

AKROTEK® PRELIMINARY

PK-VM M 7 natural (8858)

PK M7

AKROTEK® PK-VM M 7 natural (8858) is a 7 % mineral reinforced Polyketon with high flowability and good weldline performance. This type was developed as the successor to PK-VM M 7 natural (8248) in order to meet the requirements for a larger processing window during processing.

Features

hydrolysis / chemically stabilised

Properties

Modulus	Strength	Impact
2.700 MPa	65 MPa	120 kJ/m ²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	2700 MPa
Tensile stress at yield ISO 527-2	50 mm/min d.a.m.	65 MPa
Tensile strain at break ISO 527-2	50 mm/min d.a.m.	>18 %
Charpy impact strength ISO 179-1/1eU	23°C d.a.m.	120 kJ/m²
Charpy notched impact strength ISO 179-1/1eA	23°C d.a.m.	5 kJ/m²

Thermal Properties

Melting temperature ISO 11357-3	DSC, 10K/min	220 °C
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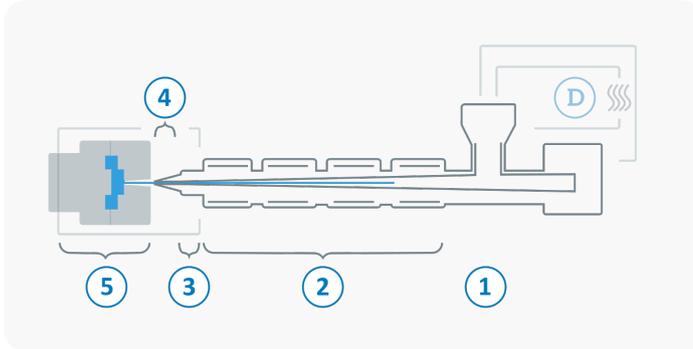
General Properties

Density	23°C	1,28 g/cm³
ISO 1183		

Molding shrinkage	flow	1,0 - 1,2 %
ISO 294-4	transverse	1,2 - 1,4 %

Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	Drying time	0 - 4 h
	Drying temperature ($\tau \leq -30^{\circ}\text{C}$)	80 °C
	Processing moisture	0,02 - 0,1 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	220 - 260 °C
3	Nozzle temperature	230 - 260 °C
4	Melt temperature	230 - 260 °C
5	Mold temperature	60 - 120 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	30 - 70 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min