

FORTRON® 9115L0

Polyphenylene sulfide

Fortron® 9115L0 is a 15% fiberglass-reinforced grade of polyphenylene sulfide with high melt strength suitable for blow molding and extrusion applications.

Product information

Resin Identification	PPS-GF15	ISO 1043
Part Marking Code	>PPS-GF15<	ISO 11469

Typical mechanical properties

Tensile modulus	7700 MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	120 MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2 %	ISO 527-1/-2
Flexural modulus	7500 MPa	ISO 178
Flexural strength	200 MPa	ISO 178
Charpy impact strength, 23°C	32 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	5 kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	5.2 kJ/m ²	ISO 180/1A
Poisson's ratio	0.34 ^[C]	

[C]: Calculated

Thermal properties

Temperature of deflection under load, 1.8 MPa	220 °C	ISO 75-1/-2
Temperature of deflection under load, 8 MPa	115 °C	ISO 75-1/-2

Flammability

Burning Behav. at thickness h	V-0 class	IEC 60695-11-10
Thickness tested	0.75 mm	IEC 60695-11-10

Electrical properties

Surface resistivity	>1E15 Ohm	IEC 62631-3-2
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Physical/Other properties

Water absorption, 2mm	0.02 %	Sim. to ISO 62
Density	1440 kg/m ³	ISO 1183

Injection

Drying Recommended	yes
Drying Temperature	130 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	≤0.02 %
Melt Temperature Optimum	330 °C
Min. melt temperature	310 °C
Max. melt temperature	340 °C
Screw tangential speed	0.2 - 0.3 m/s
Mold Temperature Optimum	150 °C
Min. mould temperature	140 °C
Max. mould temperature	160 °C

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Hold pressure range	30 - 70 MPa
Back pressure	3 MPa

Characteristics

Processing	Injection Moulding, Extrusion, Blow Moulding
Special characteristics	Flame retardant

Additional information

Processing Notes

Pre-Drying

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.

Storage

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