

# KOCETAL® TF304

Acetal (POM) Copolymer

Kolon Plastics, Inc.

## Message:

Kocetal TF304 is PTFE alloyed grade for low friction, wear and noise.

General Information			
Filler / Reinforcement	PTFE Fiber		
Features	Good Wear Resistance		
	Low Friction		
	Noise Damping		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.51	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	6.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.8	%	ASTM D955
Water Absorption (Equilibrium, 23°C, 60%RH)	0.20	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	70		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 23°C)	45.0	MPa	ASTM D638
Tensile Elongation (Yield, 23°C)	30	%	ASTM D638
Flexural Modulus (23°C)	2100	MPa	ASTM D790
Flexural Strength (23°C)	67.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	35	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	156	°C	
1.8 MPa, Unannealed	106	°C	
Melting Temperature	166	°C	
CLTE - Flow	1.3E-4	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	68.6 to 118	MPa	
Holding Pressure	98.1	MPa	
Back Pressure	1.96 to 4.90	MPa	

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#### Recommended distributors for this material

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