

KEPITAL® F20-33

POM, unfilled, medium viscosity, improved toughness A toughness-improved (medium viscosity) grade for general injection molding. Features: improved molding cycle, toughness and wear resistance

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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	2750		ISO 527-1/-2
Yield stress, 50mm/min	65 10	MPa	ISO 527-1/-2 ISO 527-1/-2
Yield strain, 50mm/min Nominal strain at break	33		ISO 527-1/-2 ISO 527-1/-2
Flexural Modulus		MPa	ISO 178
Flexural Strength		MPa	ISO 178
Charpy notched impact strength, 23°C		kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	5.5	kJ/m²	ISO 179/1eA
Thermal properties			
Melting temperature, 10°C/min	165	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	100		ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	120	E-6/K	ISO 11359-1/-2
Electrical properties			
Volume resistivity	1E12	Ohm.m	IEC 62631-3-1
Surface resistivity		Ohm	IEC 62631-3-2
Electric strength	19	kV/mm	IEC 60243-1
Other properties			
Humidity absorption, 2mm	0.2		Sim. to ISO 62
Density	1410	kg/m³	ISO 1183
Injection			
Drying Temperature	80 - 90	°C	
Drying Time, Dehumidified Dryer	3 - 4	h	
Processing Moisture Content	0.1		
Max. mould temperature	60 - 80		
Back pressure	2	MPa	

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Revised: 2023-06-27 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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barrel temperature: 170°C ~ 210°C (338°F ~ 410°F)

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

back pressure: max. 20 bar

Other Approvals

Other Approvals

OEM	Specification	Additional Information
GM	GMW22P-POM-C2	Fuel Compatible (replace d GMP.POM.005)

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