



## 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 • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass\Mineral		
Features	• Wear Resistant		
RoHS Compliance	• Contact Manufacturer		

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

Physical	Nominal Value	Unit	Test Method
Density	1.58	g/cm <sup>3</sup>	ISO 1183
Water Absorption (Saturation, 73°F)	0.020	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
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	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	2.9	ft-lb/in <sup>2</sup>	ISO 179/1eA
Charpy Unnotched Impact Strength (73°F)	8.6	ft-lb/in <sup>2</sup>	ISO 179/1eU
Notched Izod Impact Strength (73°F)	2.9	ft-lb/in <sup>2</sup>	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)	392	°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
Mold Temperature	284 to 320	°F
Injection Rate	Fast	
Back Pressure	< 435	psi

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### Injection Notes

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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.