



Fortron® 1120L4

Celanese Corporation - Polyphenylene Sulfide

Tuesday, November 5, 2019

General Information

Product Description

Fortron 1120L4 is a 20% glass fiber reinforced injection molding grade exhibiting excellent heat and chemical resistance, inherent flame retardancy, high hardness and stiffness at elevated temperatures.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Features	• Chemical Resistant • Flame Retardant	• High Hardness • High Stiffness	
RoHS Compliance	• Contact Manufacturer		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.48	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	0.70	%	
Flow	0.30	%	
Water Absorption (Saturation, 73°F)	0.020	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	17400	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.5	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.16E+6	psi	ISO 178
Flexural Stress (73°F)	24700	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	3.3	ft·lb/in ²	ISO 180/1A
Unnotched Izod Impact Strength (73°F)	17	ft·lb/in ²	ISO 180/1U
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	100		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	491	°F	ISO 75-2/A
CLTE - Flow	1.4E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	2.9E-5	in/in/°F	ISO 11359-2
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	266 to 284	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Hopper Temperature	68 to 86	°F

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Injection	Nominal Value	Unit
Rear Temperature	554 to 572	°F
Middle Temperature	590 to 608	°F
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.