

FORTRON® 6341L4

Polyphenylene sulfide

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.

Product information

Resin Identification	PPS-GF40	ISO 1043
Part Marking Code	>PPS-GF40<	ISO 11469

Typical mechanical properties

Tensile modulus	14400 MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	160 MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.6 %	ISO 527-1/-2
Flexural modulus	13700 MPa	ISO 178
Flexural strength	240 MPa	ISO 178
Charpy impact strength, 23°C	40 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	8 kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	8 kJ/m ²	ISO 180/1A
Poisson's ratio	0.33 ^[C]	

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	280 °C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	90 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	270 °C	ISO 75-1/-2
Temperature of deflection under load, 8 MPa	215 °C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	20 E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	40 E-6/K	ISO 11359-1/-2

Physical/Other properties

Water absorption, 2mm	0.02 %	Sim. to ISO 62
Density	1700 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

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