

FORTRON® FX4330T7 | PPS | Impact Modified

Description

FX4330T7 is a 30% glass-fiber reinforced, impact modified injection molding grade offering high flow. Recommended processing conditions are identical to standard filled grades.

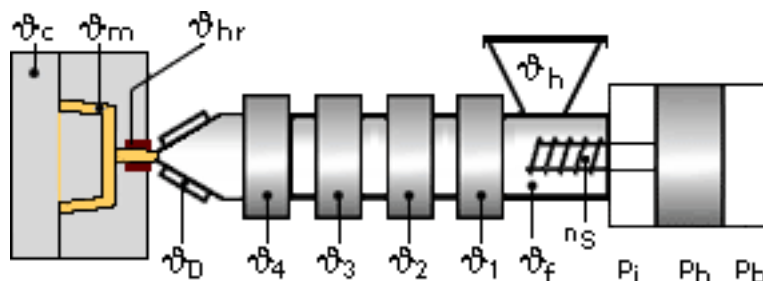
Physical properties	Value	Unit	Test Standard
Density	1470	kg/m ³	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	9800	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	137	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	1.9	%	ISO 527-2/1A
Flexural modulus (23°C)	9000	MPa	ISO 178
Flexural strength (23°C)	200	MPa	ISO 178
Unnotched impact str (Izod) @ 23°C	48	kJ/m ²	ISO 180/1U
Notched impact strength (Izod) @ 23°C	10.0	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
DTUL @ 1.8 MPa	265	°C	ISO 75-1/-2

Rheological Calculation properties	Value	Unit	Test Standard
Density of melt	1300	kg/m ³	Internal

Typical injection moulding processing conditions



Pre Drying:

Yes

Drying time: 3-4 h

Drying temperature: 110 - 120 °C

Temperature:

	ϕManifold	ϕMold	ϕMelt	ϕNozzle	ϕZone4	ϕZone3	ϕZone2	ϕZone1	ϕFeed	ϕHopper
min (°C)	320	140	320	310	330	330	310	290	60	20
max (°C)	340	160	340	330	340	340	320	300	80	30

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Pressure:

	Inj press	Hold press	Back pressure
min (bar)	500	300	0
max (bar)	1000	700	30

Speed:

Injection speed: fast

Screw speed

Screw diameter (mm)	16	25	40	55	75
Screw speed (RPM)	-	125	75	50	-

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General Disclaimer

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Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use.

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