

FORTRON[®] 6345L4

Polyphenylene sulfide

Fortron 6345L4 is 30% glass fiber/high PTFE reinforced injection molding grade. This grade, available in natural color, exhibits improved wear and sliding properties versus 1342L4 product.

Product information Resin Identification Part Marking Code	PPS-GF30 >PPS-GF30<		ISO 1043 ISO 11469
Rheological properties			
Moulding shrinkage range, parallel Moulding shrinkage range, normal	0.3 - 0.5 0.6 - 0.9		ISO 294-4, 2577 ISO 294-4, 2577
Typical mechanical properties			
Tensile stress at break, 5mm/min Tensile strain at break, 5mm/min Flexural modulus Flexural strength Compressive strength Izod notched impact strength, 23°C	1.9 10600 230 220	MPa % MPa MPa kJ/m ²	ISO 527-1/-2 ISO 527-1/-2 ISO 178 ISO 178 ISO 604 ISO 180/1A
Thermal properties			
Temperature of deflection under load, Temperature of deflection under load,		°C °C	ISO 75-1/-2 ISO 75-1/-2
Physical/Other properties			
Humidity absorption, 2mm Density	0.02 1660	kg/m³	Sim. to ISO 62 ISO 1183
Injection			
Drying Recommended Drying Temperature Drying Time, Dehumidified Dryer Processing Moisture Content Melt Temperature Optimum Min. melt temperature Max. melt temperature Screw tangential speed Mold Temperature Optimum Min. mould temperature Max. mould temperature Hold pressure range Back pressure	2 - 4 ≤0.02 330 310 340 0.2 - 0.3 150 140 160 30 - 70	°C h % °C °C °C m/s °C °C °C °C	
Characteristics			
Processing	Injection Moulding		

Special characteristics

Flame retardant, Low wear / Low friction

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Additional information

Processing Notes

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.

Storage

For subsequent storage the material should be stored dry in the dryer until processed (<= 60 h).

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