

Fortron® MT9115L0 DW

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron® MT9115L0 DW is a 15% fiberglass-reinforced grade of polyphenylene sulfide with high melt strength suitable for blow molding and extrusion applications.

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	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°C Zone 4 Temperature: 330 to 340°C Feed Temperature: 60 to 80°C

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Recommended distributors for this material

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