

FORTRON® 6345L4 - PPS

Description

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.

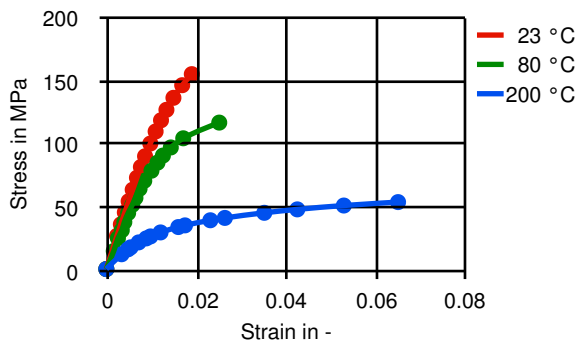
Physical properties	Value	Unit	Test Standard
Density	1660	kg/m ³	ISO 1183
Molding shrinkage, parallel	0.3 - 0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 - 0.9	%	ISO 294-4, 2577
Humidity absorption, 23°C/50%RH	0.02	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile stress at break, 5mm/min	150	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	1.9	%	ISO 527-2/1A
Flexural modulus, 23°C	10600	MPa	ISO 178
Flexural strength, 23°C	230	MPa	ISO 178
Izod impact notched, 23°C	9	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
DTUL at 1.8 MPa	260	°C	ISO 75-1, -2
DTUL at 8.0 MPa	190	°C	ISO 75-1, -2

Diagrams

True Stress-strain



Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0.02	%	-
Drying time	3 - 4	h	-
Drying temperature	130 - 140	°C	-
Temperature	Value	Unit	Test Standard
Hopper temperature	20 - 30	°C	-
Feeding zone temperature	60 - 80	°C	-
Zone1 temperature	290 - 300	°C	-
Zone2 temperature	310 - 320	°C	-
Zone3 temperature	330 - 340	°C	-
Zone4 temperature	330 - 340	°C	-
Nozzle temperature	310 - 330	°C	-
Melt temperature	330 - 340	°C	-
Mold temperature	140 - 160	°C	-
Hot runner temperature	330 - 340	°C	-

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	Value	Unit	Test Standard
Pressure			
Back pressure max.	30	bar	-
Speed			
Injection speed	fast	-	-
Screw Speed			
Screw speed diameter, 25mm	120	RPM	-
Screw speed diameter, 40mm	75	RPM	-
Screw speed diameter, 55mm	50	RPM	-

Other text information

Pre-drying

FORTRON should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be $\leq -30^{\circ}\text{C}$. The time between drying and processing should be as short as possible.

Longer pre-drying times/storage

For subsequent storage the material should be stored dry in the dryer until processed (≤ 60 h).

Characteristics

Product Categories

Specialty

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General Disclaimer

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