Celanese
The chemistry inside innovation™

FORTRON® 4184L6 DW - PPS

Description

53% Mineral/Glass reinforced, high strength, easy flow, V-0
Fortron 4184L6 is an easier flow version of Fortron 4184L4. for drinking water applications. It offers similar characteristics to the 4184L4. This grade is especially used for thin walled parts requiring long flow lengths, stiffness and dimensional control. Applications made of this grade are typically electronic components.

Physical properties	Value	Unit	Test Standard
Density	**112**	lb/ft³	ISO 1183
Molding shrinkage, parallel (flow)	**0.3**	%	ISO 294-4, 2577
Molding shrinkage, transverse normal	**0.6**	%	ISO 294-4, 2577
Water absorption, 23°C-sat	**0.02**	%	Sim. to ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	**2.41E6**	psi	ISO 527-1, -2
Tensile stress at break, 5mm/min	**23900**	psi	ISO 527-1, -2
Tensile strain at break, 5mm/min	**1.4**	%	ISO 527-1, -2
Flexural modulus, 23°C	**2.35E6**	psi	ISO 178
Flexural stress at break	**36300**	psi	ISO 178
Charpy impact strength, 23°C	**13.8**	ft-lb/in²	ISO 179/1eU
Charpy impact strength, -30°C	**13.8**	ft-lb/in²	ISO 179/1eU
Charpy notched impact strength, 23°C	**3.33**	ft-lb/in²	ISO 179/1eA
Charpy notched impact strength, -30°C	**3.33**	ft-lb/in²	ISO 179/1eA
Izod impact notched, 23°C	**3.33**	ft-lb/in²	ISO 180/1A
Izod impact notched, -30°C	**3.33**	ft-lb/in²	ISO 180/1A
Izod impact unnotched, 23°C	**12.8**	ft-lb/in²	ISO 180/1U
Izod impact unnotched, -30°C	**12.8**	ft-lb/in²	ISO 180/1U
Compressive modulus	**2.35E6**	psi	ISO 604
Rockwell hardness (M-Scale)	**100**	M-Scale	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	**536**	°F	ISO 11357-1/-3
Glass transition temperature, 10°C/min	**194**	°F	ISO 11357-1,-2,-3
DTUL at 1.8 MPa	**518**	°F	ISO 75-1, -2
DTUL at 8.0 MPa	**419**	°F	ISO 75-1, -2
Coeff. of linear therm expansion, parallel	**0.133**	E-4/°F	ISO 11359-2
Coeff. of linear therm expansion, normal	**0.178**	E-4/°F	ISO 11359-2
Flammability @1.6mm nom. thickn.	**V-0**	class	UL 94
thickness tested (1.6)	**0.1**	in	UL 94
Flammability at thickness h	**V-0**	class	UL 94
thickness tested (h)	**0.0295**	in	UL 94

Electrical properties	Value	Unit	Test Standard
Dielectric constant (Dk), 1MHz	**4.7**	-	IEC 60250
Dissipation factor, 1MHz	**20**	E-4	IEC 60250
Volume resistivity, 23°C	**>1E13**	Ohm*m	IEC 62631-3-1
Surface resistivity, 23°C	**>1E15**	Ohm	IEC 62631-3-2
Electric strength, 23°C (AC)	**686**	kV/in	IEC 60243-1
Comparative tracking index	**PLC 4**	-	UL 746

Rheological calculation properties	Value	Unit	Test Standard
Spec. heat capacity melt	**1500**	J/(kg K)	Internal

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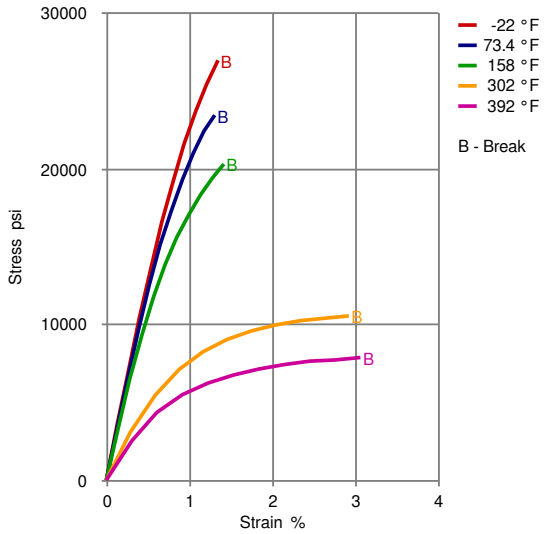
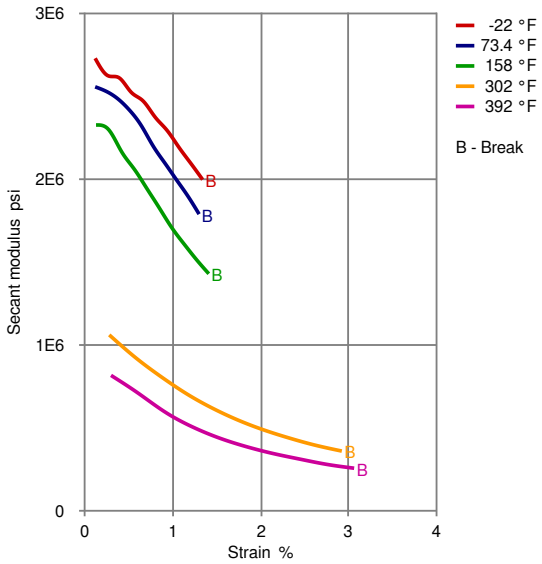
Diagrams

