FORTRON® 1342L4

PPS-GX40 Celanese

Product Texts

Fortron 1342L4 is a low wear glass filled grade, ideally suited for bearings, gears and other sliding friction/wear applications.

Flammability @1.6mm nom. thickn.	V-0	-
Flammability at thickness h (0.75 mm)	V-0	-

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
[C] Molding shrinkage, parallel	**0.2**	%	ISO 294-4, 2577
[C] Molding shrinkage, normal	**0.5**	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**14400**	MPa	ISO 527
[C] Stress at break	**165**	MPa	ISO 527
[C] Strain at break	**1.6**	%	ISO 527
[C] Charpy impact strength, +23°C	**44**	kJ/m²	ISO 179/1eU
[C] Charpy notched impact strength, +23°C	**8.5**	kJ/m²	ISO 179/1eA
[C] Charpy notched impact strength, -30°C	**8.5**	kJ/m²	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	**22**	E-6/K	ISO 11359-1/-2
[C] Coeff. of linear therm. expansion, normal	**40**	E-6/K	ISO 11359-1/-2
[C] Burning Behav. at 1.5 mm nom. thickn.	**V-0**	class	IEC 60695-11-10
Thickness tested	**1.5**	mm	-
[C] Burning Behav. at thickness h	**V-0**	class	IEC 60695-11-10
Thickness tested	**0.8**	mm	-

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
[C] Water absorption	**0.02**	%	Sim. to ISO 62
[C] Density	**1690**	kg/m³	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

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Processing
Injection Molding

Delivery form
Pellets

Additives
Release agent

Features
Tribologic Grade

Regional Availability
North America, Europe, South and Central America, Near East/Africa

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.

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