

ISO 1183

FORTRON® 6345L4

Polyphenylene sulfide

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

Product information

Resin Identification	PPS-GF30		ISO 1043
Part Marking Code	>PPS-GF30<		ISO 11469
Rheological properties			
Moulding shrinkage range, parallel	0.3 - 0.5	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.6 - 0.9	%	ISO 294-4, 2577
Typical mechanical properties			
Tensile stress at break, 5mm/min	150	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.9	%	ISO 527-1/-2
Flexural modulus	10600	MPa	ISO 178
Flexural strength		MPa	ISO 178
Compressive strength		MPa	ISO 604
Izod notched impact strength, 23°C	9	kJ/m²	ISO 180/1A
Thermal properties			
Temperature of deflection under load, 1.8 MPa	260	°C	ISO 75-1/-2
Temperature of deflection under load, 8 MPa	190	°C	ISO 75-1/-2
Physical/Other properties			
Humidity absorption, 2mm	0.02	%	Sim. to ISO 62

Injection

Density

Drying Recommended	yes	
Drying Temperature	130	°C
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.02	%
Melt Temperature Optimum	330	°C
Min. melt temperature	310	°C
Max. melt temperature	340	°C
Screw tangential speed	0.2 - 0.3	m/s
Mold Temperature Optimum	150	°C
Min. mould temperature	140	°C
Max. mould temperature	160	°C
Hold pressure range	30 - 70	MPa
Back pressure	3	MPa

Additional information

Processing Notes 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.

1660 kg/m³

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The dew point should be =< - 30 $^{\circ}$ C. The time between drying and processing should be as short as possible.

Storage

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

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