

Fortron® 1131L4 ITT

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron® 1131L4 ITT is a polyphenylene sulfide (PPS) product, which contains a 30% glass fiber reinforced material. It is available in North America, Africa and the Middle East, Latin America or Europe. The main characteristics are: flame retardant/rated flame.

General Information			
UL YellowCard	E107854-237734		
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.40	g/cm ³	ASTM D792
--	1.56	g/cm ³	ISO 1183
Specific Volume	0.715	cm ³ /g	ASTM D792
Molding Shrinkage			
Flow	1.0	%	ASTM D955
Transverse flow	0.80	%	ASTM D955
Vertical flow direction	0.50 - 0.80	%	ISO 294-4
Flow direction	0.30 - 0.70	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.020	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class m	93		ASTM D785
M scale	100		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	12200	MPa	ISO 527-2/1A/1
Tensile Strength			
Fracture, 23°C	86.2	MPa	ASTM D638
Fracture	165	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.9	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	12000	MPa	ISO 178
Flexural Stress ¹	255	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	8.0	kJ/m ²	ISO 179/1eA
23°C	8.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	42	kJ/m ²	ISO 179/1eU

23°C	42	kJ/m ²	ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-30°C	8.0	kJ/m ²	ISO 180/1A
23°C	8.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, annealed	200	°C	ASTM D648
1.8 MPa, not annealed	105	°C	ASTM D648
1.8 MPa, not annealed	265	°C	ISO 75-2/A
8.0 MPa, not annealed	205	°C	ISO 75-2/C
Glass Transition Temperature ²	90.0	°C	ISO 11357-2
Melting Temperature ³	280	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	2.9E-5	cm/cm/°C	ISO 11359-2
Lateral	6.2E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity			
--	1.0E+16	ohms · cm	ASTM D257
--	> 1.0E+15	ohms · cm	IEC 60093
Dielectric Constant			ASTM D150
1 kHz	3.00		ASTM D150
1 MHz	3.00		ASTM D150
Dissipation Factor			ASTM D150
1 kHz	1.0E-3		ASTM D150
1 MHz	9.0E-3		ASTM D150
Arc Resistance	124	sec	ASTM D495
Flammability	Nominal Value	Unit	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°CZone 4 Temperature: 330 to 340°CFeed Temperature: 60 to 80°C

NOTE

1.	Break
2.	10°C/min
3.	10°C/min

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