# Fortron® FX72T6

## Celanese Corporation - Polyphenylene Sulfide

Tuesday, November 5, 2019

### General Information

| General | | | |
|---|---|---|---|
| Material Status | • Commercial: Active | | |
| Availability | • Africa & Middle East<br>• Asia Pacific | • Europe<br>• Latin America | • North America |
| RoHS Compliance | • Contact Manufacturer | | |

### ASTM & ISO Properties [1]

| Physical | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Density | 1.18 | g/cm³ | ISO 1183 |
| Melt Mass-Flow Rate (MFR) (310°C/2.16 kg) | 35 | g/10 min | ISO 1133 |
| Molding Shrinkage | | | ISO 294-4 |
| Across Flow | 1.3 | % | |
| Flow | 1.3 | % | |
| **Mechanical** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Modulus | 244000 | psi | ISO 527-2/1A |
| Tensile Stress (Break) | 5800 | psi | ISO 527-2/1A/50 |
| Tensile Strain (Break) | 20 | % | ISO 527-2/1A/50 |
| Flexural Modulus (73°F) | 247000 | psi | ISO 178 |
| **Impact** | **Nominal Value** | **Unit** | **Test Method** |
| Charpy Notched Impact Strength (73°F) | 4.8 | ft·lb/in² | ISO 179/1eA |
| Charpy Unnotched Impact Strength (73°F) | No Break | | ISO 179/1eU |
| Notched Izod Impact Strength (73°F) | 4.8 | ft·lb/in² | ISO 180/1A |
| Unnotched Izod Impact Strength (73°F) | No Break | | ISO 180/1U |
| **Thermal** | **Nominal Value** | **Unit** | **Test Method** |
| Heat Deflection Temperature (264 psi, Unannealed) | 212 | °F | ISO 75-2/A |
| Vicat Softening Temperature | 252 | °F | ISO 306/B50 |
| CLTE - Flow | | | ISO 11359-2 |
| -22 to 158°F [2] | 4.8E-5 | in/in/°F | |
| 230 to 392°F [3] | 7.2E-5 | in/in/°F | |
| CLTE - Transverse | | | ISO 11359-2 |
| 158 to 230°F [2] | 5.4E-5 | in/in/°F | |
| 230 to 392°F [3] | 7.8E-5 | in/in/°F | |
| **Electrical** | **Nominal Value** | **Unit** | **Test Method** |
| Relative Permittivity (1 MHz) | 3.10 | | IEC 60250 |
| Dissipation Factor (1 MHz) | 3.0E-4 | | IEC 60250 |
| **Flammability** | **Nominal Value** | **Unit** | **Test Method** |
| Flame Rating (0.12 in) | V-0 | | UL 94 |
| Oxygen Index | 49 | % | ISO 4589-2 |

# Fortron® FX72T6

## Celanese Corporation - Polyphenylene Sulfide

### Processing Information

| Injection | Nominal Value | Unit |
|---|---|---|
| Drying Temperature | 176 to 212 | °F |
| Drying Time | 3.0 to 4.0 | hr |
| Suggested Max Moisture | 0.020 | % |
| Rear Temperature | 536 to 581 | °F |
| Middle Temperature | 545 to 590 | °F |
| Front Temperature | 554 to 608 | °F |
| Processing (Melt) Temp | 554 to 608 | °F |
| Mold Temperature | 122 to 158 | °F |

**Injection Notes**

Feeding zone temperature: 20 to 75°C

Zone4 temperature: 290 to 320°C

### Notes

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

[2] below Tg

[3] above Tg