

POKETONE® M710F

Description

Food & drug extrusion grade

Physical Properties

	ASTM	Value	ISO	Value
Density	D792	1.22 g/cm ³	1183	1.22 g/cm ³
Shore D hardness	D2240		868	75
Hardness Rockwell	D785	105	2039	
Water absorption equilibrium at RH 50%	D570	0.5 %	62	0.5 %
Water absorption at Saturation	D570	2.2 %	62	2.2 %
Melt flow index 220°C/2.16kg	D1238	3 g/10 min	1133	2.8 ml/10 min
	D955		294-4	
Mold Shrinkage	MD, 3 mm	1.7 %		
	TD, 3 mm	1.7 %		
	MD, 2 mm			
	TD, 2 mm			

Mechanical Properties

	ASTM	Value	ISO	Value
Tensile strength at yield	D638	43 MPa	527-1	43 MPa
Tensile modulus	D638	950 MPa	527-1	900 MPa
Tensile elongation at yield	D638	19 %	527-1	19 %
Tensile elongation at break	D638	≥ 200 %	527-1	≥ 200 %
Flexural strength	D790	40 MPa	178	40 MPa
Flexural modulus	D790	900 MPa	178	850 MPa
Unnotched Izod impact strength	D256	N.B.	180/1U	N.B.
Notched Izod impact strength	D256		180/1A	
	23 °C	200 J/m	23 °C	15 kJ/m ²
	-30 °C	50 J/m	-30 °C	4 kJ/m ²
Unnotched Charpy impact strength	D6110		179/1eU	N.B.
Notched Charpy impact strength	D6110		179/1eA	
			23 °C	14 kJ/m ²
			-30 °C	3 kJ/m ²
Falling dart impact strength			6603-2	

Thermal Properties

	ASTM	Value	ISO	Value
Melting temperature	D3418	197 °C	11357	197 °C
Coefficient of linear thermal expansion	E831		11359	
	25 ~ 55°C	1.0×10 ⁻⁴		
Vicat softening point	D1525		306/B50	
	5 kg	155 °C	50 N	152 °C
Heat deflection temperature	D648		75	
	66 psi	155 °C	0.45 MPa	140 °C
	264 psi	75 °C	1.8 MPa	65 °C



Flammability Properties

	Test Method & Condition	Value
Flame resistance	UL 94	HB (0.8 mm)

Electrical Properties

	Test Method & Condition	Value
Dielectric Strength (DS)	ASTM D149	
	3 mm	15 kV/mm
	2 mm	19 kV/mm
Volume Resistivity (VR)	ASTM D257	10 ¹⁴ Ω-cm
Surface Resistivity (SR)	ASTM D257	10 ¹⁷ Ω /m ²
Dielectric constant at 60Hz	ASTM D150	6.4
Dissipation factor at 60Hz	ASTM D150	0.014

Extrusion Processing Conditions

	Value
Pre-drying	Drying temperature
	80 °C
	Drying time
Temperature	3 ~ 4 hr
	Suggested max moisture
	0.20 %
	Adapter & Die temperature
	210 °C
	Zone 5 temperature
	210 °C
	Zone 4 temperature
	210 °C
	Zone 3 temperature
	215 °C
Screw Design	Zone 2 temperature
	225 °C
	Zone 1 temperature
	230 °C
	Jacket temperature
	< 50 °C
	Processing temperature
	210 ~ 230 °C
	L/D
	> 26
	Compression ratio
	2.5 ~ 3.0

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

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