



Fortron® 6450A6

Celanese Corporation - Polyphenylene Sulfide

Tuesday, November 5, 2019

General Information

Product Description

Fortron 6450A6 is a fiberglass reinforced, mineral filled alloy that exhibits improved wear and sliding properties versus standard Fortron compounds.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
Filler / Reinforcement	• Asia Pacific		
Features	• Glass\Mineral		
RoHS Compliance	• Wear Resistant		
	• Contact Manufacturer		

ASTM & ISO Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density	1.58	g/cm ³	ISO 1183
Water Absorption (Saturation, 73°F)	0.020	%	ISO 62
Mechanical			
Tensile Stress (Break)	13100	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.5	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.60E+6	psi	ISO 178
Flexural Stress (73°F)	18900	psi	ISO 178
Impact			
Charpy Notched Impact Strength (73°F)	2.9	ft-lb/in ²	ISO 179/1eA
Charpy Unnotched Impact Strength (73°F)	8.6	ft-lb/in ²	ISO 179/1eU
Notched Izod Impact Strength (73°F)	2.9	ft-lb/in ²	ISO 180/1A
Thermal			
Heat Deflection Temperature (264 psi, Unannealed)	500	°F	ISO 75-2/A
Heat Deflection Temperature (1160 psi, Unannealed)	392	°F	ISO 75-2/C

Processing Information

	Nominal Value	Unit
Injection		
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

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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.