Technical Data Sheet

Schulaketon GF 30

Polyketone, Aliphatic
LyondellBasell Industries
Engineering Plastics

Product Description	
30% glass fiber reinforced aliphatic Polyketon	

General	
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PK

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.47 g/cm³	1.47 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (240°c/2.16 Kg)	6.0 cm³/10min	6.0 cm³/10min	ISO 1133
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	1.13E+6 psi	7800 MPa	ISO 527-1/1A/1
Tensile Stress (Break)	19600 psi	135 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.5 %	3.5 %	ISO 527-2/1A/5
Flexural Modulus [1]	986000 psi	6800 MPa	ISO 178
Flexural Stress [1]			ISO 178
4.0% Strain	25400 psi	175 MPa	
3.5% Strain	24700 psi	170 MPa	
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-40°f (-40°c)	4.8 ft·lb/in²	10 kJ/m²	
73°f (23°c)	6.2 ft·lb/in²	13 kJ/m²	
Charpy Unnotched Impact Strength			
-40°f (-40°c)	33 ft·lb/in²	70 kJ/m²	ISO 179
73°f (23°c)	33 ft·lb/in²	70 kJ/m²	ISO 179/1eU
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			
66 Psi (0.45 Mpa), Unannealed	419 °F	215 °C	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	403 °F	206 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	403 °F	206 °C	ISO 306/B50
--	419 °F	215 °C	ISO 306/A50
Electrical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1
Comparative Tracking Index (Solution A)	600 V	600 V	IEC 60112

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Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 In (2.00 Mm)	< 3.9 in/min	< 100 mm/min	ISO 3795
0.0787 In (2.00 Mm)	< 3.9 in/min	< 100 mm/min	FMVSS 302
Flame Rating			UL 94
0.06 In (1.6 Mm)	HB	HB	IEC 60695-11-10, -20
0.13 In (3.2 Mm)	HB	HB	
Glow Wire Flammability Index			IEC 60695-2-12
0.06 In (1.5 Mm)	1290 °F	700 °C	
0.12 In (3.0 Mm)	1290 °F	700 °C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.06 In (1.5 Mm)	1340 °F	725 °C	
0.12 In (3.0 Mm)	1340 °F	725 °C	

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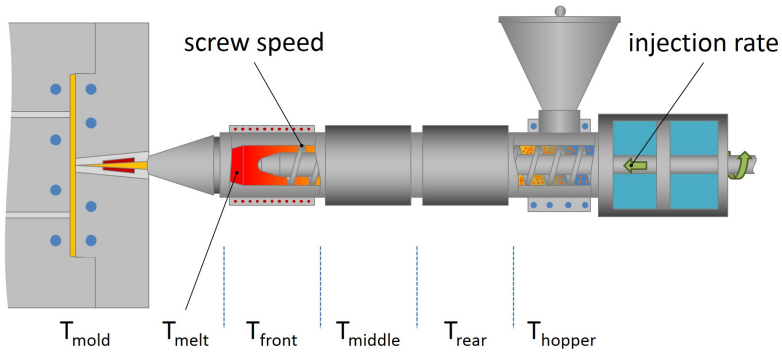

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.15 %	0.15 %
Processing (Melt) Temp	473 to 500 °F	245 to 260 °C
Mold Temperature	140 to 248 °F	60 to 120 °C

Injection Notes

Before start, nozzle, screw, barrel and hot-runner have to be cleaned with Polyolefin. Contamination of other material leads to degradation or crosslinking of SCHULAKETON®.

Avoid shut down for more than 15 minutes at moulding temperature, because of degradation and crosslinking of SCHULAKETON®. Purge with Polyolefin!

Notes

[1] 0.079 in/min (2.0 mm/min)

Notes

These are typical property values not to be construed as specification limits.