HiFill® POK 1630 A

Techmer Polymer Modifiers - *Polyketone*

General Information

Product Description	
1001180	
General	
Material Status	• Commercial: Active
Availability	• North America
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.24		ASTM D792
Melt Mass-Flow Rate (MFR)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	0.015 to 0.018	in/in	ASTM D955
Water Absorption (24 hr)	0.50	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	8500	psi	ASTM D638
Tensile Strength (Break)	8000	psi	ASTM D638
Tensile Elongation (Break)	> 250	%	ASTM D638
Flexural Modulus	230000	psi	ASTM D790
Flexural Strength	9000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	1.3	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Annealed)	406	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Annealed)	221	°F	ASTM D648
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature	170	°F
Drying Time	2.0 to 3.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	440 to 470	°F
Middle Temperature	450 to 480	°F
Front Temperature	460 to 490	°F
Nozzle Temperature	470 to 500	°F
Processing (Melt) Temp	450 to 500	°F
Mold Temperature	100 to 175	°F