

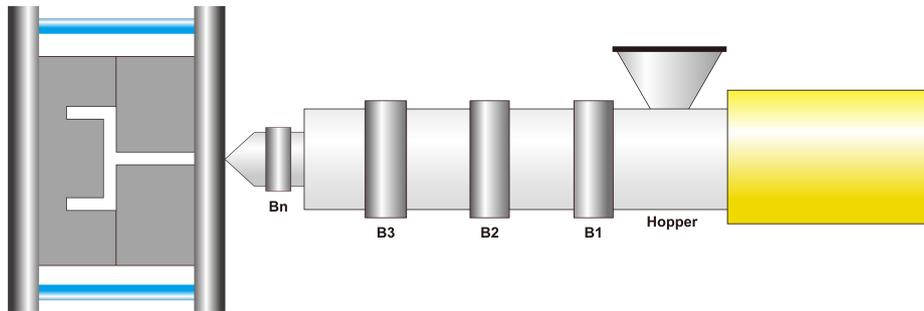
POM | KEPITAL F20-03 | 标准牌号

- 普通注塑成型的中粘度牌号
- 注塑成型应用的普通共聚聚甲醛牌号

基本信息	测试方法	单位	值
聚合物	ISO 1043	-	POM
物理性能	测试方法	单位	值
吸水率	ISO 62	%	0.2
密度	ISO 1183	g/cm ³	1.41
溶体质量流动速率	ISO 1133	g/10min	9.0
热性能	测试方法	单位	值
热变形温度(1.8 MPa)	ISO 75		100
燃烧性	UL 94	-	HB
线性膨胀系数	ISO 11359	X 10 ⁻⁵ /	12
熔融温度	ISO 11357		165
机械性能	测试方法	单位	值
拉伸模量	ISO 527	MPa	2,750
拉伸强度	ISO 527	MPa	65
屈服伸长率	ISO 527	%	10
断裂标称应变	ISO 527	%	32
弯曲强度	ISO 178	MPa	87
弯曲模量	ISO 178	MPa	2,550
简支梁冲击强度 (缺口, 23)	ISO 179/1eA	kJ/m ²	6.5
简支梁冲击强度 (缺口, -30)	ISO 179/1eA	kJ/m ²	5.5
电气性能	测试方法	单位	值
表面电阻率	IEC 60093		1x10 ¹⁶
体积电阻率	IEC 60093	· cm	1x10 ¹⁴
介电强度	IEC 60243-1	kV/mm	19
Other	测试方法	单位	值
成型收缩率(流动方向, t = 2 mm)	ISO 294-4	%	2.0

Revision No : 4 (2020-06-24)

注塑条件



预干燥 (建议最大吸水率为 : 0.1 %)

推荐干燥条件 80 °C ~ 90 °C (176 ~ 194) for 3 h ~ 4 h

温度

模具温度 : 60 ~ 80 (140 ~ 176)

料筒温度 : 170 ~ 210 (338 ~ 410)

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

塑化

螺杆转速 : 150 mm/s ~ 200 mm/s

背压 : Maximum 20 bar

联系信息

总部

首尔特别市中区小公路94 OCI大厦14楼
02-728-7481

GPAC Shanghai

SOHO Tianshan Plaza. No.1717 Tianshan Rd.
Changning District. Shanghai, China
+86-21-6237-1977

研究所

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

平泽工厂

京畿道平泽市彭城邑秋八产业园1街82号
82-31-691-3003

放弃

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