

POM | KEPITAL F40-34 | Standard grade

- An extra easy-flowing (extremely easy-flowing) grade for general injection molding.
- Suitable for multi-cavity molds and very thin-walled parts.

General information	Test Standard	Unit	Value
Polymer abbreviation	ISO 1043	-	POM

Physical properties	Test Standard	Unit	Value
Water absorption(23 °C, 50 %RH)	ISO 62	%	0.2
Density	ISO 1183	g/cm ³	1.41
Melt flow rate	ISO 1133	g/10min	75

Thermal properties	Test Standard	Unit	Value
Heat deflection temperature (1.8 MPa)	ISO 75	°C	101
Flammability	UL 94	-	HB
Coefficient of linear thermal expansion	ISO 11359	X 10 ⁻⁵ /°C	12
Melting point	ISO 11357	°C	165

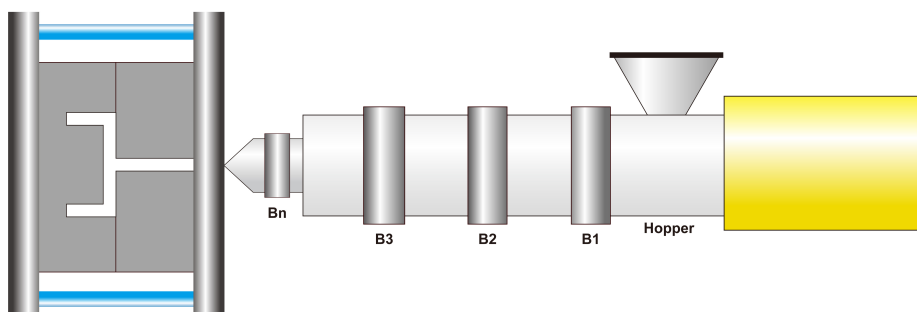
Mechanical properties	Test Standard	Unit	Value
Tensile modulus	ISO 527	MPa	2900
Tensile stress	ISO 527	MPa	65
Tensile strain at yield	ISO 527	%	-
Nominal strain at break	ISO 527	%	13
Flexural strength	ISO 178	MPa	93
Flexural modulus	ISO 178	MPa	2700
Charpy impact strength(Notched) @ 23°C	ISO 179/1eA	kJ/m ²	3.5
Charpy impact strength(Notched) @ -30°C	ISO 179/1eA	kJ/m ²	2.2

Electrical properties	Test Standard	Unit	Value
Surface resistivity	IEC 60093	Ω	1x10 ¹⁶
Volume resistivity	IEC 60093	Ω/ cm	1x10 ¹⁴
Dielectric strength	IEC 60243-1	kV/mm	19

Other	Test Standard	Unit	Value
Mold shrinkage (Flow direction)	ISO294-4	%	2.0

Revision No : 7 (2020.04.03)

Injection molding condition



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

Pre-drying : 80°C ~ 90°C 3h ~ 4h

Temperature

Mold temperature : 60°C ~ 80°C (140°F ~ 176°F)

Barrel temperature : 170°C ~ 210°C (338°F ~ 410°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 : 150mm/s ~ 200mm/s

Back pressure : Maximum 20 bar

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