Fortron® 1115L0

Celanese Corporation - Polyphenylene Sulfide

Tuesday, November 5, 2019

General Information

Product Description

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			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight		
Features	• High Melt Strength		
RoHS Compliance	• Contact Manufacturer		
Processing Method	• Blow Molding	• Extrusion	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.44	g/cm³	ISO 1183
Water Absorption (Saturation, 73°F)	0.020	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.12E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	17400	psi	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.09E+6	psi	ISO 178
Flexural Stress (73°F)	29000	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (73°F)	2.4	ft·lb/in²	ISO 179/1eA
Charpy Unnotched Impact Strength (73°F)	15	ft·lb/in²	ISO 179/1eU
Notched Izod Impact Strength (73°F)	2.5	ft·lb/in²	ISO 180/1A
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (264 psi, Unannealed)	428	°F	ISO 75-2/A
Heat Deflection Temperature (1160 psi, Unannealed)	239	°F	ISO 75-2/C
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.030 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176 to 212	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Hopper Temperature	68 to 86	°F
Rear Temperature	554 to 572	°F
Middle Temperature	590 to 608	°F

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Injection	Nominal Value	Unit
Front Temperature	626 to 644	°F
Nozzle Temperature	590 to 626	°F
Processing (Melt) Temp	626 to 644	°F
Mold Temperature	284 to 320	°F
Injection Rate	Fast	
Back Pressure	< 435	psi

Injection Notes

Feeding zone temperature: 60 to 80°C
Zone4 temperature: 330 to 340°C
Hot runner temperature: 330 to 340°C

Notes

[1] Typical properties: these are not to be construed as specifications.