

Celstran® PPS-GF40-01 AD3002 Black

Polyphenylene Sulfide
Celanese Corporation

Message:
40% long strand fiber glass reinforced polyphenylene sulfide

General Information			
Filler / Reinforcement	Long glass fiber, 40% filler by weight		
Additive	Flame retardancy		
Features	Flame retardancy		
RoHS Compliance	Contact manufacturer		
Appearance	Black		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.62	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow	0.20 - 0.30	%	ASTM D955
Transverse flow	0.40 - 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			ASTM D638
-40°C	17800	MPa	ASTM D638
23°C	16800	MPa	ASTM D638
149°C	8620	MPa	ASTM D638
204°C	7930	MPa	ASTM D638
Tensile Strength			ASTM D638
Fracture, -40°C	179	MPa	ASTM D638
Fracture, 23°C	176	MPa	ASTM D638
Fracture, 149°C	84.1	MPa	ASTM D638
Fracture, 204°C	59.3	MPa	ASTM D638
Tensile Elongation			ASTM D638
Fracture, -40°C	1.2	%	ASTM D638
Fracture, 23°C	1.2	%	ASTM D638
Fracture, 149°C	1.4	%	ASTM D638
Fracture, 204°C	1.3	%	ASTM D638
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	279	°C	ASTM D648
Injection	Nominal Value	Unit	
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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

