

Technical Data Sheet

Schulaketon NV NAT

Polyketone, Aliphatic

Product Description

Low viscosity aliphatic Polyketon

Processing Method Injection Molding**Resin ID** PK

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (240 °C/2.16 kg)	60	cm ³ /10 min	ISO 1133
Density, (Method A)	1.24	g/cm ³	ISO 1183
Mechanical			
Tensile Stress at Yield, (Type 1A, 50 mm/min)	65.0	MPa	ISO 527-2
Flexural Modulus, (2.0 mm/min)	1700	MPa	ISO 178
Tensile Strain at Yield, (Type 1A, 50 mm/min)	18	%	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	1650	MPa	ISO 527-1
Flexural Stress			
(2.0 mm/min, 3.5%)	40.0	MPa	ISO 178
(2.0 mm/min, 9.0%)	55.0	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	11	kJ/m ²	ISO 179
(-40 °C, Type 1, Edgewise, Notch A)	3.0	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	No Break		ISO 179
(-40 °C)	No Break		ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	186	°C	ISO 306
(A (10N), 50 °C/h)	200	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	184	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	89.0	°C	ISO 75-2/A
Electrical			
Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
Comparative Tracking Index (CTI), (Solution A)	600	V	IEC 60112
Surface Resistivity	>1.0E+15	ohm	IEC 60093

Flammable

Burning Rate			
(2.00 mm)	<100	mm/min	ISO 3795
(2.00 mm)	<100	mm/min	FMVSS 302
Glow Wire Flammability Index			
(1.5 mm)	700	°C	IEC 60695-2-12
(3.0 mm)	700	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			
(1.5 mm)	725	°C	IEC 60695-2-13
(3.0 mm)	725	°C	IEC 60695-2-13

UL Information

Flame Rating			
(1.6 mm)	HB		UL 94
(3.2 mm)	HB		UL 94
Flammability Classification			
(1.6 mm)	HB		IEC 60695-11-10, -20
(3.2 mm)	HB		IEC 60695-11-10, -20

Injection Parameters	Nominal Value	Units
Drying Time	3.0 to 4.0	hr
Drying Temperature	80	°C
Suggested Max Moisture	0.15	%
Processing (Melt) Temp	225 to 240	°C
Mold Temperature	60 to 120	°C