

KOPEL[®] KP3328

Injection Molding/Extrusion, PEL, General Purpose, Low Modulus

Application

Living(Artificial Leather)

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	-	1.08
Melt Flow Index	230 ℃, 2.16kg	ASTM D1238	g/10min	18.7
Shrinkage		ASTM D955	%	0.88~0.92
Water Absorption	23℃, H ₂ O, 24hr	ASTM D570	%	0.7
Mechanical				
Tensile Strength at Break (3.2mm)	200 mm/min	ASTM D638	MPa	16
Elongation at Break (3.2mm)	200 mm/min	ASTM D638	%	1,100
Flexural Strength (3.2mm)	200 mm/min	ASTM D790	MPa	4
Flexural Modulus (3.2mm)	200 mm/min	ASTM D790	MPa	48
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 ℃		J/m	NB
	-30 ℃		J/m	NB
Shore hardness	D scale	ASTM D2240	-	28
Thermal				
Melting Point	20 ℃/min	ASTM D3418	℃	180
Vicat softening temperature	10N	ASTM D1525	℃	83
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(℃)	90~110 (Dehumidifying Dryer)			
Drying Time(hr)	4~8			
Processing Moisture Contents(%)	≤ 0.1			
Cylinder Temperature(℃)	Nozzle	Front	Middle	Rear
	185~200	180~200	170~190	160~170
Mold Temperature(℃)	20~40			

