

## FORTRON® 6165A4 | PPS | Mineral / Glass Reinforced

### Description

Fortron 6165A4 offers a unique balance of properties based on a high mineral and glass reinforced composition. The heat resistance under load bearing conditions is excellent for this product. As with all Fortron grades this product is inherently flame-retardant. Applications include electronic components (i.e. lamp houses, connection parts and sockets) and components in industry (i.e. pumps and pistons).

Physical properties	Value	Unit	Test Standard
Density	<b>1950</b>	kg/m <sup>3</sup>	ISO 1183
Mold shrinkage - parallel	<b>0.2 - 0.6</b>	%	ISO 294-4
Mold shrinkage - normal	<b>0.3 - 0.7</b>	%	ISO 294-4
Water absorption (23°C-sat)	<b>0.02</b>	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	<b>19000</b>	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	<b>130</b>	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	<b>1.2</b>	%	ISO 527-2/1A
Flexural modulus (23°C)	<b>18800</b>	MPa	ISO 178
Flexural stress @ break	<b>210</b>	MPa	ISO 178
Charpy impact strength @ 23°C	<b>20</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength @ -30°C	<b>20</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength @ 23°C	<b>7</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength @ -30°C	<b>7</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Unnotched impact str (Izod) @ 23°C	<b>20</b>	kJ/m <sup>2</sup>	ISO 180/1U
Notched impact strength (Izod) @ 23°C	<b>6</b>	kJ/m <sup>2</sup>	ISO 180/1A
Notched impact strength (Izod) @ -30°C	<b>6</b>	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	<b>100</b>	M-Scale	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	<b>280</b>	°C	ISO 11357-1,-2,-3
Glass transition temperature (10°C/min)	<b>90</b>	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	<b>270</b>	°C	ISO 75-1/-2
DTUL @ 8.0 MPa	<b>215</b>	°C	ISO 75-1/-2
Coeff.of linear therm. expansion (parallel)	<b>0.19</b>	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	<b>0.24</b>	E-4/°C	ISO 11359-2
Limiting oxygen index (LOI)	<b>53</b>	%	ISO 4589
Flammability @ 1.6mm nom. thickn. thickness tested (1.6)	<b>V-0</b> <b>1.5</b>	class mm	UL94 UL94
Flammability at thickness h thickness tested (h)	<b>V-0</b> <b>0.75</b>	class mm	UL94 UL94
Flammability 5V at thickness h thickness tested (5V)	<b>5VA</b> <b>3</b>	class mm	UL94 UL94

Electrical properties	Value	Unit	Test Standard
Relative permittivity - 10kHz	<b>5.4</b>	-	IEC 60250
Relative permittivity - 1 MHz	<b>5.6</b>	-	IEC 60250
Dissipation factor - 10kHz	<b>10</b>	E-4	IEC 60250
Dissipation factor - 1 MHz	<b>20</b>	E-4	IEC 60250
Volume resistivity	<b>&gt;1E15</b>	Ohm*m	IEC 60093
Surface resistivity	<b>&gt;1E15</b>	Ohm	IEC 60093

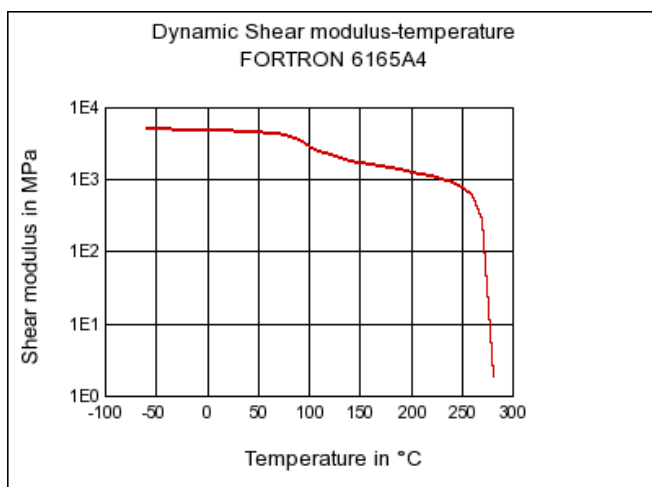
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Electrical properties	Value	Unit	Test Standard
Electric strength	<b>25</b>	kV/mm	IEC 60243-1
Comparative tracking index CTI	<b>175</b>	-	IEC 60112

