

Technical Data Sheet



Schulaketon CF 10

Polyketone, Aliphatic
LyondellBasell Industries
Engineering Plastics

Product Description

10% carbon fiber reinforced aliphatic Polyketone

General

Material Status	• Commercial: Active
Availability	• Europe
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PK CF10

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.27 g/cm ³	1.27 g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (240°C/2.16 kg)	20 cm ³ /10min	20 cm ³ /10min	ISO 1133
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	972000 psi	6700 MPa	ISO 527-1/1A/1
Tensile Stress (Break)	14100 psi	97.0 MPa	ISO 527-2
Tensile Strain (Break)	2.5 %	2.5 %	ISO 527-2
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength (73°F (23°C))	2.9 ft·lb/in ²	6.0 kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength 73°F (23°C)	20 ft·lb/in ²	42 kJ/m ²	ISO 179/1eU
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed	410 °F	210 °C	ISO 75-2/Af
Vicat Softening Temperature	392 °F	200 °C	ISO 306/B50
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	ISO 3795
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	FMVSS 302
Flame Rating			UL 94
0.06 in (1.6 mm)	HB	HB	IEC 60695-11-10,
0.13 in (3.2 mm)	HB	HB	-20

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.15 %	0.15 %
Processing (Melt) Temp	473 to 500 °F	245 to 260 °C
Mold Temperature	140 to 248 °F	60 to 120 °C

Injection Notes

Before start, nozzle, screw, barrel and hot-runner have to be cleaned with Polyolefin. Contamination of other material leads to degradation or crosslinking of SCHULAKETON®.
Avoid shut down for more than 15 minutes at moulding temperature, because of degradation and crosslinking of SCHULAKETON®. Purge with Polyolefin!

Notes

These are typical property values not to be construed as specification limits.

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Product Storage and Handling

- Product should be stored in dry conditions at temperatures below 50°C and protected from UV-light
- Improper storage may bring damage to the packaging and can negatively affects on the quality of this product
- Keep material completely dry for good processing

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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