

Product Texts

Fortron 6162A7 is a mineral/glass reinforced grade for applications requiring the highest flow.

Flammability @1.6mm nom. V-0
 thickn. -
 Flammability at thickness h (0.8 V-0
 mm) -

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	15400	MPa	ISO 527
^[C] Stress at break	115	MPa	ISO 527
^[C] Strain at break	1.3	%	ISO 527
^[C] Charpy impact strength, +23°C	16	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	28.2	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	4.5	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	7.7	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	280	°C	ISO 11357-1/-3
^[C] Glass transition temperature, 10°C/min	90	°C	ISO 11357-1/-2
^[C] Temp. of deflection under load, 1.80 MPa	270	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 8.00 MPa	215	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	19	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	34	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn. Thickness tested	V-0 1.5	class mm	IEC 60695-11-10 -
^[C] Burning Behav. at thickness h Thickness tested	V-0 0.8	class mm	IEC 60695-11-10 -

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 1MHz	5.68	-	IEC 62631-2-1
^[C] Dissipation factor, 1MHz	10	E-4	IEC 62631-2-1

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.017	%	Sim. to ISO 62
^[C] Density	1920	kg/m ³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	130 - 140	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	320 - 340	°C	-
Mold temperature	≥140	°C	-

Characteristics**Processing**

Injection Molding

Additives

Release agent

Delivery form

Pellets

Regional Availability

North America, Europe, Asia Pacific, South and Central America

Other text information**Injection molding**

Predrying in a dehumidified air dryer at 130 - 140 degC/3-4 hours is recommended.

On injection molding machines with 15-25 D long three-section screws, as are usual in the trade, the FORTRON is processable. A shut-off nozzle is preferred to a free-flow nozzle.

Melt temperature 320-340 degC

Mold wall temperature at least 140 degC

A medium injection rate is normally preferred. All mold cavities must be effectively vented.

Tool temperature of at least 135 degC is recommended for parts to achieve maximum crystallizable potential.