

## KEPITAL® F20-03 LOF2

POM, unfilled, low emission, low-to-medium viscosity, improved heat stability A low-emission (low-to-medium viscosity) grade for general injection molding. Features improved heat stability.

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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 Poisson's ratio	2750 MPa 65 MPa 10 % 32 % 2550 MPa 87 MPa 6.5 kJ/m² 5.5 kJ/m²	ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 178 ISO 178 ISO 179/1eA
Thermal properties		
Melting temperature, 10°C/min Temp. of deflection under load, 1.8 MPa Coeff. of linear therm. expansion, parallel	165 °C 100 °C 120 E-6/K	ISO 11357-1/-3 ISO 75-1/-2 ISO 11359-1/-2
Electrical properties		
Volume resistivity Surface resistivity Electric strength	1E12 Ohm.m 1E16 Ohm 19 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 °C 3 - 4 h 0.1 % 60 - 80 °C 2 MPa	

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



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## Additional information

Injection molding mold temperature:  $60 \,^{\circ}\text{C} \sim 80 \,^{\circ}\text{C} \ (140 \,^{\circ}\text{F} \sim 176 \,^{\circ}\text{F})$ 

barrel temperature: 170°C ~ 190°C (338°F ~ 374°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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screw speed: 150mm/s ~ 200mm/s

back pressure: max. 20 bar

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