

Fortron® 1130L0

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron 1130L0 is a 30% 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. 1130L0 is used to produce rods and slabs.

General Information			
UL YellowCard	E107854-237732		
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Rigidity, high		
	Weldable		
	Good electrical performance		
	Good chemical resistance		
	High hardness		
	Flame retardancy		
Uses	Bar		
	Compression plate		
RoHS Compliance	Contact manufacturer		
Processing Method	Extrusion		
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	160	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	10400	MPa	ISO 178
Flexural Stress (23°C)	255	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	10	kJ/m²	ISO 179/1eA
23°C	10	kJ/m²	ISO 179/1eA
Notched Izod Impact (23°C)	9.5	kJ/m²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	255	°C	ISO 75-2/A
Glass Transition Temperature ¹	90.0	°C	ISO 11357-2
Melting Temperature ²	280	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093

Volume Resistivity	1.0E+18	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.380 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	130 - 140	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	20.0 - 30.0	°C	
Rear Temperature	290 - 300	°C	
Middle Temperature	310 - 320	°C	
Front Temperature	330 - 340	°C	
Nozzle Temperature	310 - 330	°C	
Processing (Melt) Temp	330 - 340	°C	
Mold Temperature	140 - 160	°C	
Injection Pressure	50.0 - 100	MPa	
Injection Rate	Fast		
Holding Pressure	30.0 - 70.0	MPa	
Back Pressure	0.00 - 3.00	MPa	
Injection instructions			
Manifold Temperature: 330 to 340°CZone 4 Temperature: 330 to 340°CFeed Temperature: 60 to 80°C			
NOTE			
1.	10°C/min		
2.	10°C/min		

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