

FORTRON® 6850L6 - PPS

Description

Fortron 6850L6 offers the lowest warpage available. The easy flowing nature allows this product to be injection molded into thin walled applications. The excellent balance of mineral and glass fibers result in a superior heat resistance and dimensional stability. This grade is inherently flame-retardant along with high hardness and rigidity. Especially used for thin walled by unfavorable flow length-wall thickness ratio. This is the most isotropic grade available.

Physical properties	Value	Unit	Test Standard
Density	1800	kg/m ³	ISO 1183
Molding shrinkage, parallel	0.3 - 0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.4 - 0.6	%	ISO 294-4, 2577
Water absorption, 23°C-sat	0.02	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	18500	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	125	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	1	%	ISO 527-2/1A
Flexural modulus, 23°C	16800	MPa	ISO 178
Flexural stress at break	190	MPa	ISO 178
Charpy impact strength, 23°C	16	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	16	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	4	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	4	kJ/m ²	ISO 179/1eA
Izod impact notched, 23°C	4	kJ/m ²	ISO 180/1A
Izod impact notched, -30°C	4	kJ/m ²	ISO 180/1A
Izod impact unnotched, 23°C	20	kJ/m ²	ISO 180/1U
Izod impact unnotched, -30°C	20	kJ/m ²	ISO 180/1U
Rockwell hardness (M-Scale)	96	M-Scale	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	280	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	90	°C	ISO 11357-1,-2,-3
DTUL at 1.8 MPa	270	°C	ISO 75-1, -2
DTUL at 8.0 MPa	215	°C	ISO 75-1, -2
Coeff. of linear therm expansion, parallel	0.15	E-4/°C	ISO 11359-2
Coeff. of linear therm expansion, normal	0.31	E-4/°C	ISO 11359-2
Flammability @ 1.6mm nom. thickn. thickness tested (1.6)	V-0 1.5	class mm	UL 94 UL 94
Flammability at thickness h thickness tested (h)	V-0 0.38	class mm	UL 94 UL 94

Electrical properties	Value	Unit	Test Standard
Dissipation factor, 1MHz	10	E-4	IEC 60250
Volume resistivity	>1E13	Ohm*m	IEC 60093
Surface resistivity	>1E15	Ohm	IEC 60093
Electric strength	25	kV/mm	IEC 60243-1

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0.02	%	-
Drying time	3 - 4	h	-
Drying temperature	130 - 140	°C	-
Temperature	Value	Unit	Test Standard
Hopper temperature	20 - 30	°C	-
Feeding zone temperature	60 - 80	°C	-
Zone1 temperature	290 - 300	°C	-

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Zone2 temperature	310 - 320	°C	-
Zone3 temperature	330 - 340	°C	-
Zone4 temperature	330 - 340	°C	-
Nozzle temperature	310 - 330	°C	-
Melt temperature	330 - 340	°C	-
Mold temperature	140 - 160	°C	-
Hot runner temperature	330 - 340	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	30	bar	-
Speed	Value	Unit	Test Standard
Injection speed	fast	-	-
Screw Speed	Value	Unit	Test Standard
Screw speed diameter, 25mm	120	RPM	-
Screw speed diameter, 40mm	75	RPM	-
Screw speed diameter, 55mm	50	RPM	-
Other	Value	Unit	Test Standard
Specimen thickness (shrinkage)	3.18	mm	Internal

Other text information

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 $\leq -30^{\circ}\text{C}$. The time between drying and processing should be as short as possible.

Longer pre-drying times/storage

For subsequent storage the material should be stored dry in the dryer until processed (≤ 60 h).

Characteristics

Product Categories

Mineral/Glass reinforced

Delivery Form

Pellets

Processing

Injection molding

Additives

Release agent

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