

Fortron® MT9140L6

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron MT9140L6 is a 40% glass fiber reinforced injection molding grade with a low melt viscosity. It exhibits excellent heat and chemical resistance, inherent flame retardancy and shows high hardness and rigidity at elevated temperatures. Fortron MT9140L6 is used for thin walled parts with long flow lengths.

Components made of this grade may be used for medical, dental, pharmaceutical, and certain food handling applications. Fortron MT9140L6 is in compliance with ISO 10993, USP Class VI, and is included in the Fortron Drug and Device Master Files at the FDA. It complies with the FDA Food Contact Notification (FCN-No. 40) for repeat-use applications.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 40% filler by weight		
Features	Low viscosity		
	Rigidity, high		
	Good chemical resistance		
	Heat resistance, high		
	Compliance of Food Exposure		
	High hardness		
	Flame retardancy		
Uses	Thin wall parts		
	Non-specific food applications		
	Drug		
	Medical/nursing supplies		
Agency Ratings	FDA FCN 40		
	ISO 10993		
	USP Class VI		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.65	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.40 - 0.60	%	ISO 294-4
Flow direction	0.20 - 0.60	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.020	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	100		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	190	MPa	ISO 527-2/1A/5

Tensile Strain (Break)	1.8	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	14000	MPa	ISO 178
Flexural Stress (23°C)	280	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	9.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	48	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	32	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, not annealed	270	°C	ISO 75-2/A
8.0 MPa, not annealed	200	°C	ISO 75-2/C
Glass Transition Temperature ¹	90.0	°C	ISO 11357-2
Melting Temperature ²	280	°C	ISO 11357-3
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.	10°C/min		
2.	10°C/min		

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