

KOPEL[®] KP3855FB

Injection Molding, PEL, General Purpose, High flow

Application

Automotive(Air Bag Cover)

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	–	1.18
Melt Flow Index	240 ℃, 2.16kg	ASTM D1238	g/10min	15
Shrinkage		ASTM D955	%	1.2~1.6
Water Absorption	23℃, H ₂ O, 24hr	ASTM D570	%	0.5
Mechanical				
Tensile Strength at Break (3.2mm)	200 mm/min	ASTM D638	MPa	30
Elongation at Break (3.2mm)	200 mm/min	ASTM D638	%	450
Flexural Strength (3.2mm)	200 mm/min	ASTM D790	MPa	–
Flexural Modulus (3.2mm)	200 mm/min	ASTM D790	MPa	–
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 ℃		J/m	NB
	–30 ℃		J/m	NB
Shore hardness	D scale	ASTM D2240	–	55
Thermal				
Melting Point	20 ℃/min	ASTM D1525	℃	223
Vicat softening temperature	10N	ASTM D1525	℃	165
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/cm², 1J/m = 0.10197 Kgf · cm/cm, (Test specimen Thickness)



Processing Guide (Injection Molding)

Drying Temperature(℃)	100~110	(Dehumidifying Dryer)			
Drying Time(hr)	3~8				
Processing Moisture Contents(%)	≤ 0.1				
Cylinder Temperature(℃)	Nozzle	Front	Middle	Rear	
	220~240	220~240	210~230	190~210	
Mold Temperature(℃)	20~40				

