F ²	3.8E-5	in/in/°F	
230 to 392°F ³	7.2E-5	in/in/°F	
CLTE - Transverse			ISO 11359-2
-22 to 158°F ²	4.4E-5	in/in/°F	
230 to 392°F ³	7.8E-5	in/in/°F	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.12 in)	V-0		UL 94
Oxygen Index	44	%	ISO 4589-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	194	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.050	%
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

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Injection	Nominal Value	Unit
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 below Tg

³ above Tg