

POKETONE® M33AR5A

Description

High toughness injection molding grade

Physical Properties

	ASTM	Value	ISO	Value
Density	D792	1.11 g/cm ³	1183	1.11 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	14 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	30 MPa	527-1	
Tensile modulus	D638		527-1	
Tensile elongation at yield	D638		527-1	
Tensile elongation at break	D638	120 %	527-1	
Flexural strength	D790	25 MPa	178	
Flexural modulus	D790	700 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	80 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, 25 ~ 55°C	E831		11359	
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	



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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