

FORTRON® 1132L4

Polyphenylene sulfide

Product information

Resin Identification	PPS-GF30	ISO 1043
Part Marking Code	>PPS-GF30<	ISO 11469

Typical mechanical properties

Tensile stress at break, 50mm/min	180 MPa	ISO 527-1/-2
Tensile strain at break, 50mm/min	2 %	ISO 527-1/-2
Flexural modulus	12000 MPa	ISO 178
Flexural strength	260 MPa	ISO 178
Izod notched impact strength, 23 °C	9.3 kJ/m ²	ISO 180/1A

Thermal properties

Melting temperature, 10 °C/min	280 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	260 °C	ISO 75-1/-2

Physical/Other properties

Water absorption, 2mm	0.02 %	Sim. to ISO 62
Density	1580 kg/m ³	ISO 1183

Injection

Drying Recommended	yes
Drying Temperature	100 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	≤0.02 %
Melt Temperature Optimum	330 °C
Min. melt temperature	310 °C
Max. melt temperature	340 °C
Screw tangential speed	0.2 - 0.3 m/s
Mold Temperature Optimum	150 °C
Min. mould temperature	140 °C
Max. mould temperature	160 °C
Hold pressure range	30 - 70 MPa

Characteristics

Processing	Injection Moulding
Special characteristics	Flame retardant

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