

Star L POK D51 - BK84034

Polyketone
Eurostar Engineering Plastics

Message:
Star L POK D51 is an Unfilled, PTFE Lubricated Aliphatic Polyketone Injection Molding Resin (Preliminary Datasheet)

General Information			
Additive	PTFE lubricant		
Features	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm ³	ISO 1183
shrinkage-Flow (24 hr)	2.0 - 2.6	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	47.0	MPa	ISO 527-2
Tensile Strain (Break)	> 10	%	ISO 527-2
Flexural Modulus	1400	MPa	ISO 178
Flexural Stress	44.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	6.5	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ¹ (1.8 MPa, Unannealed, 64.0 mm Span)	62.0	°C	ISO 75-2/Af
Melting Temperature (DSC)	223	°C	ISO 3146
Injection	Nominal Value	Unit	
Drying Temperature	70 - 80	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	225 - 235	°C	
Middle Temperature	225 - 235	°C	
Front Temperature	225 - 235	°C	
Processing (Melt) Temp	225 - 235	°C	
Mold Temperature	70 - 80	°C	
NOTE			
1.	80x10x4 mm		

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