

KOCETAL® K100

Acetal (POM) Copolymer
Kolon Plastics, Inc.

Message:
Kocetal K100 is a high viscosity grade and suitable for extrusion and injection moldings.

General Information			
UL YellowCard	E190675-238632		
Features	High Viscosity		
Uses	Piping		
	Rods		
	Sheet		
	Thick-walled Parts		
	Tubing		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	2.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow	2.2	%	ASTM D955
Water Absorption (Equilibrium, 23°C, 60%RH)	0.22	%	ASTM D570

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	78		ASTM D785

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 23°C)	57.0	MPa	ASTM D638
Tensile Elongation (Yield, 23°C)	80	%	ASTM D638
Flexural Modulus (23°C)	2200	MPa	ASTM D790
Flexural Strength (23°C)	80.0	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	87	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	158	°C	
1.8 MPa, Unannealed	110	°C	
Vicat Softening Temperature	162	°C	ASTM D1525

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	160 to 180	°C	
Middle Temperature	180 to 190	°C	
Front Temperature	190 to 200	°C	
Nozzle Temperature	190 to 200	°C	
Processing (Melt) Temp	< 230	°C	
Mold Temperature	60.0 to 80.0	°C	
Injection Pressure	49.0 to 78.5	MPa	
Holding Pressure	29.4 to 49.0	MPa	
Back Pressure	0.981 to 2.94	MPa	

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