

Fortron® 6162A7

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron 6162A7 is a mineral/glass reinforced grade for applications requiring the highest flow.

General Information			
UL YellowCard	E107854-100156293		
Filler / Reinforcement	Glass \Mineral		
Features	High liquidity		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.92	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.40 - 0.80	%	ISO 294-4
Flow direction	0.10 - 0.30	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.017	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	100		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	15400	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	115	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.3	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	14500	MPa	ISO 178
Flexural Stress (23°C)	185	MPa	ISO 178
Flexural Strain at Break	1.5	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	7.7	kJ/m ²	ISO 179/1eA
23°C	4.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	28	kJ/m ²	ISO 179/1eU
23°C	16	kJ/m ²	ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-30°C	8.9	kJ/m ²	ISO 180/1A
23°C	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	18	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, not annealed	270	°C	ISO 75-2/A

8.0 MPa, not annealed	215	°C	ISO 75-2/C
Glass Transition Temperature ¹	90.0	°C	ISO 11357-2
Melting Temperature ²	280	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.9E-5	cm/cm/°C	ISO 11359-2
Lateral	3.4E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Relative Permittivity (1 MHz)	5.68		IEC 60250
Dissipation Factor (1 MHz)	1.0E-3		IEC 60250
Comparative Tracking Index	225	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.800 mm	V-0		UL 94
1.50 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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