Fortron® 6150T6

Polyphenylene Sulfide

Celanese Corporation

Message:

Fortron 6150T6 is a 50% glass-fiber reinforced and mineral-filled grade with improved impact and heat shock resistance.

General Information			
Filler / Reinforcement	Glass \mineral, 50% filler by weight		
Features	Impact resistance, good Good thermal shock resistance		
RoHS Compliance	Contact manufacturer		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.75	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.40 - 0.50	%	ISO 294-4
Flow direction	0.10 - 0.20	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	13000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	140	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.6	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	12300	MPa	ISO 178
Flexural Stress [1]	200	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	8.0	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	40	kJ/m²	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (1.8 MPa, Unannealed)	270	°C	ISO 75-2/A
Melting Temperature [2]	280	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.5E-5	cm/cm/°C	ISO 11359-2
Lateral	4.3E-5	cm/cm/°C	ISO 11359-2
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Comparative Tracking Index	175	V	IEC 60112
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.	Break
2.	10°C/min

Recommended distributors for this material

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