

Fortron® MT9141L4 DW

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron MT9141L4 DW is a 40% glass-reinforced PPS that has excellent heat and chemical resistance, inherently flame-retardant, high hardness and a good balance of strength and stiffness. This grade exhibits low flash and is typically used in applications with thicker walls and shorter flow lengths.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 40% filler by weight		
Features	Rigid, good		
	Good strength		
	Good chemical resistance		
	High hardness		
	Flame retardancy		
RoHS Compliance	Contact manufacturer		
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
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	15500	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	195	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.9	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	14800	MPa	ISO 178
Flexural Stress ¹	290	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	12	kJ/m ²	ISO 179/1eA
23°C	12	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	53	kJ/m ²	ISO 179/1eU
23°C	53	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	270	°C	ISO 75-2/A
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°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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

