

POM | KEPITAL F10-02 | Standard grade

- A high-viscosity grade for extrusion of round bars, sheets, and tubes
- Suitable for extrusion molding of thick-walled, void-free and sink mark-reduced 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	3.0

Thermal properties	Test Standard	Unit	Value
Heat deflection temperature (1.8 MPa)	ISO 75	°C	96
Flammability	UL 94	-	HB
Coefficient of linear thermal expansion	ISO 11359	X 10 ⁻⁵ /°C	12
Melting point	ISO 11357	°C	165

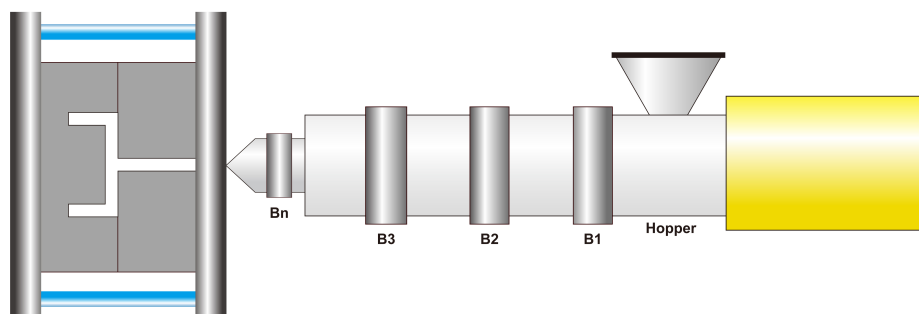
Mechanical properties	Test Standard	Unit	Value
Tensile modulus	ISO 527	MPa	2600
Tensile stress	ISO 527	MPa	63
Tensile strain at yield	ISO 527	%	10
Nominal strain at break	ISO 527	%	32
Flexural strength	ISO 178	MPa	84
Flexural modulus	ISO 178	MPa	2400
Charpy impact strength(Notched) @ 23°C	ISO 179/1eA	kJ/m ²	8.0
Charpy impact strength(Notched) @ -30°C	ISO 179/1eA	kJ/m ²	6.5

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, t = 2 mm)	ISO 294-4	%	2.0

Revision No : 7 (2020-04-03)

Injection molding condition



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

Pre-drying : 80 °C ~ 90 °C 3 h ~ 4 h

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 : 150 mm/s ~ 200 mm/s

Back pressure : Maximum 20 bar

Contact information

Headquarters

T Tower 10F, 30, Sowol-ro 2-gil, Jung-gu, Seoul, Republic of Korea (04637)
TEL: +82-2-6952-8377

KPAC China

Room T2-903C, No.2 building. SOHO Tianshan Plaza.
No.1717 Tianshan Rd. Changning District. Shanghai. China
Tel +86 21 6237-1972, Telefax +86 21 6237-1803

Research Center

Wavetech B/D, 7F, 15, Iljik-ro 94gil, Anyang city, Republic of Korea (13901)
TEL: +82-31-436-1300

Disclaimer

Notice to users : The information contained in this data sheet is based on our current knowledge and experience, so it may change as new knowledge and experience becomes available. This information is based on only above-mentioned product produced in Korea Polyacetal Co., Ltd. ("KPAC") through relevant test methods and conditions and doesn't relate to any products made of this product with the inclusion of other additives, such as processing aids or colorants. This information should not be construed as a promise or guarantee of specific properties of this product described or its suitability for a particular application, so users make their own determination as to its suitability to their purposes prior to use this product. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of this product. This product is not intended for use in medical and dental implants and users should meet all safety and health standards. KPAC makes no warranty and assumes no liability in connection with any use of this information.