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# FORTRON<sup>®</sup> FX515T1

## Polyphenylene sulfide

Fortron® FX515T1 is a 15% glass filled, impact modified PPS grade with good impact resistance suitable for injection molding and food contact applications

Product information Resin Identification Part Marking Code	PPS-GF15 >PPS-GF15<		ISO 1043 ISO 11469
Rheological properties Moulding shrinkage, parallel Moulding shrinkage, normal	0.6 0.3		ISO 294-4, 2577 ISO 294-4, 2577
Typical mechanical properties Tensile modulus Tensile stress at break, 5mm/min Tensile strain at break, 5mm/min Flexural modulus Flexural modulus Flexural strength Flexural strength Flexural strain at failure Charpy impact strength, 23°C Charpy notched impact strength, 23°C Poisson's ratio [C]: Calculated	2.1 5800 150 3.1 40	MPa % MPa MPa	ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 178 ISO 178 ISO 178 ISO 179/1eU ISO 179/1eA
Thermal properties Temperature of deflection under load, 1.8 MPa	220	°C	ISO 75-1/-2
Physical/Other properties Density	1370	kg/m³	ISO 1183
Injection Drying Recommended Drying Temperature Drying Time, Dehumidified Dryer Processing Moisture Content Melt Temperature Optimum Min. melt temperature Max. melt temperature Screw tangential speed Mold Temperature Optimum Min. mould temperature Max. mould temperature Hold pressure range Back pressure Ejection temperature	160 30 - 70	h % °C °C °C m/s °C °C °C MPa MPa	

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### Polyphenylene sulfide

#### Characteristics

Processing Special characteristics

#### Injection Moulding, Extrusion High impact or impact modified

#### Additional information

**Processing Notes** 

#### **Pre-Drying**

Fortron should be pre-dried. Because of the necessary low maximum residual moisture content, the use of dry air dryers is recommended. The dew point should be </=-30 deg C. the time between drying and processing should be as short as possible. Normal drying time is 3-4 hrs at 121 deg C but for drying overnight temp should be reduced to 90 deg C.

### Automotive

OEM Renault

#### ADDITIONAL INFORMATION

UB02b, No Spec, Special Part Approval, See Your CE Account Manager.

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