POKETONE M93FG9A

Hyosung Chemical Corporation - *Polyketone, Aliphatic*

General Information

Product Description			
50% glass-reinforced high flow injection molding grade with Food/Drinking water Compliance			
General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 50% Filler by Weight		
Features	• Drinking Water Contact Acceptable	• Food Contact Acceptable	• High Flow
Agency Ratings	• ISO 10993	• KTW	
RoHS Compliance	• RoHS Compliant		
Processing Method	• Injection Molding		

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.68		ASTM D792
Density	1.68	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (240°C/2.16 kg)	25	g/10 min	ASTM D1238
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	23900	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	1.71E+6	psi	ASTM D790
Flexural Strength	31000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	5.2	ft·lb/in²	ISO 179/1eA
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
Melting Temperature	432	°F	ISO 11357-3
Melting Temperature	432	°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