



Fortron® 6345L4

Celanese Corporation - Polyphenylene Sulfide

Tuesday, November 5, 2019

General Information

Product Description

Fortron 6345L4 is 30% glass fiber/high PTFE reinforced injection molding grade. This grade, available in natural and black color, exhibits improved wear and sliding properties versus 1342L4 product.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
Filler / Reinforcement	• Asia Pacific • Glass Fiber, 30% Filler by Weight		
Additive	• PTFE Lubricant		
Features	• Wear Resistant		
RoHS Compliance	• Contact Manufacturer		
Appearance	• Black	• Natural Color	
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.66	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	0.60 to 0.90	%	
Flow	0.30 to 0.50	%	
Water Absorption (Equilibrium, 73°F, 50% RH)	0.020	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	21800	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.9	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.54E+6	psi	ISO 178
Flexural Stress (73°F)	33400	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	4.3	ft·lb/in ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	500	°F	ISO 75-2/A
Heat Deflection Temperature (1160 psi, Unannealed)	374	°F	ISO 75-2/C

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

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Injection	Nominal Value	Unit
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.