POKETONE M63AS1B

Hyosung Chemical Corporation - *Polyketone, Aliphatic*

General Information

Product Description			
Lubricated injection general purpose injection molding grade			
General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Additive	• Lubricant		
Features	• General Purpose	• Lubricated	
Uses	• General Purpose		
RoHS Compliance	• RoHS Compliant		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.24		ASTM D792
Density	1.24	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (240°C/2.16 kg)	5.7	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (240°C/2.16 kg)	5.3	g/10 min	ISO 1133
Water Absorption (Saturation)	2.3	%	ASTM D570
Water Absorption (Saturation, 73°F)	2.3	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.60	%	ASTM D570
Water Absorption (Equilibrium, 73°F, 50% RH)	0.60	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	203000	psi	ASTM D638
Tensile Modulus	189000	psi	ISO 527-1
Tensile Strength (Yield)	7980	psi	ASTM D638
Tensile Stress (Yield)	8410	psi	ISO 527-2
Tensile Elongation (Break)	200	%	ASTM D638
Tensile Strain (Break)	200	%	ISO 527-2
Flexural Modulus	189000	psi	ASTM D790
Flexural Modulus	189000	psi	ISO 178
Flexural Strength	7980	psi	ASTM D790
Flexural Stress	7980	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	7.6	ft·lb/in²	ISO 179/1eA
Notched Izod Impact	2.3	ft·lb/in	ASTM D256
Notched Izod Impact Strength	6.7	ft·lb/in²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness	109		ASTM D785
Shore Hardness (Shore D)	68		ISO 868
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	374	°F	ASTM D648
Deflection Temperature Under Load (66 psi, Unannealed)	365	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	212	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	180	°F	ISO 75-2/A
Vicat Softening Temperature	374	°F	ASTM D1525 [2]
Vicat Softening Temperature	374	°F	ISO 306/B50
Melting Temperature	432	°F	ISO 11357-3

Melting Temperature	432	°F	ASTM D3418
CLTE - Flow (77 to 131°F)	5.6E-5	in/in/°F	ASTM E831
CLTE - Transverse (77 to 131°F)	5.6E-5	in/in/°F	ASTM E831
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+18	ohms	ASTM D257
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength			ASTM D149
0.0787 in	510	V/mil	
0.118 in	410	V/mil	
Dielectric Constant (60 Hz)	6.30		ASTM D150
Dissipation Factor (60 Hz)	0.013		ASTM D150

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

[1] Typical properties: these are not to be construed as specifications.

[2] Loading 2 (50 N)