



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 • Asia Pacific | • Europe • Latin America | • North America |
| Filler / Reinforcement | • 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.