

InStruc® POKGF13
 Americhem - Polyketone

General Information
Product Description

13% GLASS FIBER REINFORCED POLYKETONE

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 13% Filler by Weight
Features	• Filled • High Stiffness • Good Dimensional Stability • High Strength
Uses	• Closures • Electrical/Electronic Applications • Industrial Parts • Connectors • Household Goods • Consumer Applications • Industrial Applications
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.33		ASTM D792
Molding Shrinkage - Flow	2.0E-3 to 3.0E-3	in/in	ASTM D955
Mechanical			
Tensile Modulus	700000	psi	ASTM D638
Tensile Strength	14000	psi	ASTM D638
Tensile Elongation (Break)	6.0	%	ASTM D638
Flexural Modulus	600000	psi	ASTM D790
Flexural Strength	20000	psi	ASTM D790
Impact			
Notched Izod Impact	2.2	ft·lb/in	ASTM D256
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	410	°F	ASTM D648

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	170	°F
Drying Time	3.0 to 4.0	hr
Processing (Melt) Temp	450 to 480	°F
Mold Temperature	140 to 180	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

