

Fortron® 1115L0

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron® 1115L0 is a 15% fiberglass-reinforced grade of polyphenylene sulfide with high melt strength suitable for blow molding and extrusion applications.

The recommended processing conditions are similar to those of our standard grades, except drying conditions are somewhat milder at 80 to 100 C for 3-4 hours.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Features	Good melt strength		
Uses	Blow molding applications		
RoHS Compliance	Contact manufacturer		
Processing Method	Blow molding		
	Extrusion		

Physical	Nominal Value	Unit	Test Method
Density	1.44	g/cm ³	ISO 1183
Water Absorption (Saturation, 23°C)	0.020	%	ISO 62

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7700	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	120	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	7500	MPa	ISO 178
Flexural Stress (23°C)	200	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	32	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	5.2	kJ/m ²	ISO 180/1A

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, not annealed	220	°C	ISO 75-2/A
8.0 MPa, not annealed	115	°C	ISO 75-2/C

Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093

Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°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°C Zone 4 Temperature: 330 to 340°C Feed Temperature: 60 to 80°C

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