

FORTRON® 6341L4 - PPS

Description

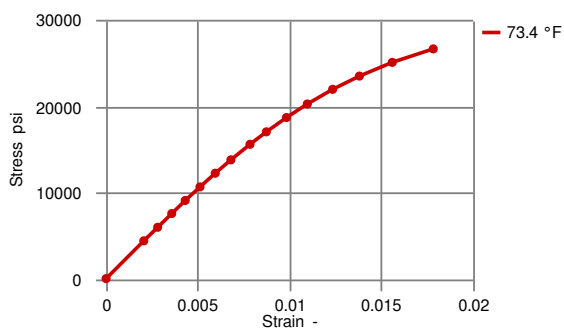
Specialty

Fortron 6341L4 is a tribological-modified Fortron®-PPS containing 40% glass fibre. Fortron 6341L4 comprises the same mechanical properties like Fortron 1342L4, but with a different tribological adjustment.

Physical properties	Value	Unit	Test Standard
Density	106	lb/ft ³	ISO 1183
Water absorption, 23°C-sat	0.02	%	Sim. to ISO 62
Mechanical properties	Value	Unit	Test Standard
Tensile modulus	2.09E6	psi	ISO 527-1, -2
Tensile stress at break, 5mm/min	23900	psi	ISO 527-1, -2
Tensile strain at break, 5mm/min	1.6	%	ISO 527-1, -2
Flexural modulus, 23°C	1.99E6	psi	ISO 178
Flexural stress at break	35500	psi	ISO 178
Charpy impact strength, 23°C	19	ft-lb/in ²	ISO 179/1eU
Charpy notched impact strength, 23°C	3.81	ft-lb/in ²	ISO 179/1eA
Izod impact notched, 23°C	3.81	ft-lb/in ²	ISO 180/1A
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	0.111	E-4/°F	ISO 11359-2
Coeff. of linear therm expansion, normal	0.222	E-4/°F	ISO 11359-2

Diagrams





Typical injection moulding processing conditions

Pre Drying

	Value	Unit
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 - 644	°F
Mold temperature	284 - 320	°F
Hot runner temperature	626 - 644	°F

Pressure

	Value	Unit
Back pressure max.	30	bar

Screw Speed

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

Characteristics

Special Characteristics	Wear resistant
Product Categories	Specialty, Tribological
Processing	Injection molding

