

Fortron® 1140L0

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron 1140L0 is a 40% glass-reinforced extrusion grade. It exhibits excellent heat and chemical resistance, good electrical properties and is inherently flame-retardant. The high hardness and rigidity at elevated temperatures allows for good load bearing performance. This product has good weldability due to the modest filler level. 1140L0 is used to produce rods and slabs.

General Information			
UL YellowCard	E107854-237735	E107854-237738	
Filler / Reinforcement	Glass fiber reinforced material, 40% filler by weight		
Features	Good electrical performance		
	Good chemical resistance		
	Heat resistance, high		
	Flame retardancy		
RoHS Compliance	Contact manufacturer		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.65	g/cm³	ISO 1183
Water Absorption (Saturation, 23°C)	0.020	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	185	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.9	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	14000	MPa	ISO 178
Flexural Stress ¹	280	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	10	kJ/m²	ISO 179/1eA
23°C	10	kJ/m²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature ²	90.0	°C	ISO 11357-2
Melting Temperature ³	280	°C	ISO 11357-3
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
0.380 mm	V-0		UL 94
1.50 mm	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	130 - 140	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	

Hopper Temperature	20.0 - 30.0	°C
Rear Temperature	290 - 300	°C
Middle Temperature	310 - 320	°C
Front Temperature	330 - 340	°C
Nozzle Temperature	310 - 330	°C
Processing (Melt) Temp	330 - 340	°C
Mold Temperature	140 - 160	°C
Injection Pressure	50.0 - 100	MPa
Injection Rate	Fast	
Holding Pressure	30.0 - 70.0	MPa
Back Pressure	0.00 - 3.00	MPa

Injection instructions

Manifold Temperature: 330 to 340°C Zone 4 Temperature: 330 to 340°C Feed Temperature: 60 to 80°C

NOTE

1. Break
2. 10°C/min
3. 10°C/min

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