



## Fortron® MT9141L4 DW

Celanese Corporation - Polyphenylene Sulfide

Tuesday, November 5, 2019

### General Information

#### Product Description

Fortron MT9141L4 DW is a 40% glass-reinforced PPS that has excellent heat and chemical resistance, inherently flame-retardant, high hardness and a good balance of strength and stiffness. This grade exhibits low flash and is typically used in applications with thicker walls and shorter flow lengths.

#### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Europe	• Latin America • North America	
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight		
Features	• Chemical Resistant • Flame Retardant	• Good Stiffness • Good Strength	• High Hardness
RoHS Compliance	• Contact Manufacturer		

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

Physical	Nominal Value	Unit	Test Method
Density	1.65	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	0.40 to 0.60	%	
Flow	0.20 to 0.60	%	
Water Absorption (Saturation, 73°F)	0.020	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.25E+6	psi	ISO 527-2/1A/1
Tensile Stress (Break)	28300	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.9	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	2.15E+6	psi	ISO 178
Flexural Stress <sup>2</sup>	42100	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	5.7	ft-lb/in <sup>2</sup>	
73°F	5.7	ft-lb/in <sup>2</sup>	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	25	ft-lb/in <sup>2</sup>	
73°F	25	ft-lb/in <sup>2</sup>	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	518	°F	ISO 75-2/A
Glass Transition Temperature <sup>3</sup>	194	°F	ISO 11357-2
Melting Temperature <sup>3</sup>	536	°F	ISO 11357-3
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.015 in	V-0		
0.06 in	V-0		

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### 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 Pressure	7250 to 14500	psi
Injection Rate	Fast	
Holding Pressure	4350 to 10200	psi
Back Pressure	0.00 to 435	psi

### Injection Notes

Manifold Temperature: 330 to 340°C  
Zone 4 Temperature: 330 to 340°C  
Feed Temperature: 60 to 80°C

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> Break

<sup>3</sup> 10°C/min