KOLON PLASTICS

KOCETAL® UR302L0

Polyacetal, Impact Modified, Low Emission, Injection Molding, Medium Viscosity

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Specific Gravity		ASTM D792	-	1.37
Melt Flow Index	190 ℃, 2.16 kg	ASTM D1238	g/10min	8.5
Shrinkage		ASTM D955	%	1.5-2.1
Water Absorption	23 ℃, H_2O, 24 hr	ASTM D570	%	0.24
Mechanical				
Tensile Strength at Yield (3.2mm	50 mm/min	ASTM D638	MPa	49
Nominal Strain at Break(3.2mm)	50 mm/min	ASTM D638	%	>50
Flexural Strength (3.2mm)	2 mm/min	ASTM D790	MPa	80
Flexural Modulus (3.2mm)	2 mm/min	ASTM D790	MPa	2,000
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 ℃		J/m	114
	-30 ℃		J/m	84
Rockwell Hardness	M scale	ASTM D785	-	70
Thermal				
Melting Point	20 ℃/min	ASTM D1525	℃	167
Heat Deflection Temperature	1.8 MPa	ASTM D648	℃	90
Coefficient of linear expansion		ASTM D696	× 10^{-5}cm/cm · ℃	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 Kgf/cm^2, 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	
	170 ~ 190	175 ~ 190	175 ~ 190	165 ~ 175	
Mold Temperature(℃)	60 ~ 80				