

FORTRON® 6165A6 - PPS

Description

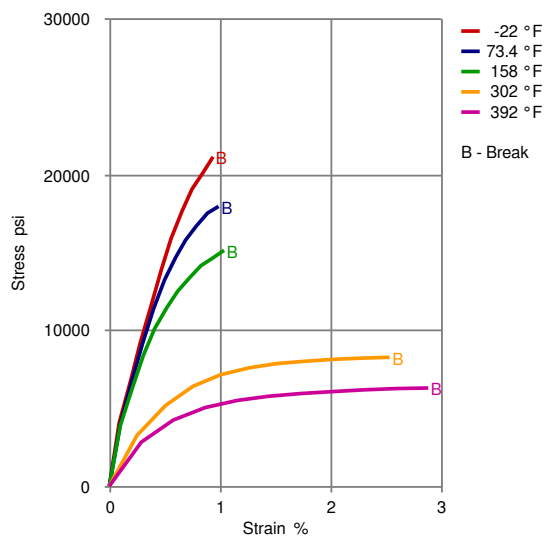
65% Mineral/Glass reinforced, easy flow, V-0

Fortron 6165A6 is an easier flow version of Fortron 6165A4. It offers similar characteristics to the 6165A4. Applications include electronic components (i.e. lamps housings and sockets) and mechanical components (i.e. pumps and pistons).

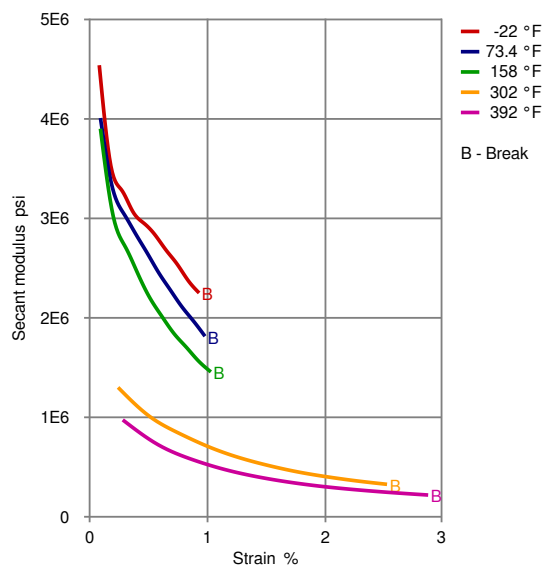
Physical properties	Value	Unit	Test Standard
Density	122	lb/ft ³	ISO 1183
Molding shrinkage, parallel (flow)	0.2	%	ISO 294-4, 2577
Molding shrinkage, transverse normal	0.5	%	ISO 294-4, 2577
Water absorption, 23°C-sat	0.02	%	Sim. to ISO 62
Mechanical properties	Value	Unit	Test Standard
Tensile modulus	2.83E6	psi	ISO 527-1, -2
Tensile stress at break, 5mm/min	19600	psi	ISO 527-1, -2
Tensile strain at break, 5mm/min	1.2	%	ISO 527-1, -2
Flexural modulus, 23°C	2.76E6	psi	ISO 178
Flexural stress at break	30500	psi	ISO 178
Charpy impact strength, 23°C	9.51	ft-lb/in ²	ISO 179/1eU
Charpy impact strength, -30°C	9.51	ft-lb/in ²	ISO 179/1eU
Charpy notched impact strength, 23°C	3.33	ft-lb/in ²	ISO 179/1eA
Charpy notched impact strength, -30°C	3.33	ft-lb/in ²	ISO 179/1eA
Izod impact notched, 23°C	2.85	ft-lb/in ²	ISO 180/1A
Izod impact notched, -30°C	2.85	ft-lb/in ²	ISO 180/1A
Izod impact unnotched, 23°C	9.51	ft-lb/in ²	ISO 180/1U
Izod impact unnotched, -30°C	9.51	ft-lb/in ²	ISO 180/1U
Compressive modulus	2.68E6	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	0.106	E-4/°F	ISO 11359-2
Coeff. of linear therm expansion, normal	0.133	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	5.6	-	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)	635	kV/in	IEC 60243-1
Comparative tracking index	PLC 2	-	UL 746
Rheological calculation properties	Value	Unit	Test Standard
Spec. heat capacity melt	1600	J/(kg K)	Internal



