



Fortron® FX72T6

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
Density	1.18	g/cm ³	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/in ²	ISO 179/1eA
Charpy Unnotched Impact Strength (73°F)	No Break		ISO 179/1eU
Notched Izod Impact Strength (73°F)	4.8	ft·lb/in ²	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

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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