

KOPEL[®] KP3855FBBL

Injection Molding, TPC-ET

Application

Automotive parts, appliance, etc.

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Specific Gravity		ISO 1183	-	1.18
Melt Flow Index	240 °C, 2.16kg	ISO 1133	g/10min	14
Shrinkage		ISO 294-4	%	1.4~1.8
Water Absorption	23°C, H ₂ O, 24hr	ISO 62	%	0.4
Mechanical				
Tensile Strength at Break (2.0mm)	50 mm/min	ISO 527	MPa	25
Elongation at Break (2.0mm)	50 mm/min	ISO 527	%	350 ↑
Flexural Modulus (4.0mm)	10 mm/min	ISO 178	MPa	285
Izod Impact strength (4.0mm)		ISO 180		
(Notched)	23 °C		kJ/m ²	N.B
	-40 °C		kJ/m ²	N.B
Charpy Impact Strength (4.0mm)		ISO 179/1eA		
(Notched)	23 °C		kJ/m ²	P.B
	-40 °C		kJ/m ²	P.B
Shore Hardness (Max)		ISO 868	Shore D	55
Thermal				
Melting Point	20 °C/min	ISO 11357-1	°C	223
Vicat softening temperature	10N, 50°C/h	ISO 306	°C	162
Flammability (0.8mm)		UL94	Class	HB

※ (Test specimen Thickness)



Processing Guide (Injection Molding)

Drying Temperature(°C)	80 ~ 110	(Dehumidifying Dryer)			
Drying Time(hr)	3~6				
Processing Moisture Contents(%)	≤ 0.08				
Cylinder Temperature(°C)	Nozzle	Front	Middle	Rear	
	220~240	220 ~ 240	210 ~ 230	190 ~ 210	
Mold Temperature(°C)	20~40				