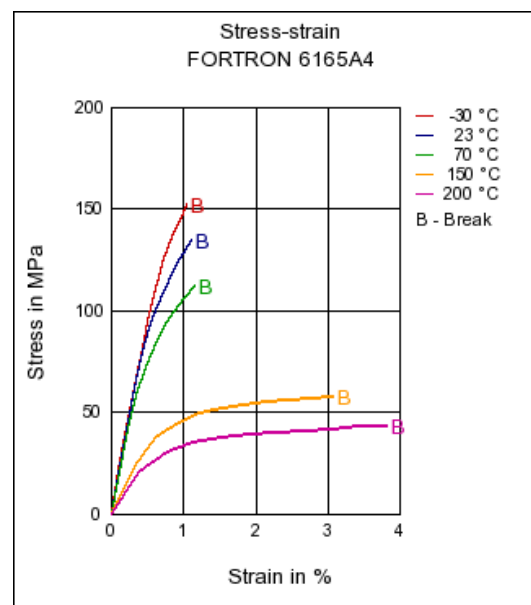
Test specimen production	Value	Unit	Test Standard
Injection molding melt temperature	<b>310 - 340</b>	°C	ISO 294
Injection molding mold temperature	<b>135 - 160</b>	°C	ISO 294

Rheological Calculation properties	Value	Unit	Test Standard
Specific heat capacity of melt	<b>1600</b>	J/(kg K)	Internal

**Dynamic Shear modulus-temperature**

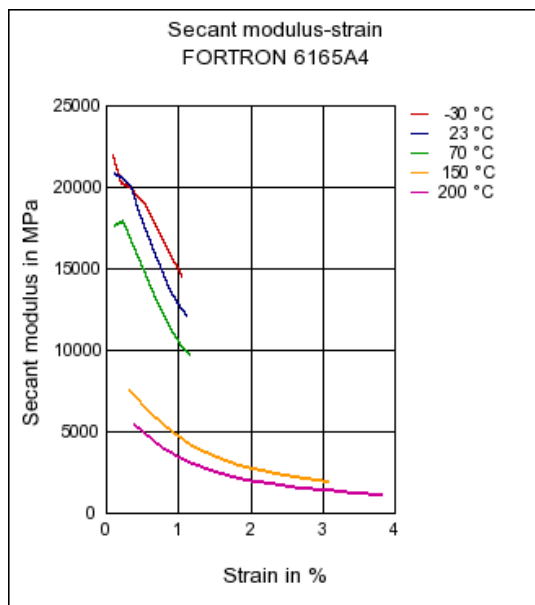


**Stress-strain**

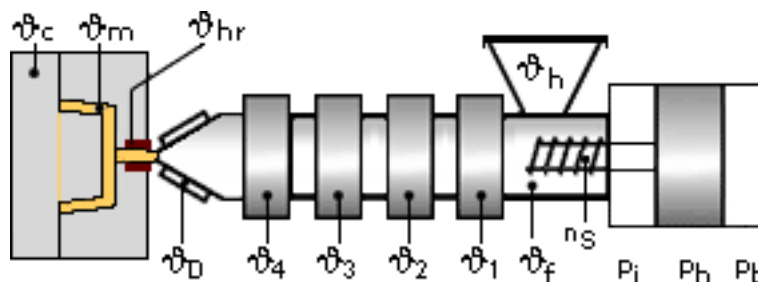


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**Secant modulus-strain**



**Typical injection moulding processing conditions**



**Pre Drying:**

**Necessary low maximum residual moisture content: 0.02%**

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.

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

**Drying time: 3 - 4 h**

**Drying temperature: 130 - 140 °C**

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### Temperature:

	Manifold	Mold	Melt	Nozzle	Zone4	Zone3	Zone2	Zone1	Feed	Hopper
min (°C)	330	140	330	310	330	330	310	290	60	20
max (°C)	340	160	340	330	340	340	320	300	80	30

### Pressure:

	Inj press	Hold press	Back pressure
min (bar)	500	300	0
max (bar)	1000	700	30

### Speed:

#### Injection speed: fast

#### Screw speed

Screw diameter (mm)	16	25	40	55	75
Screw speed (RPM)	-	120	75	50	-

## Injection Molding

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

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

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### General Disclaimer

**NOTICE TO USERS:** Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values.

Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use.

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