FORTRON® ICE 504L HR

Polyphenylene sulfide

FORTRON ICE 504L HR is a 40% glass fiber reinforced polyphenylene sulfide, that belongs to our new generation of Fortron® PPS.
This new technology combines improved hydrolysis resistance with optimization of molding conditions with faster cycle times. Due to the faster crystallization of the material at a higher temperature, the option of mold wall temperature reduction can be subject of advanced process optimization. The potential for optimization of Fortron® ICE by cycle time reduction is possible by standard cavity surface temperatures of 140 °C. The potential for lowering the mold temperature must be checked individually and it depends on process and part design.

Product information

Resin Identification	PPS-GF40		ISO 1043
Part Marking Code	>PPS-GF40<		ISO 11469

Rheological properties

Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	2.32E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	29000	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.8	%	ISO 527-1/-2
Flexural modulus	2.18E6	psi	ISO 178
Flexural strength	42600	psi	ISO 178
Charpy notched impact strength, 23 °C	4.28	ftlb/in²	ISO 179/1eA
Izod notched impact strength, 23 °C	4.06	ftlb/in²	ISO 180/1A
Izod impact strength, 23 °C	27.9	ftlb/in²	ISO 180/1U

Thermal properties

Melting temperature, 10 °C/min	536	°F	ISO 11357-1/-3
Glass transition temperature, 10 °C/min	194	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	518	°F	ISO 75-1/-2
Thermal conductivity, flow	0.47	W/(m K)	ISO 22007-2
Thermal conductivity, crossflow	0.41	W/(m K)	ISO 22007-2
Thermal conductivity, through plane	0.39	W/(m K)	ISO 22007-2
Effective thermal diffusivity, flow	2.7E-7	m²/s	ISO 22007-4
Effective thermal diffusivity, crossflow	2.4E-7	m²/s	ISO 22007-4
Effective thermal diffusivity, through plane	2.2E-7	m²/s	ISO 22007-4
Specific heat capacity of melt	1040	J/(kg K)	ISO 22007-4

Flammability

Burning Behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.0150	in	IEC 60695-11-10
Oxygen index	47	%	ISO 4589-1/-2

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Electrical properties

Volume resistivity	1E15	Ohm.m	IEC 62631-3-1
Arc Resistance	134	s	UL 746B

Physical/Other properties

Water absorption, 2mm	0.02	%	Sim. to ISO 62
Water absorption, Immersion 24h	0.02	%	Sim. to ISO 62
Density	0.0596	lb/in³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	266	°F
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.02	%
Melt Temperature Optimum	626	°F
Min. melt temperature	590	°F
Max. melt temperature	644	°F
Max. screw tangential speed	0.2 - 0.3	m/s
Mold Temperature Optimum	284	°F
Min. mold temperature	257	°F
Max. mold temperature	320	°F
Hold pressure range	4350 - 10200	psi
Back pressure	435	psi

Characteristics

Processing	Injection Molding
Additives	Release agent
Special characteristics	Flame retardant, Heat stabilized or stable to heat, Hydrolysis resistant, Chemical resistant

Additional information

Injection molding

Preprocessing

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

Processing

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

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vented.

Postprocessing

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

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 =< - 30° 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 (<= 60 h).

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