



# Fortron® 1140L7

Celanese Corporation - Polyphenylene Sulfide

Tuesday, November 5, 2019

## General Information

### Product Description

One of the easiest flowing 40% glass reinforced grade in the Fortron product line. This material can be processed at fast cycle times due to the unique crystallization characteristics. This product offers good heat and chemical resistance, as well as, good electrical properties. The product is inherently flame-retardant and exhibits high hardness and rigidity.

### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
• Asia Pacific	• Latin America		
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight		
Features	• Chemical Resistant	• Good Electrical Properties	• High Hardness
	• Fast Molding Cycle	• Good Flow	• High Stiffness
	• Flame Retardant	• Good Heat Resistance	
RoHS Compliance	• Contact Manufacturer		

## ASTM & ISO Properties<sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density	1.65	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	0.50 to 0.70	%	
Flow	0.10 to 0.30	%	
Water Absorption (Saturation, 73°F)	0.020	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.10E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	24700	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.6	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	2.10E+6	psi	ISO 178
Flexural Stress	37700	psi	ISO 178
Compressive Modulus	2.03E+6	psi	ISO 604
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength			ISO 180/1A
-22°F	3.8	ft·lb/in <sup>2</sup>	
73°F	3.8	ft·lb/in <sup>2</sup>	
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)	518	°F	ISO 75-2/A
Heat Deflection Temperature (1160 psi, Unannealed)	392	°F	ISO 75-2/C
Glass Transition Temperature <sup>2</sup>	194	°F	ISO 11357-2
Melting Temperature <sup>2</sup>	536	°F	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Electric Strength	660	V/mil	IEC 60243-1
Comparative Tracking Index	125	V	IEC 60112

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## Celanese Corporation - Polyphenylene Sulfide

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.015 in	V-0		
0.06 in	V-0		

### 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
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

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 10°C/min