

Technical Data Sheet



Schulaketon GF30 4DE SF ORE962591

Polyketone, Aliphatic
LyondellBasell Industries
Engineering Plastics

Product Description

30% glass fiber reinforced aliphatic Polyketone, flame-retardant, halogen free. Available in orange colour.

General

Material Status	• Experimental: Active
Availability	• Europe
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Features	• Flame Retardant • Halogen Free
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PK GF30 FR(40)

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.47 g/cm ³	1.47 g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (240°C/5.0 kg)	20 cm ³ /10min	20 cm ³ /10min	ISO 1133
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	1.16E+6 psi	8000 MPa	ISO 527-1/1A/1
Tensile Stress (Break)	18100 psi	125 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	4.0 %	4.0 %	ISO 527-2/1A/5
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength (73°F (23°C))	6.2 ft·lb/in ²	13 kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength 73°F (23°C)	38 ft·lb/in ²	80 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	408 °F	209 °C	ISO 75-2/Af
RTI Elec			UL 746B
0.016 in (0.40 mm)	122 °F	50.0 °C	
0.024 in (0.60 mm)	122 °F	50.0 °C	
0.031 in (0.8 mm)	122 °F	50.0 °C	
0.06 in (1.6 mm)	122 °F	50.0 °C	
0.12 in (3.0 mm)	122 °F	50.0 °C	
RTI Imp			UL 746B
0.016 in (0.40 mm)	122 °F	50.0 °C	
0.024 in (0.60 mm)	122 °F	50.0 °C	
0.031 in (0.8 mm)	122 °F	50.0 °C	
0.06 in (1.6 mm)	122 °F	50.0 °C	
0.12 in (3.0 mm)	122 °F	50.0 °C	
RTI Str			UL 746B
0.016 in (0.40 mm)	122 °F	50.0 °C	
0.024 in (0.60 mm)	122 °F	50.0 °C	
0.031 in (0.8 mm)	122 °F	50.0 °C	
0.06 in (1.6 mm)	122 °F	50.0 °C	
0.12 in (3.0 mm)	122 °F	50.0 °C	
Electrical	Nominal Value (English)	Nominal Value (SI)	Test Method
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1
Electric Strength			IEC 60243-1
73°F (23°C), 0.0394 in (1.00 mm), in Air	970 V/mil	38 kV/mm	
Comparative Tracking Index	600 V	600 V	IEC 60112

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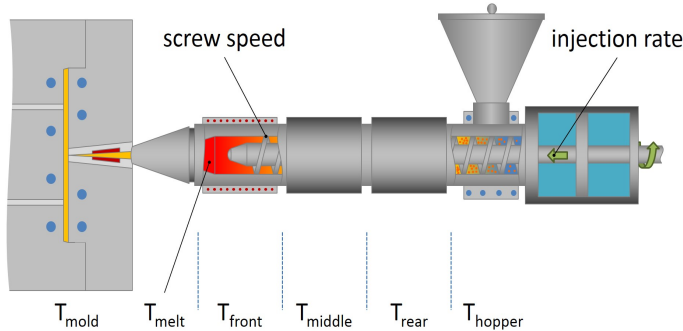
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 in (2.00 mm), Self-Extinguishing	0.0 in/min	0.0 mm/min	ISO 3795
0.0787 in (2.00 mm), Self-Extinguishing	0.0 in/min	0.0 mm/min	FMVSS 302
Flame Rating			
0.031 in (0.8 mm)	V-0	V-0	UL 94
0.06 in (1.6 mm)	V-0	V-0	UL 94 IEC 60695-11-10, -20
0.12 in (3.0 mm)	V-0	V-0	UL 94 IEC 60695-11-10, -20
0.03 in (0.8 mm)	V-0	V-0	IEC 60695-11-10, -20
Glow Wire Flammability Index			IEC 60695-2-12
0.031 in (0.8 mm)	1760 °F	960 °C	
0.06 in (1.6 mm)	1760 °F	960 °C	
0.12 in (3.0 mm)	1760 °F	960 °C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.031 in (0.8 mm)	1520 °F	825 °C	
0.06 in (1.6 mm)	1560 °F	850 °C	
0.12 in (3.0 mm)	1520 °F	825 °C	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.15 %	0.15 %
Processing (Melt) Temp	428 to 446 °F	220 to 230 °C
Mold Temperature	140 to 212 °F	60 to 100 °C
Injection Rate	Slow-Moderate	Slow-Moderate
Back Pressure	290 to 1160 psi	2.00 to 8.00 MPa
Screw Speed	< 591 in/min	< 15 m/min

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 8 minutes at moulding temperature, because of degradation and crosslinking of SCHULAKETON®. Purge with Polyolefin!

Mould surfaces in contact with melt are recommended to be of non-corrosive steel, chrome content >12%

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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