

Fortron® CES50

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron CES50 is a 40% glass fiber reinforced material with a total chlorine content less than or equal to 900 ppm. It offers excellent physical properties similar to those of the Fortron 1140L6 product.

General Information			
UL YellowCard	E107854-101162913		
Filler / Reinforcement	Glass fiber reinforced material, 40% filler by weight		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.63	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	13900	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	170	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.9	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	13300	MPa	ISO 178
Flexural Stress (23°C)	240	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	9.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	51	kJ/m ²	ISO 179
Notched Izod Impact (23°C)	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	44	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	262	°C	ISO 75-2/A
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.5E-5	cm/cm/°C	ISO 11359-2
Lateral	5.0E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+14	ohms	IEC 60093
Volume Resistivity	> 1.0E+16	ohms · cm	IEC 60093
Dielectric Strength	30	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	4.50		IEC 60250
Dissipation Factor (1 MHz)	1.0E-3		IEC 60250
Comparative Tracking Index	125	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.200 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	130 - 140	°C	

Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	0.020	%
Hopper Temperature	20.0 - 30.0	°C
Rear Temperature	290 - 300	°C
Middle Temperature	310 - 320	°C
Front Temperature	330 - 340	°C
Nozzle Temperature	310 - 330	°C
Processing (Melt) Temp	330 - 340	°C
Mold Temperature	60.0 - 80.0	°C
Injection Pressure	50.0 - 100	MPa
Holding Pressure	30.0 - 70.0	MPa
Back Pressure	0.00 - 3.00	MPa

Injection instructions

Feed Temperature: 60 to 80°C Zone 4 Temperature: 330 to 340°C Manifold Temperature: 330 to 340°C

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Recommended distributors for this material

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