

POKETONE M33AR5A

Hyosung Chemical Corporation - Polyketone, Aliphatic

General Information
Product Description

High toughness injection molding grade

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Features	• High Toughness
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.11		ASTM D792
Density	1.11	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (240°C/2.16 kg)	14	g/10 min	ASTM D1238
Mechanical			
Tensile Strength (Yield)	4350	psi	ASTM D638
Tensile Elongation (Break)	120	%	ASTM D638
Flexural Modulus	102000	psi	ASTM D790
Flexural Strength	3630	psi	ASTM D790
Impact			
Charpy Notched Impact Strength	38	ft·lb/in ²	ISO 179/1eA
Thermal			
Melting Temperature	432	°F	ISO 11357-3
Melting Temperature	432	°F	ASTM D3418

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	176	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	410	°F
Middle Temperature	419 to 428	°F
Front Temperature	446	°F
Nozzle Temperature	464	°F
Processing (Melt) Temp	437 to 464	°F
Mold Temperature	140 to 176	°F
Back Pressure	42.7 to 99.6	psi
Screw Speed	50 to 100	rpm

