

Compound No.: 8661

AKROTEK® PK-VM GF 30 natural (8661)

PK GF30

AKROTEK® PK-VM GF 30 natural (8661) is a 30% glass fiber reinforced Polyketone with average stiffness and strength. Due to its very good media resistance, the material is suitable for the use in applications that carry cooling water. This type was developed as the successor to PK-VM GF 30 natural (4706) in order to meet the requirements for a larger processing window during processing.

Features hydrolysis / chemically stabilised E-Mobility **Properties** Modulus Strength **Impact 8.300** MPa **144** MPa **76** kJ/m²

Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	8300 MPa
Tensile stress at break ISO 527-2	5 mm/min d.a.m.	144 MPa
Tensile strain at break ISO 527-2	5 mm/min d.a.m.	3,1 %
Charpy impact strength ISO 179-1/1eU	23°C d.a.m.	76 kJ/m²
Flammability		
Flammability	1,6 mm Wall thickness	HB Class

General Properties

UL 94



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23°C	1,48 g/cm³
70°C, 62% r.H.	0,6 - 0,7 %
flow	0,3 - 0,5 % 0,8 - 1,0 %
	70°C, 62% r.H.

Rheological Properties

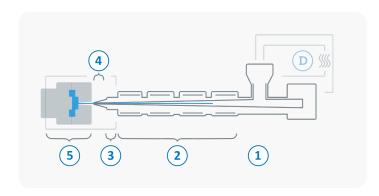
MVR ISO 1133	240°C/2,16kg	4 cm ³ /10 min
150 1733		



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