

# KOCETAL<sup>®</sup> K700LO

Polyacetal, Low emission of formaldehyde, Injection Molding, Low-Viscosity

Properties	Measurement condition	Test Method	Unit	Typical value
<b>Physical</b>				
Density		ISO 1183	g/cm <sup>3</sup>	1.41
Melt Flow Index	190 °C, 2.16 kg	ISO 1133	g/10min	27.0
Melt Volume Rate	190 °C, 2.16 kg	ISO 1133	cm <sup>3</sup> /10min	23.0
Shrinkage		ISO 294-4	%	1.8-2.2
Water Absorption	23 °C, 50% RH	ISO 62	%	0.22
<b>Mechanical</b>				
Tensile Strength at Yield (4.0mm)	50 mm/min	ISO 527	MPa	65
Elongation at Break (4.0mm)	50 mm/min	ISO 527	%	25
Strain at Yield, (4.0mm)	50 mm/min	ISO 527	%	9
Flexural Strength (4.0mm)	2 mm/min	ISO 178	MPa	88
Flexural Modulus (4.0mm)	2 mm/min	ISO 178	MPa	2,700
Charpy Impact Strength, (4.0mm)		ISO 179/1eA		
(Notched)	23 °C		kJ/m <sup>2</sup>	5.5
	-30 °C		kJ/m <sup>2</sup>	-
Rockwell Hardness	M scale	ISO 2039-2	-	80
<b>Thermal</b>				
Melting Point	20 °C/min	ISO 11357-1	°C	167
Heat Deflection Temperature	1.8 MPa	ISO 75	°C	95
Coefficient of linear expansion		ISO 11359	× E <sup>-6</sup> /K	-
Flammability (0.8mm)		UL94	Class	HB
<b>Electrical</b>				
Dielectric Strength		IEC 60243	kV/mm	-
Volume Resistivity		IEC 60093	Ω·cm	-
Surface Resistivity		IEC 60093	Ω	-
※ ( Test specimen Thickness )				



## Processing Guide (Injection Molding)

Drying Temperature(°C)	80 ~ 90	(Dehumidifying Dryer)		
Drying Time(hr)	3 ~ 5			
Limitation of Processing Temperature(°C)	200			
Processing Moisture Contents(%)	≤ 0.1			
Cylinder Temperature(°C)	Nozzle	Front	Middle	Rear
	180 ~ 200	180 ~ 200	170 ~ 190	160 ~ 180
Mold Temperature(°C)	60 ~ 80			

