Celanese
The chemistry inside innovation™

FORTRON® 6850L6 - PPS

Description

50% Mineral/Glass reinforced, low warpage, good surface, V-0
Fortron 6850L6 offers the lowest warpage available. The easy flowing nature allows this product to be injection molded into thin walled applications. The excellent balance of mineral and glass fibers result in a superior heat resistance and dimensional stability. This grade is inherently flame-retardant along with high hardness and rigidity. Especially used for thin walled by unfavorable flow length-wall thickness ratio. This is the most isotropic grade available.

Physical properties	Value	Unit	Test Standard
Density	**112**	lb/ft³	ISO 1183
Molding shrinkage, parallel (flow)	**0.3 - 0.6**	%	ISO 294-4, 2577
Molding shrinkage, transverse normal	**0.4 - 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	**2.68E6**	psi	ISO 527-1, -2
Tensile stress at break, 5mm/min	**18100**	psi	ISO 527-1, -2
Tensile strain at break, 5mm/min	**1**	%	ISO 527-1, -2
Flexural modulus, 23 °C	**2.44E6**	psi	ISO 178
Flexural stress at break	**27600**	psi	ISO 178
Charpy impact strength, 23 °C	**7.61**	ft-lb/in²	ISO 179/1eU
Charpy impact strength, -30 °C	**7.61**	ft-lb/in²	ISO 179/1eU
Charpy notched impact strength, 23 °C	**1.9**	ft-lb/in²	ISO 179/1eA
Charpy notched impact strength, -30 °C	**1.9**	ft-lb/in²	ISO 179/1eA
Izod impact notched, 23 °C	**1.9**	ft-lb/in²	ISO 180/1A
Izod impact notched, -30 °C	**1.9**	ft-lb/in²	ISO 180/1A
Izod impact unnotched, 23 °C	**9.51**	ft-lb/in²	ISO 180/1U
Izod impact unnotched, -30 °C	**9.51**	ft-lb/in²	ISO 180/1U
Rockwell hardness (M-Scale)	**96**	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	**0.0833**	E-4/°F	ISO 11359-2
Coeff. of linear therm expansion, normal	**0.172**	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)	**0.0150**	in	UL 94

Electrical properties	Value	Unit	Test Standard
Dissipation factor, 1MHz	**10**	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 4**	-	UL 746

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

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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

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

Other	Value	Unit	Test Standard
Specimen thickness (shrinkage)	**0.125**	in	Internal

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).

Characteristics

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

Other Approvals

OEM	Specification
Continental	TST N 055 58.12