

Fortron® 1120L4

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron 1120L4 is a 20% glass fiber reinforced injection molding grade exhibiting excellent heat and chemical resistance, inherent flame retardancy, high hardness and stiffness at elevated temperatures.

General Information			
UL YellowCard	E107854-237731		
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Features	Rigidity, high		
	Good chemical resistance		
	Heat resistance, high		
	High hardness		
	Flame retardancy		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.47	g/cm ³	ASTM D792
--	1.48	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.70 - 1.0	%	ISO 294-4
Flow direction	0.30 - 0.60	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.020	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class m	102		ASTM D785
M scale	100		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Fracture, 23°C	126	MPa	ASTM D638
Fracture	120	MPa	ISO 527-2/1A/5
Tensile Elongation			
Fracture, 23°C	1.8	%	ASTM D638
Fracture	1.5	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	8000	MPa	ISO 178
Flexural Stress (23°C)	170	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact (23°C)	7.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	35	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, annealed	280	°C	ASTM D648
1.8 MPa, not annealed	260	°C	ASTM D648
1.8 MPa, not annealed	255	°C	ISO 75-2/A
Linear thermal expansion coefficient			ISO 11359-2
Flow	2.6E-5	cm/cm/°C	ISO 11359-2
Lateral	5.3E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value		Test Method
Flame Rating (1.60 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

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