

KOCETAL® TC704

Acetal (POM) Copolymer

Kolon Plastics, Inc.

Message:

Kocetal TC704 is Mineral reinforced grade for good dimensional stability.

General Information			
Filler / Reinforcement	Mineral		
Features	Good Dimensional Stability		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.56	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.6	%	ASTM D955
Water Absorption (Equilibrium, 23°C, 60%RH)	0.20	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	84		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 23°C)	60.0	MPa	ASTM D638
Tensile Elongation (Yield, 23°C)	7.5	%	ASTM D638
Flexural Modulus (23°C)	5300	MPa	ASTM D790
Flexural Strength (23°C)	105	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	33	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	163	°C	
1.8 MPa, Unannealed	145	°C	
Melting Temperature	166	°C	
CLTE - Flow	6.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	ASTM D257
Volume Resistivity	1.0E+14	ohms · cm	ASTM D257
Dielectric Strength	19	kV/mm	ASTM D149
Dielectric Constant	3.70		ASTM D150
Dissipation Factor (1 MHz)	6.0E-3		ASTM D150
Flammability	Nominal Value	Unit	Test Method

Flame Rating	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	> 3.0	hr
Suggested Max Regrind	30	%
Rear Temperature	170 to 190	°C
Middle Temperature	190 to 210	°C
Front Temperature	200 to 220	°C
Nozzle Temperature	200 to 220	°C
Processing (Melt) Temp	165 to 220	°C
Mold Temperature	70.0 to 120	°C
Injection Pressure	98.1	MPa
Holding Pressure	98.1	MPa
Back Pressure	1.96 to 4.90	MPa

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