

Technical Data Sheet

SCHULAKETON LV Natural

Polyketone, Aliphatic
Engineering Plastics

Product Description

Low viscosity Aliphatic Polyketone for Melt-Blown Technology

General

- | | |
|---------------------|---------------------|
| Processing Method | • Injection Molding |
| Resin ID (ISO 1043) | • PK |

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
----------	-------------------------	--------------------	-------------

Density	1.23 g/cm ³	1.23 g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (240°C/2.16 kg)	190 cm ³ /10min	190 cm ³ /10min	ISO 1133
Molding Shrinkage	1.5 to 2.2 %	1.5 to 2.2 %	ISO 294-4

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
------------	-------------------------	--------------------	-------------

Tensile Modulus	260000 psi	1790 MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	9570 psi	66.0 MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	16 %	16 %	ISO 527-2/1A/50
Flexural Modulus ¹	281000 psi	1940 MPa	ISO 178
Flexural Stress ¹ (9.0% Strain)	10400 psi	72.0 MPa	ISO 178

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
--------	-------------------------	--------------------	-------------

Charpy Notched Impact Strength			ISO 179/1eA
-40°F (-40°C)	0.95 ft·lb/in ²	2.0 kJ/m ²	
73°F (23°C)	2.4 ft·lb/in ²	5.0 kJ/m ²	
Charpy Unnotched Impact Strength			
-40°F (-40°C)	No Break	No Break	ISO 179
73°F (23°C)	No Break	No Break	ISO 179/1eU

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
---------	-------------------------	--------------------	-------------

Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	354 °F	179 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	225 °F	107 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	412 °F	211 °C	ISO 306/A50
--	367 °F	186 °C	ISO 306/B50

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

Technical Data Sheet

SCHULAKETON LV Natural

Polyketone, Aliphatic
Engineering Plastics

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 IEC 60695-11-10, -20
0.06 in (1.6 mm)	HB	HB	
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	

Technical Data Sheet

SCHULAKETON LV Natural

Polyketone, Aliphatic
Engineering Plastics



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 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	437 to 464 °F	225 to 240 °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.