

KOCETAL[®] K300LO

Polyacetal, Low Emission, Injection Molding, Medium Viscosity

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Specific Gravity		ASTM D792	-	1.41
Melt Flow Index	190 °C, 2.16 kg	ASTM D1238	g/10min	9.0
Shrinkage		ASTM D955	%	1.8-2.2
Water Absorption	23 °C, H ₂ O, 24 hr	ASTM D570	%	0.22
Mechanical				
Tensile Strength at Yield (3.2mm)	50 mm/min	ASTM D638	MPa	63
Nominal Strain at Break(3.2mm)	50 mm/min	ASTM D638	%	40
Flexural Strength (3.2mm)	2 mm/min	ASTM D790	MPa	93
Flexural Modulus (3.2mm)	2 mm/min	ASTM D790	MPa	2,500
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 °C		J/m	65
	-30 °C		J/m	-
Rockwell Hardness	M scale	ASTM D785	-	80
Thermal				
Melting Point	20 °C/min	ASTM D3418	°C	167
Heat Deflection Temperature	1.8 MPa	ASTM D648	°C	-
Coefficient of linear expansion		ASTM D696	× 10 ⁻⁵ cm/cm·°C	13
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			
Drying Time(hr)	3 ~ 5			
Processing Moisture Contents(%)	≤ 0.1			
Cylinder Temperature(℃)	Nozzle	Front	Middle	Rear
	170 ~ 190	175 ~ 190	175 ~ 190	165 ~ 175
Mold Temperature(℃)	60 ~ 80			

