

Celstran® PPS-GF50-01 AD3002 Black

Polyphenylene Sulfide

Celanese Corporation

Message:

50% long strand glass fiber reinforced polyphenylene sulfide

General Information			
UL YellowCard	E113269-237797		
Filler / Reinforcement	Long glass fiber, 50% filler by weight		
Features	Flame retardancy		
RoHS Compliance	Contact manufacturer		
Appearance	Black		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.72	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow	0.10 - 0.20	%	ASTM D955
Transverse flow	0.30 - 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-40°C	21400	MPa	ASTM D638
23°C	20200	MPa	ASTM D638
--	19000	MPa	ISO 527-2/1A/1
Tensile Strength			
Fracture, -40°C	180	MPa	ASTM D638
Fracture, 23°C	177	MPa	ASTM D638
Fracture	165	MPa	ISO 527-2/1A/5
Tensile Elongation			
Fracture, -40°C	0.95	%	ASTM D638
Fracture, 23°C	1.0	%	ASTM D638
Fracture	1.0	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	18500	MPa	ISO 178
Flexural Stress (23°C)	280	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	28	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	282	°C	ASTM D648, ISO 75-2/A
Injection	Nominal Value	Unit	Test Method
Drying Temperature	130 - 140	°C	
Drying Time	3.0 - 4.0	hr	

Suggested Max Moisture	0.020	%
Hopper Temperature	70.0 - 80.0	°C
Rear Temperature	285 - 295	°C
Middle Temperature	290 - 300	°C
Front Temperature	295 - 305	°C
Nozzle Temperature	290 - 300	°C
Processing (Melt) Temp	300 - 310	°C
Mold Temperature	140 - 160	°C

Injection instructions

Zone 4 Temperature: 300 to 310°C Feed Temperature: 20 to 50°C

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