

**Product Texts**

Fortron 1141L4 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.

Flammability @1.6mm nom. thickn. V-0 -  
 Flammability at thickness h (0.38 mm) V-0 -

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	0.5	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	15500	MPa	ISO 527
<sup>[C]</sup> Stress at break	195	MPa	ISO 527
<sup>[C]</sup> Strain at break	1.9	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	53	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	53	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	12	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	12	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	280	°C	ISO 11357-1/-3
<sup>[C]</sup> Glass transition temperature, 10°C/min	90	°C	ISO 11357-1/-2
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	270	°C	ISO 75-1/-2
<sup>[C]</sup> Burning Behav. at 1.5 mm nom. thickn. Thickness tested	V-0	class	IEC 60695-11-10
<sup>[C]</sup> Burning Behav. at thickness h Thickness tested	V-0	class	IEC 60695-11-10
	0.4	mm	-

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Water absorption	0.02	%	Sim. to ISO 62
<sup>[C]</sup> Density	1650	kg/m <sup>3</sup>	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

**Special Characteristics**

Flame retardant, Heat stabilized or stable to heat

**Delivery form**

Pellets

**Chemical Resistance**

General Chemical Resistance

**Additives**

Release agent

**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.