

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	230 MPa	ISO 178
Compressive strength	220 MPa	ISO 604
Izod notched impact strength, 23°C	9 kJ/m ²	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
Density	1660 kg/m ³	ISO 1183

Injection

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.

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The dew point should be $\leq -30^{\circ}\text{C}$. 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 ($\leq 60\text{ h}$).