FORTRON® 1115L0 - PPS

Description

Fortron® 1115L0 is a 15% fiberglass-reinforced grade of polyphenylene sulfide with high melt strength suitable for blow molding and extrusion applications. The recommended processing conditions are similar to those of our standard grades, except drying conditions are somewhat milder at 80 to 100 C for 3-4 hours.

Physical properties	Value	Unit	Test Standard
Density	**1440**	kg/m³	ISO 1183
Water absorption, 23°C-sat	**0,02**	%	ISO 62

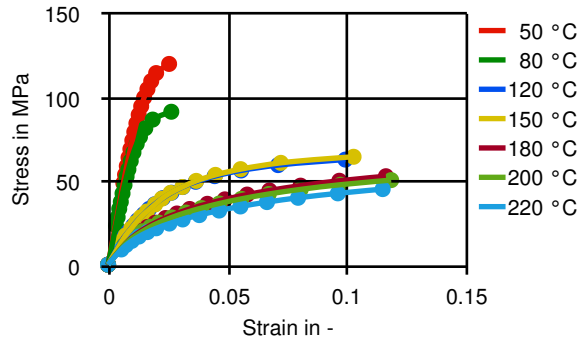
Mechanical properties	Value	Unit	Test Standard
Tensile modulus	**7700**	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	**120**	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	**2**	%	ISO 527-2/1A
Flexural modulus, 23°C	**7500**	MPa	ISO 178
Flexural strength, 23°C	**200**	MPa	ISO 178
Charpy impact strength, 23°C	**32**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	**5**	kJ/m²	ISO 179/1eA
Izod impact notched, 23°C	**5,2**	kJ/m²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
DTUL at 1.8 MPa	**220**	°C	ISO 75-1, -2
DTUL at 8.0 MPa	**115**	°C	ISO 75-1, -2
Flammability at thickness h	**V-0**	class	UL 94
thickness tested (h)	**0,75**	mm	UL 94

Electrical properties	Value	Unit	Test Standard
Surface resistivity	**>1E15**	Ohm	IEC 60093

Diagrams

True Stress-strain



Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	**0,02**	%	-
Drying time	**3 - 4**	h	-
Drying temperature	**100 - 140**	°C	-
Temperature	**Value**	**Unit**	**Test Standard**
Hopper temperature	**20 - 30**	°C	-
Feeding zone temperature	**60 - 80**	°C	-
Zone1 temperature	**290 - 300**	°C	-
Zone2 temperature	**310 - 320**	°C	-
Zone3 temperature	**330 - 340**	°C	-
Zone4 temperature	**330 - 340**	°C	-
Nozzle temperature	**310 - 330**	°C	-

Melt temperature	**330 - 340**	°C	-
Mold temperature	**140 - 160**	°C	-
Hot runner temperature	**330 - 340**	°C	-
Pressure	**Value**	**Unit**	**Test Standard**
Back pressure max.	**30**	bar	-
Speed	**Value**	**Unit**	**Test Standard**
Injection speed	**fast**	-	-
Screw Speed	**Value**	**Unit**	**Test Standard**
Screw speed diameter, 25mm	**120**	RPM	-
Screw speed diameter, 40mm	**75**	RPM	-
Screw speed diameter, 55mm	**50**	RPM	-

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

Product Categories

Specialty

Contact Information

Americas
8040 Dixie Highway
Florence, KY 41042 USA
Product Information Service
t: +1-800-833-4882
t: +1-859-372-3244
Customer Service
t: +1-800-526-4960
t: +1-859-372-3214
e: info-engineeredmaterials-am@celanese.com

Asia
4560 Jinke Road
Zhang Jiang Hi Tech Park
Shanghai 201203 PRC
Customer Service
t: +86 21 3861 9266
f: +86 21 3861 9599
e: info-engineeredmaterials-asia@celanese.com

Europe
Am Unisys-Park 1
65843 Sulzbach, Germany
Product Information Service
t: +49-800-86427-531
t: +49-(0)-69-45009-1011
e: info-engineeredmaterials-eu@celanese.com

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