

POM | KEPITAL F30-03 | Standard grade

- A standard unfilled(medium-low viscosity) grade for general injection molding.

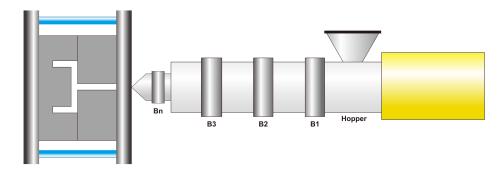
- Suitable for multi-cavity molds and thin-walled parts.

Physical properties	Test Standard	Unit	Value
Density	ISO 1183	g/cm ³	1.41
Melt flow rate	ISO 1133	g/10min	27
Water absorption(23 °C, 50 %RH)	ISO 62	%	0.2
101	Trat Star Jan J	TT *4	¥7-1
Thermal properties	Test Standard	Unit	Value
Heat deflection temperature(1.8 MPa)	ISO 75	°C	101
Flammability	UL 94	-	HB
Melting point	ISO 11357	°C	165
Coefficient of linear thermal expansion	ISO 11359	X 10 ⁻⁵ /°C	12
Mechanical properties	Test Standard	Unit	Value
Tensile modulus	ISO 527	MPa	2,850
Tensile strength	ISO 527	MPa	65
Tensile strain at yield	ISO 527	%	8
Strain at break	ISO 527	%	25
Flexural strength	ISO 178	MPa	90
Flexural modulus	ISO 178	MPa	2,700
Charpy impact strength(Notched) @ 23°C	ISO 179/1eA	kJ/m ²	5.5
Charpy impact strength(Notched) @ -30°C	ISO 179/1eA	kJ/m ²	5.0
Electrical properties	Test Standard	Unit	Value
Surface resistivity	IEC 60093	Ω	1×10^{16}

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Volume resistivity	IEC 60093	Ω/ cm	$1 x 10^{14}$
Dielectric strength	IEC 60243-1	kV/mm	19
Other	Test Standard	Unit	Value
Other Mold shrinkage(flow direction, $\Phi = 100 \text{ mm}, t = 3 \text{ mm}$)	Test Standard KEP Method	Unit %	Value 2.0

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Pre-drying (Suggested max. moisture : 0.1%)

It is recommend to dry material at 80° C ~ 100° C(176° F ~ 212° F) for 3 h ~ 4 h if necessary.

Temperature

Mold temperature : $60 \degree C \sim 80 \degree C(140 \degree F \sim 176 \degree F)$ Barrel temperature : $170 \degree C \sim 210 \degree C(338 \degree F \sim 410 \degree F)$

Mold	Bn(Nozzle)	B3(Metering)	B2(Compression)	B1(Feeding)	Hopper
60 ~ 80 °C	180 ~ 210 °C	190 ~ 200 °C	180 ~ 190 °C	170 ~ 180 °C	60 ~ 80 °C
140 ~ 176 °F	356 ~ 410 °F	374 ~ 392 °F	356 ~ 374 °F	338 ~ 356 °F	140 ~ 176 °F

Plastification

Screw speed : 150 mm/s ~ 200 mm/s Back pressure : Maximum 20 bar

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