Ticona
Performance Driven Solutions™

FORTRON® 1140E7 | PPS | Glass Reinforced

Description

Fortron 1140E7 is an inherently flame-retardant grade exhibiting extremely low flash and fast cycle times. It has excellent electrical properties, high hardness and stiffness. This grade exhibits good high-temperature load-bearing capabilities. It is especially used for thinner walled and longer flow length parts requiring low flash behavior. Good weldability due to a modest filler level. Commonly used in electrical connectors and and other thin wall/long flow length parts.

Physical properties	Value	Unit	Test Standard
Density	**1650**	kg/m³	ISO 1183
Mold shrinkage - parallel	**0.2 - 0.6**	%	ISO 294-4
Mold shrinkage - normal	**0.4 - 0.6**	%	ISO 294-4
Water absorption (23°C-sat)	**0.02**	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	**15700**	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	**150**	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	**1.2**	%	ISO 527-2/1A
Flexural modulus (23°C)	**15000**	MPa	ISO 178
Flexural stress @ break	**230**	MPa	ISO 178
Charpy impact strength @ 23°C	**28**	kJ/m²	ISO 179/1eU
Charpy impact strength @ -30°C	**28**	kJ/m²	ISO 179/1eU
Charpy notched impact strength @ 23°C	**7**	kJ/m²	ISO 179/1eA
Charpy notched impact strength @ -30°C	**7**	kJ/m²	ISO 179/1eA
Notched impact strength (Izod) @ 23°C	**7**	kJ/m²	ISO 180/1A
Notched impact strength (Izod) @-30°C	**7**	kJ/m²	ISO 180/1A
Rockwell hardness	**100**	M-Scale	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	**280**	°C	ISO 11357-1,-2,-3
Glass transition temperature (10°C/min)	**90**	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	**270**	°C	ISO 75-1/-2
DTUL @ 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)	**0.41**	E-4/°C	ISO 11359-2
Limiting oxygen index (LOI)	**47**	%	ISO 4589
Flammability @1.6mm nom. thickn.	**V-0**	class	UL94
thickness tested (1.6)	**1.5**	mm	UL94
Flammability at thickness h	**V-0**	class	UL94
thickness tested (h)	**0.85**	mm	UL94

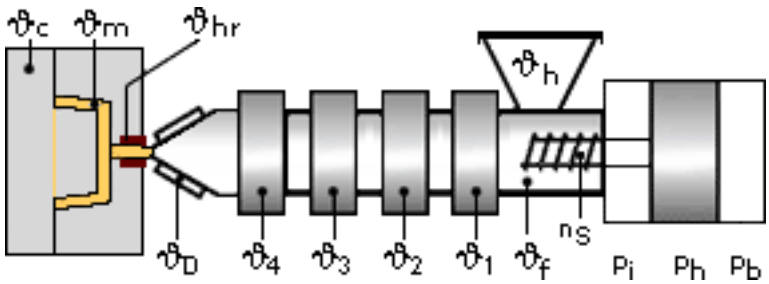
Electrical properties	Value	Unit	Test Standard
Relative permittivity - 1 MHz	**4.7**	-	IEC 60250
Dissipation factor - 1 MHz	**200**	E-4	IEC 60250
Volume resistivity	**>1E13**	Ohm*m	IEC 60093
Surface resistivity	**>1E15**	Ohm	IEC 60093
Electric strength	**25**	kV/mm	IEC 60243-1

Test specimen production	Value	Unit	Test Standard
Injection molding melt temperature	**310 - 340**	°C	ISO 294

FORTRON® 1140E7 | PPS | Glass Reinforced

Test specimen production	Value	Unit	Test Standard
Injection molding mold temperature	**135 - 160**	°C	ISO 294

Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.02%

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.

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

Drying time: 3 - 4 h

Drying temperature: 130 - 140 °C

Temperature:

	ϑManifold	ϑMold	ϑMelt	ϑNozzle	ϑZone4	ϑZone3	ϑZone2	ϑZone1	ϑFeed	ϑHopper
min (°C)	330	140	330	310	330	330	310	290	60	20
max (°C)	340	160	340	330	340	340	320	300	80	30

Pressure:

	Inj press	Hold press	Back pressure
min (bar)	500	300	0
max (bar)	1000	700	30

Speed:

Injection speed: fast

Screw speed

Screw diameter (mm)	16	25	40	55	75
Screw speed (RPM)	-	120	75	50	-

Injection Molding

On injection molding machines with 15-25 D long three-section screws, as are usual in the trade, the FORTRON is processable. A shut-off nozzle is preferred to a free-flow nozzle.

FORTRON® 1140E7 | PPS | Glass Reinforced

Melt temperature	320-340	degC
Mold wall temperature	at least 140	degC

A medium injection rate is normally preferred. All mold cavities must be effectively vented.

Contact Information

Americas

Ticona North American Headquarters
Product Information Service
8040 Dixie Highway
Florence, KY 41042
USA
Tel.: +1-800-833-4882
Tel.: +1-859-372-3244
email: prodinfo@ticona.com
Ticona on the web: www.ticona.com

Customer Service
Tel.: +1-800-526-4960
Tel.: +1-859-372-3214
Fax: +1-859-372-3125

Europe

Ticona GmbH
Information Service
Tel.: +49 (0) 180-5842662 (Germany)
+49 (0) 69-30516299 (Europe)
Fax: +49 (0) 180-2021202 (Germany & Europe)
email: infoservice@ticona.de
Internet: www.ticona.com

General Disclaimer