POKETONE® M93FG6C-BK0

Description

Glass-reinforced high-flow injection molding grade for Automotive Cooling Fan

Physical Properties	ASTM	Value	ISO	Value
Density	D792	1.35 g/cm^3	1183	1.35 g/cm^3
Shore D hardness	D2240		868	
Hardness Rockwell	D785		2039	
Water absorption equilibrium at RH 50%	D570		62	
Water absorption at Saturation	D570		62	
Melt flow index 240°C/2.16kg	D1238	26 g/10 min	1133	
Mold Shrinkage	D955 MD, 3 mm TD, 3 mm		294-4	
	MD, 2 mm TD, 2 mm			

Mechanical Properties	ASTM	Value	ISO	Value
Tensile strength at yield	D638		527-1	121 MPa
Tensile modulus	D638		527-1	6,690 MPa
Tensile elongation at yield	D638		527-1	
Tensile elongation at break	D638		527-1	3.0 %
Flexural strength	D790		178	164 MPa
Flexural modulus	D790		178	5,200 MPa
Unnotched Izod impact strength	D256		180/1U	
Notched Izod impact strength	D256		180/1A	
Unnotched Charpy impact strength	D6110		179/1eU	
Notched Charpy impact strength	D6110		179/1eA	9.2 kJ/m^2
Falling dart impact strength			6603-2	

Thermal Properties	ASTM	Value	ISO	Value
Melting temperature	D3418	222 °C	11357	222 °C
Coefficient of linear thermal expansion,	E831 TD		11359	

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25 ~ 55°C	MD	
Vicat softening point	D1525	306/B50
	5 kg	50 N
Heat deflection temperature	D648	75
	66 psi	0.45 MPa
	264 psi	1.8 MPa

Electrical Properties

	Test Method & Condition	Value
Dielectric Strength (DS)	ASTM D149	
	3 mm	
	2 mm	
Volume Resistivity (VR)	ASTM D257	
Surface Resistivity (SR)	ASTM D257	
Dielectric constant at 60Hz	ASTM D150	
Dissipation factor at 60Hz	ASTM D150	

Injection Molding Processing Conditions

		Value
Pre-drying	Drying temperature	80 °C
	Drying time	3 ~ 4 hr
	Suggested max moisture	0.20 %
Temperature	Nozzle temperature	240 °C
	Zone 1 temperature	230 °C
	Zone 2 temperature	220 °C
	Zone 3 temperature	215 °C
	Zone 4 temperature	210 °C
	Processing temperature	225 ~ 240 °C
	Mold temperature	60 ~ 80 °C
Pressure	Back pressure	0.294 ~ 0.686 MPa
Speed	Screw Speed	50 ~ 100 rpm

* The data listed here is not for specification warranty, but typical value.

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