

## FORTRON® 6345L4 | PPS | Specialty

### Description

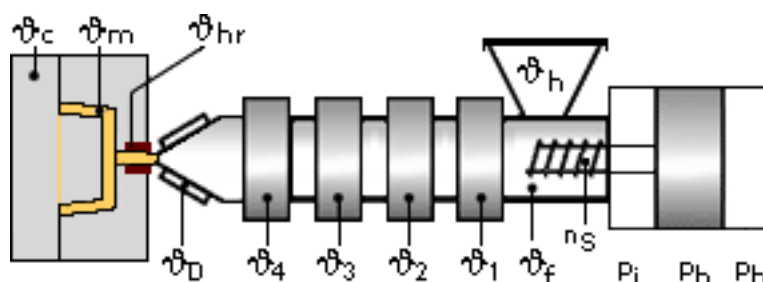
Fortron 6345L4 is 30% glass fiber/high PTFE reinforced injection molding grade. This grade, available in natural and black color, exhibits improved wear and sliding properties versus 1342L4 product.

Physical properties	Value	Unit	Test Standard
Density	<b>1660</b>	kg/m <sup>3</sup>	ISO 1183
Mold shrinkage - parallel	<b>0.3-0.5</b>	%	ISO 294-4
Mold shrinkage - normal	<b>0.6-0.9</b>	%	ISO 294-4
Humidity absorption (23°C/50%RH)	<b>0.02</b>	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile stress at break (5mm/min)	<b>150</b>	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	<b>1.9</b>	%	ISO 527-2/1A
Flexural modulus (23°C)	<b>10600</b>	MPa	ISO 178
Flexural strength (23°C)	<b>230</b>	MPa	ISO 178
Notched impact strength (Izod) @ 23°C	<b>9.0</b>	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
DTUL @ 1.8 MPa	<b>260</b>	°C	ISO 75-1/-2
DTUL @ 8.0 MPa	<b>190</b>	°C	ISO 75-1/-2

### 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  $\leq -30^\circ\text{C}$ . 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 ( $\leq 60$  h).

**Drying time: 3 - 4 h**

**Drying temperature: 130 - 140 °C**

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### Temperature:

	ϑ <sub>Manifold</sub>	ϑ <sub>Mold</sub>	ϑ <sub>Melt</sub>	ϑ <sub>Nozzle</sub>	ϑ <sub>Zone4</sub>	ϑ <sub>Zone3</sub>	ϑ <sub>Zone2</sub>	ϑ <sub>Zone1</sub>	ϑ <sub>Feed</sub>	ϑ <sub>Hopper</sub>
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	-

## Contact Information

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## General Disclaimer

**NOTICE TO USERS:** Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values.

Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use.

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## **FORTRON® 6345L4 | PPS | Specialty**

We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed (+49 (0) 69 30516299 for Europe and +1 859-372-3244 for the Americas) for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.

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