

FORTRON® 6450A6 - PPS

Description

Fortron 6450A6 is a fiberglass reinforced, mineral filled alloy that exhibits improved wear and sliding properties versus standard Fortron compounds.

Physical properties	Value	Unit	Test Standard
Density	1580	kg/m ³	ISO 1183
Water absorption, 23°C-sat	0.02	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile stress at break, 5mm/min	90	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	1.5	%	ISO 527-2/1A
Flexural modulus, 23°C	11000	MPa	ISO 178
Flexural strength, 23°C	130	MPa	ISO 178
Charpy impact strength, 23°C	18	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	6	kJ/m ²	ISO 179/1eA
Izod impact notched, 23°C	6	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
DTUL at 1.8 MPa	260	°C	ISO 75-1, -2
DTUL at 8.0 MPa	200	°C	ISO 75-1, -2

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0.02	%	-
Drying time	3 - 4	h	-
Drying temperature	130 - 140	°C	-
Temperature	Value	Unit	Test Standard
Hopper temperature	20 - 30	°C	-
Feeding zone temperature	60 - 80	°C	-
Zone1 temperature	290 - 300	°C	-
Zone2 temperature	310 - 320	°C	-
Zone3 temperature	330 - 340	°C	-
Zone4 temperature	330 - 340	°C	-
Nozzle temperature	310 - 330	°C	-
Melt temperature	330 - 340	°C	-
Mold temperature	140 - 160	°C	-
Hot runner temperature	330 - 340	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	30	bar	-
Speed	Value	Unit	Test Standard
Injection speed	fast	-	-
Screw Speed	Value	Unit	Test Standard
Screw speed diameter, 25mm	120	RPM	-
Screw speed diameter, 40mm	75	RPM	-
Screw speed diameter, 55mm	50	RPM	-

Other text information

Pre-drying

FORTRON should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be =< - 30° C. The time between drying and processing should be as short as possible.

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Longer pre-drying times/storage

For subsequent storage the material should be stored dry in the dryer until processed (<= 60 h).

Characteristics

Product Categories

Specialty

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