

FORTRON® 6341L4 - PPS

Description

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.

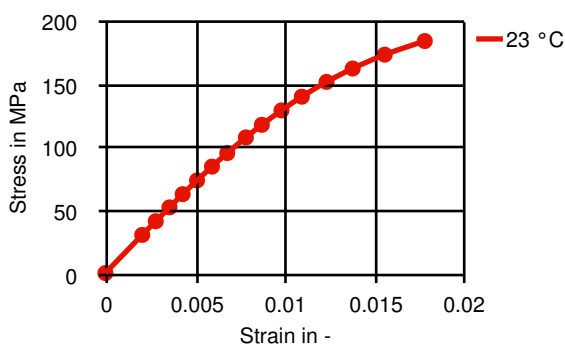
Physical properties	Value	Unit	Test Standard
Density	1700	kg/m ³	ISO 1183
Water absorption, 23°C-sat	0,02	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	14400	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	165	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	1,6	%	ISO 527-2/1A
Flexural modulus, 23°C	13700	MPa	ISO 178
Flexural stress at break	245	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 impact notched, 23°C	8	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	280	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	90	°C	ISO 11357-1,-2,-3
DTUL at 1.8 MPa	270	°C	ISO 75-1, -2
DTUL at 8.0 MPa	215	°C	ISO 75-1, -2
Coeff. of linear therm expansion, parallel	0,2	E-4/°C	ISO 11359-2
Coeff. of linear therm expansion, normal	0,4	E-4/°C	ISO 11359-2

Diagrams

True Stress-strain



Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Drying time	3 - 4	h	-
Drying temperature	130 - 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	-

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Pressure	Value	Unit	Test Standard
Back pressure max.	30	bar	-
Screw Speed	Value	Unit	Test Standard
Screw speed diameter, 25mm	120	RPM	-
Screw speed diameter, 40mm	75	RPM	-
Screw speed diameter, 55mm	50	RPM	-

Characteristics

Product Categories

Specialty

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