

KOPEL[®] KP3346

Injection Molding, PEL, General Purpose, Low Modulus

Application

Living(Elastic fabric, Low noise gear)

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	-	1.15
Melt Flow Index	230 ℃, 2.16kg	ASTM D1238	g/10min	41.7
Shrinkage		ASTM D955	%	1.11~1.14
Water Absorption	23℃, H ₂ O, 24hr	ASTM D570	%	0.6
Mechanical				
Tensile Strength at Break (3.2mm)	200 mm/min	ASTM D638	MPa	23
Elongation at Break (3.2mm)	200 mm/min	ASTM D638	%	910
Flexural Strength (3.2mm)	200 mm/min	ASTM D790	MPa	6
Flexural Modulus (3.2mm)	200 mm/min	ASTM D790	MPa	83
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 ℃		J/m	NB
	-30 ℃		J/m	NB
Shore hardness	D scale	ASTM D2240	-	45
Thermal				
Melting Point	20 ℃/min	ASTM D3418	℃	184
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 Kg/cm², 1J/m = 0.10197 Kg·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	
	210~220	210~220	200~220	180~190	
Mold Temperature(℃)	20~40				

