

# Fortron® 9141L4

Celanese Corporation - Polyphenylene Sulfide

Tuesday, January 21, 2020

## General Information

### Product Description

Fortron 9141L4 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 • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight		
Features	• Chemical Resistant • Flame Retardant • Good Heat Resistance	• Good Stiffness • Good Strength • High Hardness	• Minimal Flash
Uses	• Thick-walled Parts		

## 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, 23°C)	0.020	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	15500	MPa	ISO 527-2/1A
Tensile Stress (Break)	195	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.9	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	14800	MPa	ISO 178
Flexural Stress	290	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	12	kJ/m <sup>2</sup>	
23°C	12	kJ/m <sup>2</sup>	
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	53	kJ/m <sup>2</sup>	
23°C	53	kJ/m <sup>2</sup>	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	270	°C	ISO 75-2/A
Glass Transition Temperature <sup>2</sup>	90.0	°C	ISO 11357-2
Melting Temperature <sup>2</sup>	280	°C	ISO 11357-3
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.38 mm	V-0		
1.5 mm	V-0		

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### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	130 to 140	°C
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Hopper Temperature	20 to 30	°C
Rear Temperature	290 to 300	°C
Middle Temperature	310 to 320	°C
Front Temperature	330 to 340	°C
Nozzle Temperature	310 to 330	°C
Processing (Melt) Temp	330 to 340	°C
Mold Temperature	140 to 160	°C
Injection Rate	Fast	
Back Pressure	< 3.00	MPa

### Injection Notes

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.

<sup>2</sup> 10°C/min