

Compound No.: 7575

AKROTEK® PK-VM M 10 natural (7575)

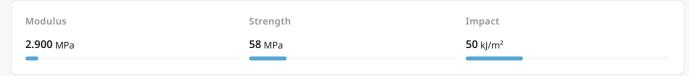
PΚ

AKROTEK® PK-VM M 10 natural (7575) is a 10% mineral reinforced Polyketone with high flowability, isotropic shrinkage and dark inherent color. The outstanding friction and wear properties enable the use for demanding components exposed to tribological stress. PK is characterized by its outstanding media resistance, which qualifies it to be used for components that are in contact with chemicals. The most important markets for AKROTEK® PK are the automotive and furniture industry and mechanical engineering.

Features

hydrolysis / chemically stabilised

Properties



Mechanical Properties

Tensile modulus ISO 527-2	1 mm/min d.a.m.	2900 MPa
Tensile stress at yield ISO 527-2	50 mm/min d.a.m.	58 MPa
Tensile strain at break ISO 527-2	50 mm/min d.a.m.	> 10 %
Charpy impact strength ISO 179-1/1eU	23°C d.a.m.	50 kJ/m²
Charpy notched impact strength ISO 179-1/1eA	23°C d.a.m.	7,5 kJ/m²

Thermal Properties

Melting temperature	DSC. 10K/min	220 °C
ISO 11357-3	DSC, TOTOTHIN	220 C



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General Properties

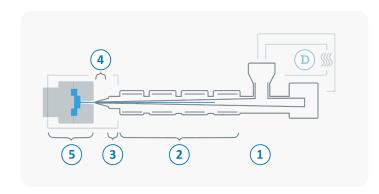
Density ISO 1183	23°C	1,31 g/cm³
Humidity absorption ISO 1110	70°C, 62% r.H.	0,7 - 0,8 %
Molding shrinkage ISO 294-4	flow transverse	1,6 % 1,6 %





Processing

The values mentioned are recommendations. We only recommend desiccant / dry air dryers or vacuum dryers. Too long a drying time and the resulting residual moisture content below the lower limit can lead to filling problems and surface defects. The specified drying time refers to closed and undamaged bagged material. When processing from previously opened bags or from octabins with polyolefin inliners, a longer drying time may be necessary. It is recommended to check the residual moisture content after the drying process.



D	Drying time	0 - 4 h
	Drying temperature (τ <= -30°C)	80 °C
	Processing moisture	0,02 - 0,1 %
1	Feed section	60 - 80 °C
2	Temperature Zone 1 - Zone 4	220 - 260 °C
3	Nozzle temperature	230 - 260 °C
4	Melt temperature	230 - 260 °C
5	Mold temperature	60 - 120 °C
\ominus	Holding pressure, spec.	300 - 800 bar
\bigcirc	Back pressure, spec.	30 - 70 bar
	Injection speed	medium to high
	Screw speed	8 - 15 m/min



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Diagrams

