

## KEPITAL® F10-03HM

POM, copolymer, unfilled, stiffness-improved, high-viscosity

- A stiffness-improved (high-viscosity) grade for general injection molding.
- Features greater stiffness compared to general POM copolymer.
- Improved resistance to heat, high humidity, hot water

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Part Marking Code	> POM <		ISO 11469
Rheological properties			
Moulding shrinkage, parallel	2.0	%	ISO 294-4, 2577
Typical mechanical properties			
Tensile Modulus Yield stress, 50mm/min Yield strain, 50mm/min Nominal strain at break Flexural Modulus Flexural Strength Charpy notched impact strength, 23°C Charpy notched impact strength, -30°C	67 12 34 2600 90 8.3		ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 178 ISO 179/1eA ISO 179/1eA
Thermal properties	0.0	10/111	100 170/10/1
Melting temperature, 10°C/min Temp. of deflection under load, 1.8 MPa Coeff. of linear therm. expansion, parallel	170 100 120		ISO 11357-1/-3 ISO 75-1/-2 ISO 11359-1/-2
Electrical properties			
Volume resistivity Surface resistivity Electric strength	1E16	Ohm.m Ohm kV/mm	IEC 62631-3-1 IEC 62631-3-2 IEC 60243-1
Other properties			
Humidity absorption, 2mm Density	0.2 1410	% kg/m³	Sim. to ISO 62 ISO 1183
Injection			
Drying Temperature Drying Time, Dehumidified Dryer Processing Moisture Content Max. mould temperature Back pressure	80 - 90 3 - 4 0.1 60 - 80 2	h %	

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Revised: 2023-05-10 Source: Celanese Materials Database



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## Additional information

Injection molding mold temperature: 60°C ~ 80°C (140°F ~ 176°F)

barrel temperature: 170°C ~ 210°C (338°F ~ 410°F)

screw speed: 150mm/s ~ 200mm/s

back pressure: max. 20 bar

**Processing Texts** 

Pre-drying It is recommended to dry material at 80 °C ~ 90 °C (176 °F ~ 194 °F) for 3h ~ 4h if

necessary.

suggest max. moisture: 0.1%

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