

POKETONE® M330F-S

Description

High-flow injection molding grade (Food Contact)

Physical Properties	ASTM	Value	ISO	Value
Density	D792	1.24 g/cm ³	1183	1.24 g/cm ³
Shore D hardness	D2240		868	77
Hardness Rockwell	D785	110	2039	
Water absorption equilibrium at RH 50%	D570	0.5 %	62	0.5 %
Water absorption at Saturation	D570	2.1 %	62	2.1 %
Melt flow index 240°C/2.16kg	D1238	60 g/10 min	1133	56 ml/10 min
Mold Shrinkage	D955		294-4	
	MD, 3 mm	2.0 %		
	TD, 3 mm	2.0 %		
	MD, 2 mm	1.6 %		
	TD, 2 mm	1.5 %		

Mechanical Properties	ASTM	Value	ISO	Value
Tensile strength at yield	D638	60 MPa	527-1	60 MPa
Tensile modulus	D638	1,600 MPa	527-1	1,500 MPa
Tensile elongation at yield	D638	21 %	527-1	21 %
Tensile elongation at break	D638	≥ 200 %	527-1	≥ 200 %
Flexural strength	D790	57 MPa	178	57 MPa
Flexural modulus	D790	1,500 MPa	178	1,400 MPa
Unnotched Izod impact strength	D256	N.B.	180/1U	N.B.
Notched Izod impact strength	D256		180/1A	
	23 °C	95 J/m	23 °C	7 kJ/m ²
	-10 °C	60 J/m	-10 °C	4 kJ/m ²
	-30 °C	40 J/m	-30 °C	3 kJ/m ²
Unnotched Charpy impact strength	D6110		179/1eU	N.B.
Notched Charpy impact strength	D6110		179/1eA	
		23 °C	8 kJ/m ²	
		-10 °C	4 kJ/m ²	
	-30 °C	2 kJ/m ²		
Falling dart impact strength			6603-2	50 J
			23 °C	

Thermal Properties	ASTM	Value	ISO	Value
Melting temperature	D3418	222 °C	11357	222 °C
Coefficient of linear thermal expansion	E831	9.7×10 ⁻⁵	11359	
	25 ~ 55°C			
Vicat softening point	D1525	195 °C	306/B50	195 °C
	5 kg		50 N	
Heat deflection temperature	D648		75	
	66 psi	200 °C	0.45 MPa	190 °C
	264 psi	105 °C	1.8 MPa	92 °C

Flammability Properties

	Test Method & Condition	Value
Flame resistance	UL 94	HB (0.8 mm)
Glow Wire Ignition Temperature (GWIT)	IEC 60695-2-13	725 °C (0.8 mm)
Glow Wire Flammability Index (GWFI)	IEC 60695-2-12	700 °C (0.8 mm)

Electrical Properties

	Test Method & Condition	Value
Dielectric Strength (DS)	ASTM D149	23 kV/mm
Volume Resistivity (VR)	ASTM D257	10 ¹² Ω-cm
Surface Resistivity (SR)	ASTM D257	10 ¹⁷ Ω/m ²
Dielectric constant at 60Hz	ASTM D150	6.2
	IEC 250	5
Dissipation factor at 60Hz	ASTM D150	0.008
	IEC 250	0.013
Hot Wire Ignition (HWI)	UL 746A	PLC 4 (0.8 mm)
		PLC 3 (1.5 mm)
		PLC 2 (3.0 mm)
High Amp Arc Ignition (HAI)	UL 746A	PLC 0 (0.8 mm)
High Volt arc Track Rate (HVTR)	UL 746A	PLC 0
High voltage, low current Arc Resistance (AR)	ASTM D495	PLC 4
Comparative Tracking Index (CTI)	ASTM D3638	PLC 0

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.

All products purchased from or supplied by Hyosung Chemical Corporation are subject to terms and conditions set out in the contract, order acknowledgement and/or bill of loading. Values given above are simply references for representing typical level and do not expressly or impliedly guarantee anything. Neither should it be interpreted as specification limit nor sole criterion for part/tool design that is intended to have a legal binding effect. All other information, including that herein, supplied by Hyosung Chemical is considered accurate but is furnished upon the express condition that the customer shall make its own assessment to determine the product's suitability for a particular purpose. Hyosung Chemical makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the use of such other information or product will not infringe any patent. Any references in this brochure to "Hyosung Chemical" refer to the collectivity of Hyosung Chemical engaged in the manufacture and sale of chemical products. Particular contracts are entered into by any such company individually and any warranty, representation or any other commitment provided by Hyosung Chemical is the commitment of such individual company only.