

Compound No.: 7344

AKROTEK® PK-VM GF 10 grey (7344)

PK GF10

AKROTEK® PK-VM GF 10 grey (7344) is a 10% glass fibre reinforced Polyketone with average stiffness and strength. The material is colored in grey similar to RAL 7044. This grade is suitable for parts of switches in the electric industry.

Features

hydrolysis / chemically stabilised

Properties

Modulus	Strength	Impact
3.600 MPa	65 MPa	50 kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	3600 MPa
Tensile stress at break ISO 527-2	5 mm/min d.a.m.	65 MPa
Tensile strain at break	5 mm/min d.a.m.	10 %
Charpy impact strength ISO 179-1/1eU	23°C d.a.m.	50 kJ/m²

Thermal Properties

Temperature of deflection under load HDT/A	1,8 MPa	205 °C
Melting temperature ISO 11357-3	DSC, 10K/min	220 °C

General Properties



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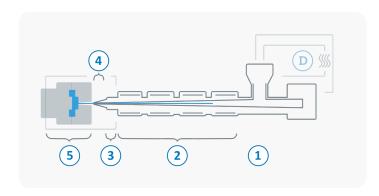
Density ISO 1183	23°℃	1,32 g/cm³
Humidity absorption ISO 1110	70°C, 62% r.H.	0,7 - 0,8 %
Molding shrinkage ISO 294-4	flow transverse	0,7 - 0,9 % 1,3 - 1,5 %





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 (τ <= -30°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
\bigcirc	Holding pressure, spec.	300 - 800 bar
	Back pressure, spec.	30 - 70 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min