



# FORTRON® 1140L0

## Polyphenylene sulfide

Fortron 1140L0 is a 40% glass-reinforced extrusion grade. It exhibits excellent heat and chemical resistance, good electrical properties and is inherently flame-retardant. The high hardness and rigidity at elevated temperatures allows for good load bearing performance. This product has good weldability due to the modest filler level. 1140L0 is used to produce rods and slabs.

#### **Product information**

Resin Identification Part Marking Code	PPS-GF40 >PPS-GF40<		ISO 1043 ISO 11469
Typical mechanical properties			
Tensile stress at break, 5mm/min Tensile strain at break, 5mm/min Flexural modulus Flexural strength Charpy notched impact strength, 23°C Charpy notched impact strength, -30°C	1.8 14000 280 10		ISO 527-1/-2 ISO 527-1/-2 ISO 178 ISO 178 ISO 179/1eA ISO 179/1eA
Thermal properties			
Melting temperature, 10°C/min Glass transition temperature, 10°C/min	280 90	°C	ISO 11357-1/-3 ISO 11357-1/-3
Flammability			
Burning Behav. at 1.5mm nom. thickn. Thickness tested Burning Behav. at thickness h Thickness tested	1.5	class mm class mm	IEC 60695-11-10 IEC 60695-11-10 IEC 60695-11-10 IEC 60695-11-10
Physical/Other properties			
Water absorption, 2mm Density	0.02 1650	% kg/m³	Sim. to ISO 62 ISO 1183
Injection			
Druing Dagammandad	1/00		

Drying Recommended	yes	
Drying Temperature	100	°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	150	°C
Min. mould temperature	140	°C
Max. mould temperature	160	°C
Hold pressure range	30 - 70	MPa
Back pressure	3	MPa

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#### Characteristics

Processing Injection Moulding, Extrusion, Other Extrusion

Delivery form Pellets

Additives Release agent

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

#### 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 =< -  $30^{\circ}$  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).

#### **Processing Notes**

The higher drying conditions result in higher melt viscosity.

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