

Fortron® 6341L4

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron 6341L4 is a tribological-modified Fortron® -PPS containing 40% glass fibre. Fortron 6341L4 comprises the same mechanical properties like Fortron 1342L4, but with a different tribological adjustment.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 40% filler by weight		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.70	g/cm ³	ISO 1183
Water Absorption (Saturation, 23°C)	0.020	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	14400	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	165	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.6	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	13700	MPa	ISO 178
Flexural Stress ¹	245	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	40	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	8.0	kJ/m ²	ISO 180/1A
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	215	°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	2.0E-5	cm/cm/°C	ISO 11359-2
Lateral	4.0E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	130 - 140	°C	
Drying Time	3.0 - 4.0	hr	
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
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

NOTE

1.	Break
2.	10°C/min
3.	10°C/min

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