

ResMart Ultra PK6 - General purpose Polyketone resin for injection molding
and extrusion applications

Technical Data Sheet Properties

Physical Property	Value	Test Method
Specific Gravity	1.24	ASTM D 792
Melt Flow Rate @ 240°C - 2.16kg	6.0 g/10 min	ASTM D 1238
Mold Shrinkage	1.5 - 2.3 %	ASTM D 955

Mechanical Property	Value	Test Method
Tensile Strength	8400 psi	ASTM D 638
Tensile Strain at Yield	22 %	ASTM D638
Tensile Strain at Break	300 %	ASTM D638
Flexural Strength	7700 psi	ASTM D 790
Flexural Modulus	195000 psi	ASTM D 790
Notched Izod Impact Strength	4.0 ft-lb/in.	ASTM D256

Thermal Property	Value	Test Method
HDT (66 psi) Unannealed	383 °F	ASTM D 648
HDT (264 psi) Unannealed	215 °F	ASTM D 648
Vicat Softening Point	377 °F	ASTM D 1525

Regulatory Compliance	Value
FDA Compliance	Yes
RoHS Compliance	Yes

Processing Guidelines	Value
Drying Temperature	160 - 180 °F
Drying Time	2 - 4 Hours
Melt Temperature	450 - 470 °F
Mold Temperature	150 - 200 °F
Injection Pressure	10000 - 15000 psi

The information provided on this datasheet should only be used as a guideline. Actual lot to lot values will vary.

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