

**FORTRON® 1131L4 ITT | PPS | Glass Reinforced**

Physical properties	Value	Unit	Test Standard
Density	0.0505	g/ccm	ASTM D792
Specific gravity	1.4	-	ASTM D792
Specific volume	19.8	cubic in/lb	ASTM D792
Mold shrinkage - flow direction	0.0100	mm/mm	ASTM D955
Mold shrinkage - transverse direction	0.0080	mm/mm	ASTM D955

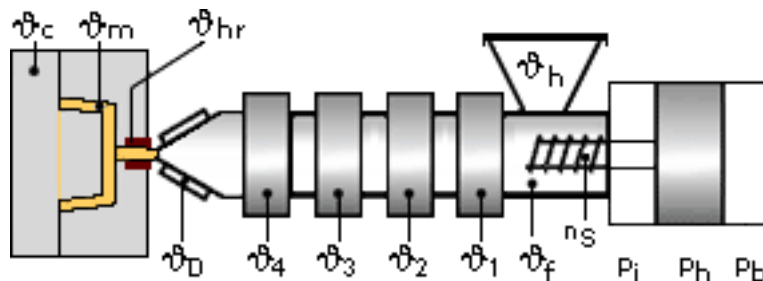
Mechanical properties	Value	Unit	Test Standard
Rockwell hardness	93	M-Scale	ASTM D785
Tensile strength @ break (73°F)	12500	psi	ASTM D638

Thermal properties	Value	Unit	Test Standard
Heat deflection temperature @264 psi	105	°C	ASTM D648
Heat deflection temperature @66 psi	200	°C	ASTM D648

Electrical properties	Value	Unit	Test Standard
Dielectric constant - 1kHz	3	-	ASTM D150
Dielectric constant - 1MHz	3	-	ASTM D150
Dissipation factor - 1kHz	0.001	-	ASTM D150
Dissipation factor - 1MHz	0.009	-	ASTM D150
Volume resistivity	1E16	ohm-cm	ASTM D257
Arc resistance	124	s	ASTM D495

**Typical injection moulding processing conditions**

**Pre Drying:**
**Necessary low maximum residual moisture content: 0.02%**

FORTRON should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be  $\leq -30^\circ\text{C}$ . The time between drying and processing should be as short as possible.

For subsequent storage the material should be stored dry in the dryer until processed ( $\leq 60\text{ h}$ ).

**Drying time: 3 - 4 h**

**Drying temperature: 130 - 140 °C**

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**Temperature:**

	°Manifold	°Mold	°Melt	°Nozzle	°Zone4	°Zone3	°Zone2	°Zone1	°Feed	°Hopper
min (°C)	330	140	330	310	330	330	310	290	60	20
max (°C)	340	160	340	330	340	340	320	300	80	30

**Pressure:**

	Inj press	Hold press	Back pressure
min (bar)	500	300	0
max (bar)	1000	700	30

**Speed:**
**Injection speed: fast**
**Screw speed**

Screw diameter (mm)	16	25	40	55	75
Screw speed (RPM)	-	120	75	50	-

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**Contact Information**


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Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use.

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