

Fortron® 4332L6

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron 4332L6 is a glass fiber/mineral filled injection molding grade, which is intended for applications requiring improved tensile and flexural properties, when compared to other GF/MIN reinforced PPS grades. The recommended processing parameters are similar to the standard grades.

General Information			
UL YellowCard	E107854-237745		
Filler / Reinforcement	Glass\Mineral		
RoHS Compliance	Contact Manufacturer		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.95	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	0.30 to 0.70	%	
Flow	0.20 to 0.60	%	
Water Absorption (Saturation, 23°C)	0.020	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	21500	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	160	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.2	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	21000	MPa	ISO 178
Flexural Stress (23°C)	260	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	30	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, Unannealed	270	°C	ISO 75-2/A
8.0 MPa, Unannealed	220	°C	ISO 75-2/C
CLTE			ISO 11359-2
Flow	1.4E-5	cm/cm/°C	
Transverse	3.1E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Processing (Melt) Temp	320 to 340	°C	
Mold Temperature	140	°C	
Screw L/D Ratio	15.0:1.0 to 25.0:1.0		

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