

CELSTRAN® PPS-GF40-02 AD3002 Black

40% long strand fiber glass reinforced polyphenylene sulfide

Typical mechanical properties

Tensile Modulus	14800 MPa	ISO 527-1/-2
Stress at break, 5mm/min	165 MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.3 %	ISO 527-1/-2
Flexural Modulus	14300 MPa	ISO 178
Flexural Strength	265 MPa	ISO 178
Charpy impact strength, 23°C	40 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	23 kJ/m ²	ISO 179/1eA

Thermal properties

Temp. of deflection under load, 1.8 MPa	270 °C	ISO 75-1/-2
Temp. of deflection under load, 8 MPa	240 °C	ISO 75-1/-2

Other properties

Density	1650 kg/m ³	ISO 1183
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Injection

Drying Temperature	130 - 140 °C	
Drying Time, Dehumidified Dryer	3 - 4 h	
Processing Moisture Content	0.02 %	
Melt Temperature Optimum	305 °C	Internal
Max. mould temperature	140 - 160 °C	

Processing Texts

Pre-drying FORTRON should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be ≤ -30°C. The time between drying and processing should be as short as possible.

Longer pre-drying times/storage For subsequent storage the material should be stored dry in the dryer until processed (≤ 60 h).

