Compound No.: 8895





# AKROTEK® UL PRELIMINARY **PK-VM GF 30 8 HU natural (8895)**

PK GF30

AKROTEK® PK-VM GF 30 8 HU natural (8895) is a 30% glass fibre reinforced polyketone with high stiffness and strength. PK is characterized by its outstanding media resistance, which qualifies it to be used for components that are in contact with chemicals. The material corresponds to the European food guideline EU 10/2011 and to the American FDA 21 CFR. This grade is suitable for parts of kitchen and household appliances. This compound is listed at UL94 HB all colors.

#### Regulatory







#### **Properties**



### **Mechanical Properties**

iin   d.a.m. 8400 MPa
in   d.a.m. 140 MPa
in   d.a.m. 2,5 %
.a.m. 70 kJ/m²
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#### **Thermal Properties**

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

## **Flammability**



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Flammability	UL	0,8 mm Wall thickness	HB Class
UL 94	UL	1,6 mm Wall thickness	<b>HB Class</b>
l de la companya de	UL	3,2 mm Wall thickness	HB Class

# **General Properties**

<b>Density</b> ISO 1183	23°C	1,48 g/cm³
Humidity absorption ISO 1110	70°C, 62% r.H.	0,6 - 0,7 %
Water absorption ISO 62	23°C, saturated	0,6 - 0,7 %
Molding shrinkage ISO 294-4	flow transverse	0,3 - 0,5 % 0,8 - 1,0 %

# **Electrical Properties**

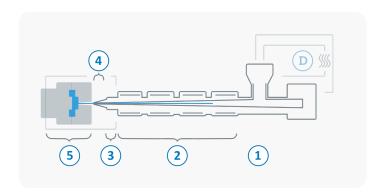
Comparative tracking index IEC 60112	UL Test liquid A	600 V
Comparative tracking index ASTM D3638	UL	0 PLC





#### **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
$\Rightarrow$	Holding pressure, spec.	300 - 800 bar
	Back pressure, spec.	30 - 70 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min