

AKROTEK® PRELIMINARY

PK-VM GF 10 FR natural (8744)

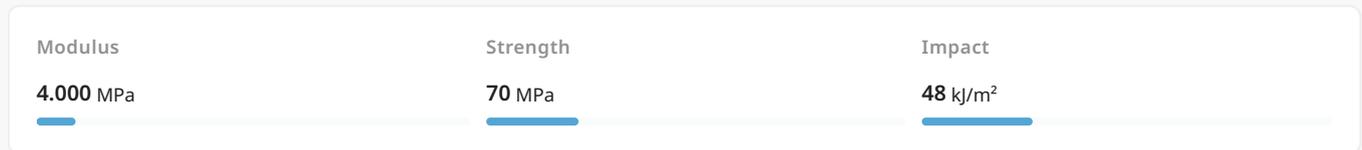
PK GF 10 FR(40)

AKROTEK® PK-VM GF 10 FR natural (8744) is a 10% glass fibre reinforced, flame retardant and process improved Polyketone compound. The flame retardant system is free of red phosphorous, melamine, PFAS and halogenes. Due to its good chemical resistance, good dimensional stability and high elongation at break it is suitable for high voltage components in e-mobility.

Features

hydrolysis / chemically stabilised flame retardant process improved E-Mobility

Properties



Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	4000 MPa
Tensile stress at break ISO 527-2	5 mm/min d.a.m.	70 MPa
Tensile strain at break ISO 527-2	5 mm/min d.a.m.	5,5 %
Charpy impact strength ISO 179-1/1eU	23°C d.a.m. -30°C d.a.m.	48 kJ/m² 50 kJ/m²
Charpy notched impact strength ISO 179-1/1eA	23°C d.a.m. -30°C d.a.m.	8 kJ/m² 6 kJ/m²

Thermal Properties

Melting temperature ISO 11357-3	DSC, 10K/min	220 °C
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Flammability

Flammability UL 94	0,8 mm Wall thickness	V-0 Class
	1,6 mm Wall thickness	V-0 Class
	3,2 mm Wall thickness	V-0 Class
GWFI IEC 60695-2-12	0,8 mm Wall thickness	960 °C
	1,6 mm Wall thickness	960 °C
	3,2 mm Wall thickness	960 °C
GWIT IEC 60695-2-13	0,8 mm Wall thickness	825 °C
	1,6 mm Wall thickness	850 °C
Burning rate (<100 mm/min) FMVSS 302	> 1 mm Thickness	+

General Properties

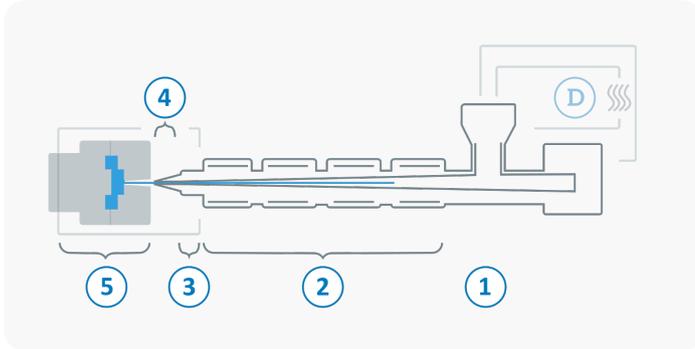
Density ISO 1183	23°C	1,34 g/cm ³
Humidity absorption ISO 1110	70°C, 62% r.H.	0,5 - 0,7 %
Molding shrinkage ISO 294-4	flow	0,5 - 0,7 %
	transverse	1,1 - 1,3 %

Electrical Properties

Comparative tracking index IEC 60112	Test liquid A	600 V
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Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	Drying time	0 - 4 h
	Drying temperature ($\tau \leq -30^{\circ}\text{C}$)	80 °C
	Processing moisture	0,02 - 0,1 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	210 - 240 °C
3	Nozzle temperature	230 - 240 °C
4	Melt temperature	230 - 240 °C
5	Mold temperature	60 - 100 °C
→	Holding pressure, spec.	300 - 800 bar
←	Back pressure, spec.	30 - 50 bar
	Injection speed	medium
	Screw speed	5 - 10 m/min



Polyketones crosslink depending on time and temperature, crosslinking is noticed by an increase of viscosity and/or dark spots in natural colored compounds. The melt temperature should be at or below 240 °C and under no circumstances go beyond 250 °C because crosslinking speed will increase. The use of a hot runner system is not recommended when processing polyketone. However, if it is used, it should be noted that the residence time in the barrel including the hot runner should not exceed 4 min. If interruptions of more than 4 minutes are expected, the barrel and hot runner need to be purged and cleaned with polyolefins. The molding machine needs to be purged with polyolefins before and after processing of AKROTEK® PK! There is a risk of cross linking caused by reactions with POM or PA as well as unsuitable masterbatches or cleaning compounds! Crosslinking is noticed by an increase of viscosity and or dark spots in natural colored compounds. In this case purge immediately with polyolefins. Further processing instructions are available on request.