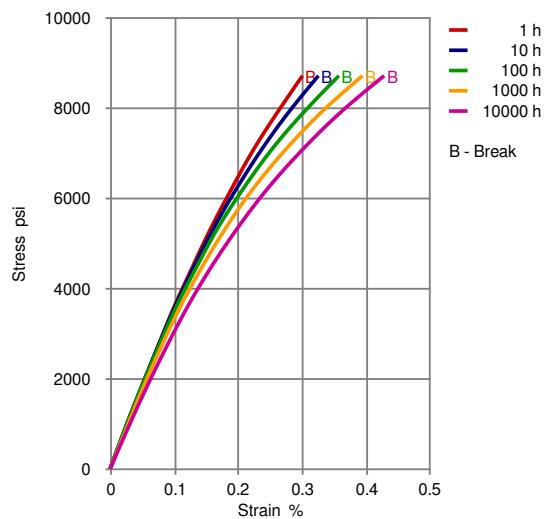
Stress-strain



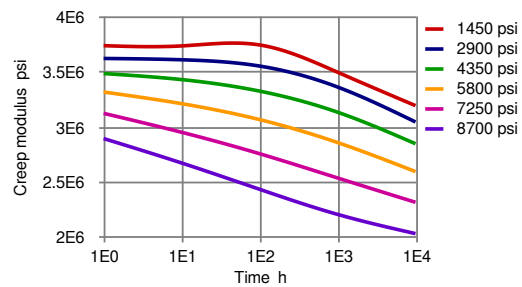
Secant modulus-strain

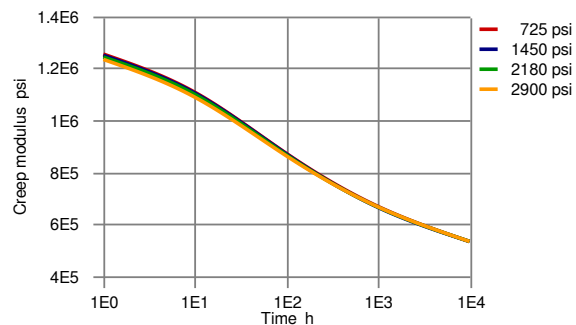
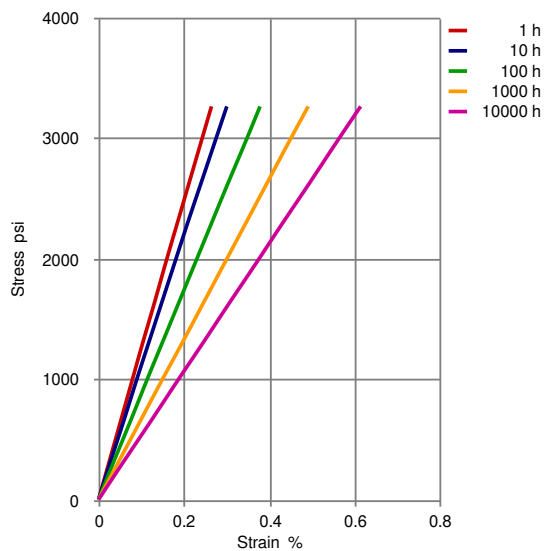
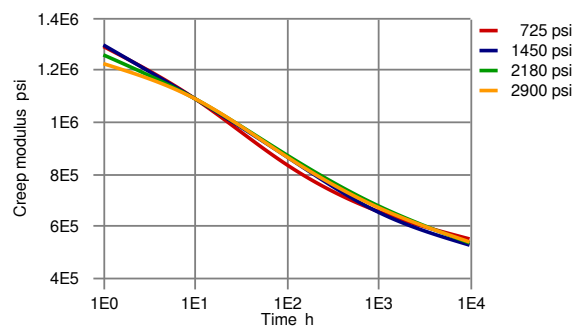
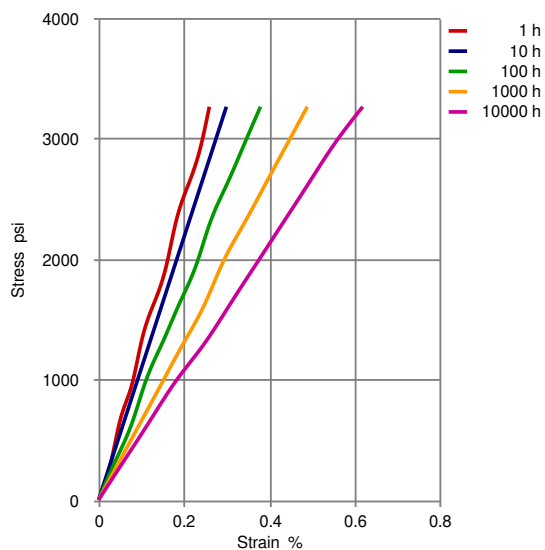


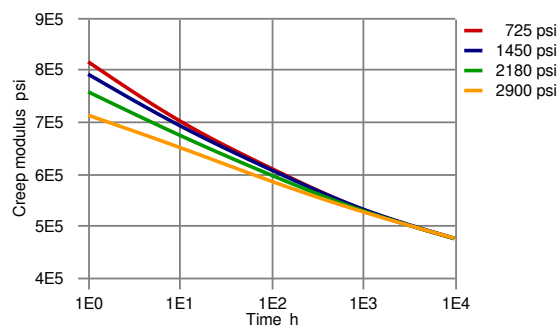
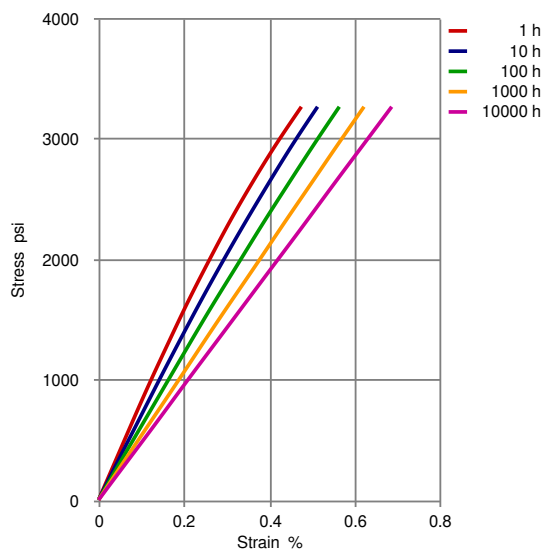
CAMPUS Stress-strain (isochronous) 73.4 °F



CAMPUS Creep modulus-time 73.4 °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 $\leq -30^{\circ}\text{C}$. 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 ($\leq 60\text{ h}$).

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, Chemical resistant, Flame retardant, Heat resistant, High flow, Light stabilized
Product Categories	Mineral/Glass reinforced
Processing	Injection molding
Regulatory	Drinking water approved
Delivery Form	Pellets
Additives	Release agent

Other Approvals

OEM	Specification	Additional Information
Continental	TST N 055 58.01	
Ford	WSF-M4D803-A2	
Mercedes-Benz Group (Daimler)	DBL 5404	Black

