

KOCETAL[®] UR306

Polyacetal, Impact Modified, Injection Molding, Medium Viscosity

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Specific Gravity		ASTM D792	–	1.30
Melt Flow Index	190 °C, 2.16 kg	ASTM D1238	g/10min	7.0
Shrinkage		ASTM D955	%	1.3–1.9
Water Absorption	23 °C, H ₂ O, 24 hr	ASTM D570	%	0.25
Mechanical				
Tensile Strength at Yield (3.2mm)	20 mm/min	ASTM D638	MPa	35
Nominal Strain at Break(3.2mm)	20 mm/min	ASTM D638	%	>50
Flexural Strength (3.2mm)	10 mm/min	ASTM D790	MPa	50
Flexural Modulus (3.2mm)	10 mm/min	ASTM D790	MPa	1,500
Izod Impact Strength (6.4mm) (Notched)	23 °C	ASTM D256	J/m	210
	–30 °C		J/m	–
Rockwell Hardness	M scale	ASTM D785	–	50
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	$\times 10^{-5} \text{cm/cm} \cdot ^\circ\text{C}$	–
Flammability (0.8mm)		UL94	Class	HB
Electrical				
Dielectric Strength		IEC 60243	kV/mm	–
Volume Resistivity		IEC 60093	$\Omega \cdot \text{cm}$	–
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
	190 ~ 200	190 ~ 200	190 ~ 200	160 ~ 180
Mold Temperature(℃)	60 ~ 80			

