

KOCETAL® LW3011

Polyacetal, Tribological grade, Injection Molding, Medium Viscosity

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Specific Gravity		ASTM D792	-	1.39
Melt Flow Index	190 °C, 2.16 kg	ASTM D1238	g/10min	11.0
Shrinkage		ASTM D955	%	1.8-2.2
Water Absorption	23 °C, H ₂ O, 24 hr	ASTM D570	%	-
Mechanical				
Tensile Strength at Yield (3.2mm)	50 mm/min	ASTM D638	MPa	53
Nominal Strain at Break(3.2mm)	50 mm/min	ASTM D638	%	50
Flexural Strength (3.2mm)	2 mm/min	ASTM D790	MPa	81
Flexural Modulus (3.2mm)	2 mm/min	ASTM D790	MPa	2,300
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 °C		J/m	70
	-30 °C		J/m	-
Rockwell Hardness	M scale	ASTM D785	-	
Thermal				
Melting Point	20 °C/min	ASTM D3418	°C	167
Heat Deflection Temperature	1.8 MPa	ASTM D648	°C	97
Coefficient of linear expansion		ASTM D696	× 10 ⁻⁵ cm/cm·°C	14
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 Kg/cm², 1J/m = 0.10197 Kg·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	
	180 ~ 200	180 ~ 200	170 ~ 190	160 ~ 180	
Mold Temperature(℃)	60 ~ 80				

