

# POKETONE® M33FM2A-WH1

## Description

10% Mineral-reinforced grade  
 Purpose: Food Contact, Outdoor  
 Color: White

## Physical Properties

	Value	Unit	Test Method & Condition
Density	1.35	g/cm <sup>3</sup>	ASTM D792
Melt flow index 240°C/2.16kg	40	g/10min	ASTM D1238

## Mechanical Properties

	Value	Unit	Test Method & Condition
Tensile strength at yield	50	MPa	ASTM D638
Tensile elongation at break	15	%	ASTM D638
Flexural strength	65	MPa	ASTM D790
Flexural modulus	2,300	MPa	ASTM D790
Notched Charpy impact strength	6	kJ/m <sup>2</sup>	ISO 179/1eA, 23°C

## Thermal Properties

	Value	Unit	Test Method & Condition
Melting temperature	222	°C	ASTM D3418

## Injection Molding Processing Conditions

		Value	Unit
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	235 ~ 250	°C
	Mold temperature	60 ~ 80	°C
Pressure	Back pressure	0.3 ~ 0.7	MPa
Speed	Screw Speed	50 ~ 100	rpm

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