

CELSTRAN® PPS-GF40-01 AF3001 Natural

40% long strand fiber glass reinforced polyphenylene sulfide. UL-V0 flame retardant.
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Typical mechanical properties

Tensile Modulus	15000 MPa	ISO 527-1/-2
Stress at break, 5mm/min	160 MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.2 %	ISO 527-1/-2
Flexural Modulus	14500 MPa	ISO 178
Flexural Strength	272 MPa	ISO 178
Charpy notched impact strength, 23°C	33 kJ/m ²	ISO 179/1eA

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 %
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).

