

**POKETONE M43AG6A**

Hyosung Chemical Corporation - Polyketone, Aliphatic

## General Information

**Product Description**

30% glass-reinforced high-impact injection molding grade

**General**

Material Status	• Commercial: Active
Availability	• Asia Pacific                      • Europe                      • North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Agency Ratings	• ISO 10993                      • KTW
RoHS Compliance	• RoHS Compliant
Processing Method	• Injection Molding

 Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.48		ASTM D792
Density	1.48	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (240°C/2.16 kg)	4.4	g/10 min	ASTM D1238
Molding Shrinkage - Flow			ASTM D955
0.0787 in	1.0E-3	in/in	
0.118 in	2.0E-3	in/in	
Molding Shrinkage - Across Flow			ASTM D955
0.0787 in	9.0E-3	in/in	
0.118 in	0.011	in/in	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.16E+6	psi	ISO 527-1
Tensile Strength (Yield)	18900	psi	ASTM D638
Tensile Stress (Yield)	17400	psi	ISO 527-2
Tensile Elongation (Break)	3.0	%	ASTM D638
Tensile Strain (Break)	3.5	%	ISO 527-2
Flexural Modulus	986000	psi	ASTM D790
Flexural Modulus	841000	psi	ISO 178
Flexural Strength	27700	psi	ASTM D790
Flexural Stress	25400	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-40°F	3.8	ft-lb/in <sup>2</sup>	
73°F	6.2	ft-lb/in <sup>2</sup>	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	419	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	410	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	408	°F	ISO 75-2/A
Melting Temperature	392	°F	ISO 11357-3
Melting Temperature	392	°F	ASTM D3418

## Processing Information

Injection	Nominal Value	Unit
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

#### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