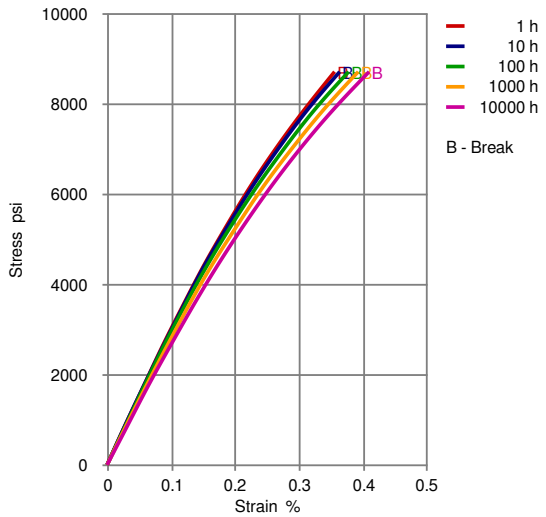
Stress-strain



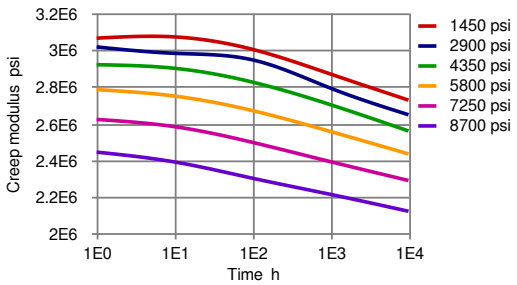
Secant modulus-strain



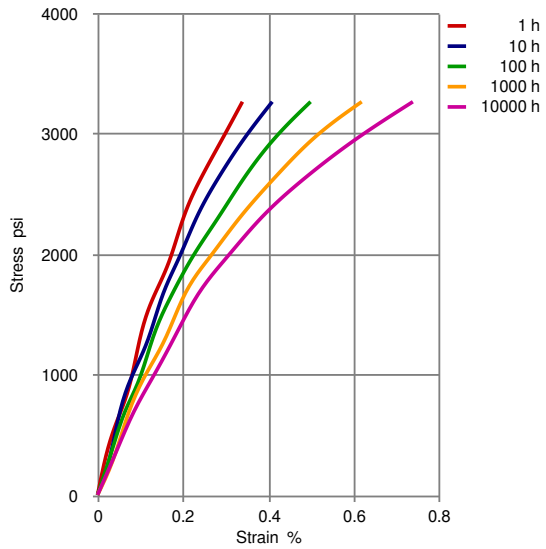
CAMPUS Stress-strain (isochronous) 73.4°F



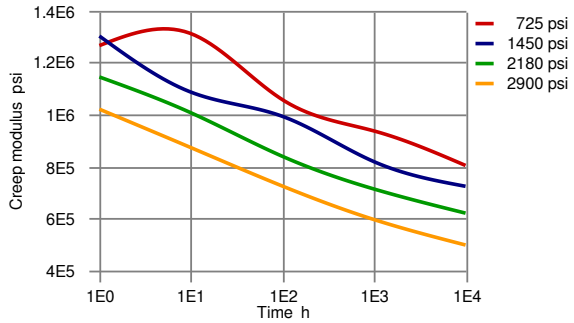
CAMPUS Creep modulus-time 73.4°F



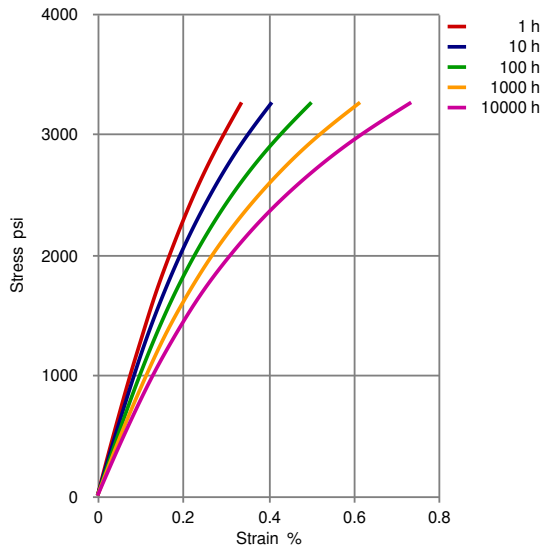
CAMPUS Stress-strain (isochronous) 248°F



