

Fortron® 6345L4

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron 6345L4 is 30% glass fiber/high PTFE reinforced injection molding grade. This grade, available in natural and black color, exhibits improved wear and sliding properties versus 1342L4 product.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	PTFE lubricant		
Features	Low friction coefficient		
	Good wear resistance		
RoHS Compliance	Contact manufacturer		
Appearance	Black		
	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.66	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.60 - 0.90	%	ISO 294-4
Flow direction	0.30 - 0.50	%	ISO 294-4
Water Absorption (Equilibrium, 23°C, 50% RH)	0.020	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	150	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.9	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	10600	MPa	ISO 178
Flexural Stress (23°C)	230	MPa	ISO 178
Coefficient of Friction			ASTM D1894
Dynamic ¹	0.28		ASTM D1894
Dynamic ²	0.28		ASTM D1894
Static ³	0.30		ASTM D1894
Static ⁴	0.29		ASTM D1894
With steel-dynamic ⁵	0.15		ASTM D1894
With steel-static ⁶	0.17		ASTM D1894
Wear Factor ⁷			ASTM D3702
416 Stainless : 32°C	148	10 ⁻¹⁰ in ³ ·min/ft·lb·hr	ASTM D3702
C-1018 Steel : 49°C	120	10 ⁻¹⁰ in ³ ·min/ft·lb·hr	ASTM D3702
C-1018 Steel : 93°C	415	10 ⁻¹⁰ in ³ ·min/ft·lb·hr	ASTM D3702

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	9.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, not annealed	260	°C	ISO 75-2/A
8.0 MPa, not annealed	190	°C	ISO 75-2/C
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.	vs Fortron 1140L4, 73°F, 5 lbf, 5 in		
2.	vs Fortron 6165A4, 73°F, 5 lbf, 5 in		
3.	vs Fortron 6165A4, 73°F, 5 lbf, 5 in		
4.	vs Fortron 1140L4, 73°F, 5 lbf, 5 in		
5.	73°F, 5 lbf, 5 in		
6.	73°F, 5 lbf, 5 in		
7.	16 μ-in, PV2000, 40 psi, 50ft/min		

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