

SKX-9057 - PPS

Description

PPS, 50% GF/MF reinforced, impact modified and heat shock resistant

Fortron 6150T4 is a 50% glass-fiber and mineral reinforced grade with improved impact and heat shock resistance.

Physical properties	Value	Unit	Test Standard
Density	104	lb/ft ³	ISO 1183
Molding shrinkage, parallel (flow)	0.3	%	ISO 294-4, 2577
Molding shrinkage, transverse normal	0.5	%	ISO 294-4, 2577
Water absorption, 23°C-sat	0.07	%	Sim. to ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile stress at break, 5mm/min	23900	psi	ISO 527-1, -2
Tensile strain at break, 5mm/min	1.7	%	ISO 527-1, -2
Flexural modulus, 23°C	2.1E6	psi	ISO 178
Flexural strength, 23°C	36500	psi	ISO 178
Charpy impact strength, 23°C	23.8	ft-lb/in ²	ISO 179/1eU
Charpy notched impact strength, 23°C	4.76	ft-lb/in ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	536	°F	ISO 11357-1/-3
DTUL at 1.8 MPa	518	°F	ISO 75-1, -2

Electrical properties	Value	Unit	Test Standard
Volume resistivity, 23°C	>1E13	Ohm*m	IEC 62631-3-1
Surface resistivity, 23°C	>1E15	Ohm	IEC 62631-3-2
Electric strength, 23°C (AC)	635	kV/in	IEC 60243-1
Comparative tracking index CTI M	Group IIIa	-	IEC 60112

Typical injection moulding processing conditions

Pre Drying	Value	Unit
Drying time	3 - 4	h
Drying temperature	266 - 284	°F

Temperature	Value	Unit
Hopper temperature	68 - 86	°F
Feeding zone temperature	140 - 176	°F
Zone1 temperature	554 - 572	°F
Zone2 temperature	590 - 608	°F
Zone3 temperature	626 - 644	°F
Zone4 temperature	626 - 644	°F
Nozzle temperature	590 - 626	°F
Melt temperature	626 - 644	°F
Mold temperature	284 - 320	°F
Hot runner temperature	626 - 644	°F

Pressure	Value	Unit
Back pressure max.	30	bar

Screw Speed	Value	Unit
Screw speed diameter, 25mm	120	RPM
Screw speed diameter, 40mm	75	RPM
Screw speed diameter, 55mm	50	RPM

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Other text information

Pre-drying

Pre-drying conditions: Fortron should, in principle, be pre-dried. Because of the necessary low maximum residual moisture content, the use of dry air dryers is recommended. The dew point should be ≤ -30 deg. C. the time between drying and processing should be as short as possible.

Characteristics

Product Categories	Impact modified, Mineral/Glass reinforced
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Processing	Injection molding
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