

POKETONE M93FC1F

Hyosung Chemical Corporation - Polyketone, Aliphatic

General Information

Product Description

20% flat-glass fiber-reinforced conductive injection molding grade

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Features	• Conductive
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.34		ASTM D792
Density	1.34	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (240°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow			ASTM D955
0.0787 in	1.0E-3	in/in	
0.118 in	9.0E-4	in/in	
Molding Shrinkage - Across Flow			ASTM D955
0.0787 in	7.0E-3	in/in	
0.118 in	7.2E-3	in/in	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	14900	psi	ASTM D638
Tensile Stress (Yield)	14900	psi	ISO 527-2
Tensile Elongation (Break)	3.1	%	ASTM D638
Tensile Strain (Break)	3.1	%	ISO 527-2
Flexural Modulus	731000	psi	ASTM D790
Flexural Modulus	731000	psi	ISO 178
Flexural Strength	21300	psi	ASTM D790
Flexural Stress	21300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	0.191	ft·lb/in	ASTM D6110
Charpy Notched Impact Strength	4.9	ft·lb/in ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	432	°F	ISO 11357-3
Melting Temperature	432	°F	ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+6	ohms	ASTM D257

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.