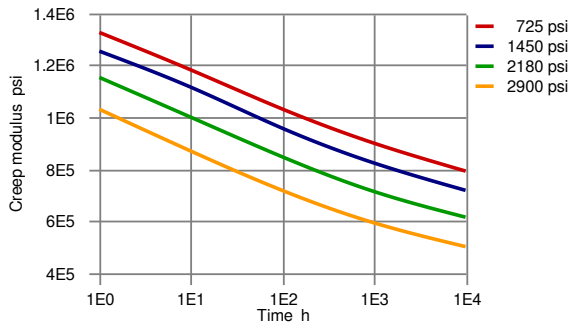
CAMPUS Creep modulus-time 248°F



CAMPUS Stress-strain (isochronous) 302°F



CAMPUS Creep modulus-time 302°F



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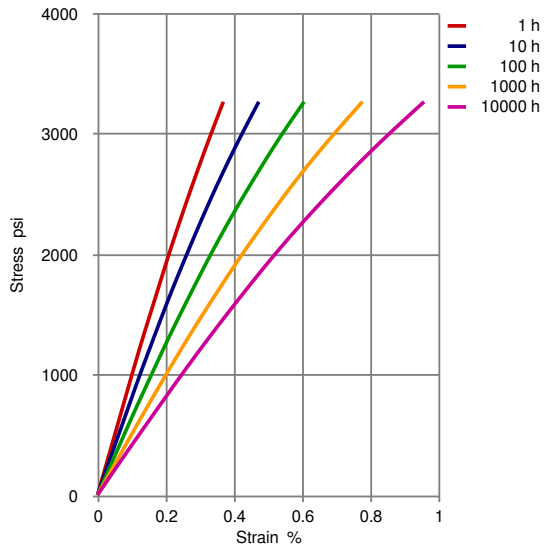
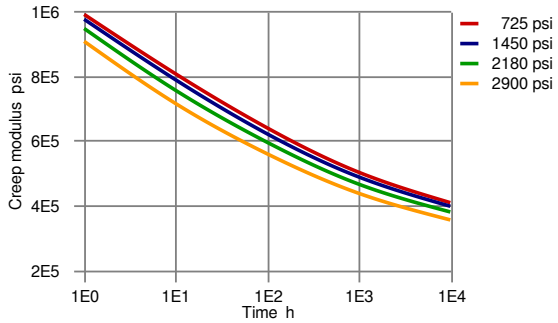
CAMPUS Stress-strain (isochronous) 392°F



CAMPUS Creep modulus-time 392°F



Typical injection moulding processing conditions

Pre Drying	Value	Unit
Necessary low maximum residual moisture content	**0.02**	%
Drying time	**3 - 4**	h
Drying temperature	**266 - 284**	°F

Temperature	Value	Unit
Hopper temperature	**68 - 86**	°F
Feeding zone temperature	**140 - 176**	°F
Zone1 temperature	**554 - 572**	°F
Zone2 temperature	**590 - 608**	°F
Zone3 temperature	**626 - 644**	°F
Zone4 temperature	**626 - 644**	°F
Nozzle temperature	**590 - 626**	°F
Melt temperature	**626**	°F
Mold temperature	**284 - 320**	°F
Hot runner temperature	**626 - 644**	°F

Pressure	Value	Unit
Back pressure max.	**30**	bar

Speed	Value
Injection speed	**fast**

Screw Speed	Value	Unit
Screw speed diameter, 25mm	**120**	RPM
Screw speed diameter, 40mm	**75**	RPM
Screw speed diameter, 55mm	**50**	RPM

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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 =< - 30° 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).

Injection molding

On injection molding machines with 15-25 D long three-section screws, as are usual in the trade, the FORTRON is processable. A shut-off nozzle is preferred to a free-flow nozzle.

Melt temperature 320-340 degC
Mold wall temperature at least 140 degC

A medium injection rate is normally preferred. All mold cavities must be effectively vented.

Injection Molding Preprocessing

Predrying in a dehumidified air dryer at 130 - 140 degC/3-4 hours is recommended.

Injection Molding Postprocessing

Tool temperature of at least 135 degC is recommended for parts to achieve maximum crystallizable potential.

Characteristics

Special Characteristics	Auto spec approved, Flame retardant, Heat resistant, High flow, Improved creep, Light stabilized
Product Categories	Mineral/Glass reinforced
Processing	Injection molding
Delivery Form	Pellets
Additives	Release agent