Fortron® 1342L4

Celanese Corporation - Polyphenylene Sulfide

Tuesday, November 5, 2019

General Information

Product Description

Fortron 1342L4 is a low wear glass filled grade, ideally suited for bearings, gears and other sliding friction/wear applications.

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber		
Features	• Wear Resistant		
Uses	• Bearings	• Gears	
RoHS Compliance	• Contact Manufacturer		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.69	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	0.50	%	
Flow	0.20	%	
Water Absorption (Saturation, 73°F)	0.020	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2.09E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	23900	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.6	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.99E+6	psi	ISO 178
Flexural Stress	35500	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	4.0	ft·lb/in²	
73°F	4.0	ft·lb/in²	
Charpy Unnotched Impact Strength (73°F)	21	ft·lb/in²	ISO 179/1eU
Notched Izod Impact Strength			ISO 180/1A
-22°F	4.0	ft·lb/in²	
73°F	4.0	ft·lb/in²	
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (264 psi, Unannealed)	518	°F	ISO 75-2/A
Heat Deflection Temperature (1160 psi, Unannealed)	419	°F	ISO 75-2/C
Glass Transition Temperature [2]	194	°F	ISO 11357-2
Melting Temperature [2]	536	°F	ISO 11357-3
CLTE - Flow	1.2E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	2.2E-5	in/in/°F	ISO 11359-2
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
0.030 in	V-0		
0.06 in	V-0		

Fortron® 1342L4

Celanese Corporation - Polyphenylene Sulfide

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

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

[2] 10°C/min