



FORTRON® ICE 504L HR

Polyphenylene sulfide

FORTRON ICE 504L HR is a 40% glass fiber reinforced polyphenylene sulfide, that belongs to our new generation of Fortron® PPS.

This new technology combines improved hydrolysis resistance with optimization of molding conditions with faster cycle times. Due to the faster crystallization of the material at a higher temperature, the option of mold wall temperature reduction can be subject of advanced process optimization. The potential for optimization of Fortron® ICE by cycle time reduction is possible by standard cavity surface temperatures of 140 °C. The potential for lowering the mold temperature must be checked individually and it depends on process and part design.

Product information

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Resin Identification	PPS-GF40		ISO 1043
Part Marking Code	>PPS-GF40<		ISO 11469
Rheological properties			
Moulding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.6	%	ISO 294-4, 2577
Typical mechanical properties			
Tensile modulus	16000	MDa	ISO 527-1/-2
Tensile modulus Tensile stress at break, 5mm/min		MPa	ISO 527-1/-2 ISO 527-1/-2
Tensile strain at break, 5mm/min	1.8		ISO 527-1/-2
Flexural modulus	15000		ISO 327-17-2 ISO 178
Flexural strength		MPa	ISO 178
Charpy notched impact strength, 23°C		kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23 °C		kJ/m ²	ISO 180/1A
Izod impact strength, 23°C		kJ/m ²	ISO 180/1U
Poisson's ratio	0.33 ^[C]	NO/III	100 100/10
[C]: Calculated	0.00		
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Thermal properties			
Melting temperature, 10°C/min	280	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	90	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	270	°C	ISO 75-1/-2
Thermal conductivity, flow	0.47	W/(m K)	ISO 22007-2
Thermal conductivity, crossflow	0.41	W/(m K)	ISO 22007-2
Thermal conductivity, through plane	0.39	W/(m K)	ISO 22007-2
Effective thermal diffusivity, flow	2.7E-7	m²/s	ISO 22007-4
Effective thermal diffusivity, crossflow	2.4E-7		ISO 22007-4
Effective thermal diffusivity, through plane	2.2E-7		ISO 22007-4
Specific heat capacity of melt	1040	J/(kg K)	ISO 22007-4
Flammability			
Burning Behav. at thickness h	\/_∩	class	IEC 60695-11-10
Thickness tested	0.38		IEC 60695-11-10
Oxygen index	47		ISO 4589-1/-2
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Electrical properties

Volume resistivity	1E15 Ohm.m	IEC 62631-3-1
Arc Resistance	134 s	UL 746B

Physical/Other properties

Water absorption, 2mm	0.02 %	Sim. to ISO 62
Water absorption, Immersion 24h	0.02 %	Sim. to ISO 62
Density	1600 kg/m ³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	130	°C
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.02	%
Melt Temperature Optimum	330	°C
Min. melt temperature	310	°C
Max. melt temperature	340	°C
Screw tangential speed	0.2 - 0.3	m/s
Mold Temperature Optimum	140	°C
Min. mould temperature	125	°C
Max. mould temperature	160	°C
Hold pressure range	30 - 70	MPa
Back pressure	3	MPa

Characteristics

Processing Injection Moulding

Delivery form Pellets

Additives Release agent

Special characteristics Flame retardant, Heat stabilised or stable to heat, Hydrolysis resistant, Chemical

resistant

Additional information

Injection molding Preprocessing

Predrying in a dehumidified air dryer at 130 - 140 degC/3-4 hours is recommended.

Processing

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.

Melt temperature 320-340 degC

Mold wall temperature at least 140 degC

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

Postprocessing

Tool temperature of at least 135 degC is recommended for parts to achieve maximum crystallizable potential.

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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