



100 1040

FORTRON® 9115L0

Polyphenylene sulfide

Fortron® 9115L0 is a 15% fiberglass-reinforced grade of polyphenylene sulfide with high melt strength suitable for blow molding and extrusion applications.

DDC CE1E

Product	in	forn	nati	on
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Resin Identification Part Marking Code	PPS-GF15 >PPS-GF15<		ISO 1043 ISO 11469	
Typical mechanical properties				
Tensile modulus Tensile stress at break, 5mm/min Tensile strain at break, 5mm/min Flexural modulus Flexural strength Charpy impact strength, 23°C Charpy notched impact strength, 23°C Izod notched impact strength, 23°C Poisson's ratio [C]: Calculated	2 7500 200 32 5	MPa %	ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 178 ISO 179 ISO 179/1eU ISO 179/1eA ISO 180/1A	
Thermal properties				
Temperature of deflection under load, 1.8 MPa Temperature of deflection under load, 8 MPa	220 115		ISO 75-1/-2 ISO 75-1/-2	
Flammability				
Burning Behav. at thickness h Thickness tested	V-0 0.75	class mm	IEC 60695-11-10 IEC 60695-11-10	
Electrical properties				
Surface resistivity	>1E15	Ohm	IEC 62631-3-2	
Physical/Other properties				
Water absorption, 2mm Density	0.02 1440	% kg/m³	Sim. to ISO 62 ISO 1183	
Injection				
Drying Recommended Drying Temperature Drying Time, Dehumidified Dryer Processing Moisture Content Melt Temperature Optimum Min. melt temperature Max. melt temperature Screw tangential speed Mold Temperature Optimum Min. mould temperature	yes 130 2 - 4 ≤0.02 330 310 340 0.2 - 0.3 150 140	h % °C °C °C m/s °C		

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160 °C

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Max. mould temperature





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Hold pressure range 30 - 70 MPa Back pressure 3 MPa

Characteristics

Processing Injection Moulding, Extrusion, Blow Moulding

Special characteristics Flame retardant

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° 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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