

HiFill® POK AF5 BK

 Techmer Polymer Modifiers - *Polyketone*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Aramid Fiber, 5.0% Filler by Weight
Appearance	<ul style="list-style-type: none"> Black
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.25		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	8500	psi	ASTM D638
Tensile Elongation (Break)	15	%	ASTM D638
Flexural Modulus	275000	psi	ASTM D790
Flexural Strength	9000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.85	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	420 to 450	°F
Middle Temperature	430 to 460	°F
Front Temperature	440 to 470	°F
Nozzle Temperature	450 to 480	°F
Processing (Melt) Temp	430 to 475	°F
Mold Temperature	120 to 180	°F
Injection Rate	Slow-Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	Slow-Moderate	

