

POKETONE® M33FG9A

Description

50% glass-reinforced high flow injection molding grade with Food/Drinking water Compliance

Physical Properties	ASTM	Value	ISO	Value
Density	D792	1.69 g/cm ³	1183	1.69 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	3 g/10 min	1133	
Mold Shrinkage	D955		294-4	
	MD, 3 mm			
	TD, 3 mm			
	MD, 2 mm			
	TD, 2 mm			

Mechanical Properties	ASTM	Value	ISO	Value
Tensile strength at yield	D638	155 MPa	527-1	
Tensile modulus	D638	14,000 MPa	527-1	
Tensile elongation at yield	D638	2.9 %	527-1	
Tensile elongation at break	D638	2.9 %	527-1	
Flexural strength	D790	210 MPa	178	
Flexural modulus	D790	10,000 MPa	178	
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	15 kJ/m²
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, 25 ~ 55°C	E831			
	TD		11359	
	MD			
Vicat softening point	D1525		306/B50	
	5 kg		50 N	
Heat deflection temperature	D648		75	
	66 psi	215 °C	0.45 MPa	
	264 psi	210 °C	1.8 MPa	



Injection Molding Processing Conditions Value Drying temperature 80°C 3 ~ 4 hr Pre-drying Drying time 0.20 % Suggested max moisture Nozzle temperature 240 °C Zone 1 temperature 230 °C Zone 2 temperature 220°C **Temperature** Zone 3 temperature 215 °C Zone 4 temperature 210°C 225 ~ 240 °C Processing temperature 80 ~ 130 °C Mold temperature Pressure Back pressure 0.3 ~ 0.7 MPa Speed Screw Speed 50 ~ 100 rpm

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