POKETONE M93FC1T

Hyosung Chemical Corporation - *Polyketone, Aliphatic*

General Information

Product Description			
Conductive injection molding grade			
General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Features	• Conductive		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.37		ASTM D792
Melt Mass-Flow Rate (MFR) (240°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	6960	psi	ASTM D638
Tensile Stress (Yield)	6960	psi	ISO 527-2
Tensile Elongation (Break)	5.4	%	ASTM D638
Tensile Strain (Break)	5.4	%	ISO 527-2
Flexural Modulus	445000	psi	ASTM D790
Flexural Modulus	445000	psi	ISO 178
Flexural Strength	10200	psi	ASTM D790
Flexural Stress	10200	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	0.0543	ft·lb/in	ASTM D6110
Charpy Notched Impact Strength	1.4	ft·lb/in²	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