

KOCETAL[®] GF305

Polyacetal + Glass Fiber, Reinforced, Injection Molding, Medium Viscosity

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	–	1.56
Melt Flow Index	190 °C, 2.16 kg	ASTM D1238	g/10min	7.0
Shrinkage		ASTM D955	%	0.5–1.1
Water Absorption	23 °C, H ₂ O, 24 hr	ASTM D570	%	0.2
Mechanical				
Tensile Strength at Yield (3.2mm)	5 mm/min	ASTM D638	MPa	135
Nominal Strain at Break(3.2mm)	5 mm/min	ASTM D638	%	–
Flexural Strength (3.2mm)	10 mm/min	ASTM D790	MPa	215
Flexural Modulus (3.2mm)	10 mm/min	ASTM D790	MPa	8,200
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 °C		J/m	73
	–30 °C		J/m	–
Rockwell Hardness	M scale	ASTM D785	–	90
Thermal				
Melting Point	20 °C/min	ASTM D1525	°C	167
Heat Deflection Temperature	1.8 MPa	ASTM D648	°C	–
Coefficient of linear expansion		ASTM D696	× 10 ^{–5} cm/cm · °C	2.5
Flammability (0.8mm)		UL94	Class	HB
Electrical				
Dielectric Strength		IEC 60243	kV/mm	–
Volume Resistivity		IEC 60093	Ω · cm	–
Surface Resistivity		IEC 60093	Ω /sq	–

※ 1Mpa = 10.197162 Kgf/cm², 1J/m = 0.10197 Kgf · cm/cm, (Test specimen Thickness)



Processing Guide (Injection Molding)

Drying Temperature(℃)	80 ~ 90	(Dehumidifying Dryer)			
Drying Time(hr)	3 ~ 5				
Processing Moisture Contents(%)	≤ 0.1				
Cylinder Temperature(℃)	Nozzle	Front	Middle	Rear	
	190 ~ 210	190 ~ 210	180 ~ 200	170 ~ 190	
Mold Temperature(℃)	70 ~ 120				

