

# FORTRON<sup>®</sup> FX75T1

## Polyphenylene sulfide

Fortron® FX75T1 is an unreinforced, impact-modified poly(phenylene sulfide) with high melt viscosity suitable for extrusion.

Product information Resin Identification Part Marking Code	PPS >PPS<		ISO 1043 ISO 11469
Rheological properties Moulding shrinkage, parallel Moulding shrinkage, normal	1.9 2.1		ISO 294-4, 2577 ISO 294-4, 2577
Thermal mechanical properties Tensile modulus Tensile stress at break, 50mm/min Tensile strain at break, 50mm/min Flexural modulus Flexural stress at 3.5% Charpy notched impact strength, 23°C Charpy notched impact strength, -30°C Poisson's ratio [OT]: One time tested [C]: Calculated	42 80 1600 50 70 <sup>[OT]</sup>	MPa MPa MPa KJ/m <sup>2</sup> kJ/m <sup>2</sup>	ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 178 ISO 178 ISO 179/1eA ISO 179/1eA
Thermal properties Temperature of deflection under load, 1.8 MPa Vicat softening temperature, 50°C/h 50N Vicat softening temperature, 50°C/h 10N Coefficient of linear thermal expansion (CLTE), parallel Coefficient of linear thermal expansion (CLTE), normal Thermal conductivity, flow Thermal conductivity, through plane Effective thermal diffusivity, through plane Effective thermal diffusivity, through plane Specific heat capacity of melt [OT]: One time tested [1]: Ref: AL-014114, data by Tony Yu	120 270 98 122 0.332 <sup>[OT]</sup> 0.346 <sup>[OT]</sup> 1.65E-7 <sup>[OT]</sup> 1.73E-7 <sup>[OT, 1]</sup>	°C E-6/K E-6/K W/(m K) W/(m K) m <sup>2</sup> /s	ISO 75-1/-2 ISO 306 ISO 306 ISO 11359-1/-2 ISO 11359-1/-2 ISO 22007-2 ISO 22007-2 ISO 22007-4 ISO 22007-4 ISO 22007-4
Electrical properties Relative permittivity, 1MHz Dissipation factor, 1MHz Volume resistivity		E-4 Ohm.m	IEC 62631-2-1 IEC 62631-2-1 IEC 62631-3-1

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ISO 1183

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### Polyphenylene sulfide

# Physical/Other properties

Density	1200	kg/m³
Injection		
Drying Recommended	yes	
Drying Temperature	130	°C
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.02	%
Melt Temperature Optimum	330	°C
Min. melt temperature	310	°C
Max. melt temperature	340	°C
Screw tangential speed	0.2 - 0.3	m/s
Mold Temperature Optimum	120	°C
Min. mould temperature	80	°C
Max. mould temperature	160	°C
Hold pressure range	30 - 70	MPa
Back pressure	3.5	MPa

#### Characteristics

Processing	Injection Moulding, Extrusion, Blow Moulding
Special characteristics	High impact or impact modified

#### Additional information

Injection molding

#### Processing

Drying - alternate 80°C, approx. 6 hours

### Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
General Motors	GMW17769P-PPS-T2	Black
General Motors	GMW17769P-PPS-T2	Natural

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