

KOCETAL® EL304

Acetal (POM) Copolymer
Kolon Plastics, Inc.

Message:
Kocetal EL304 is impact strength modified grade suitable for fasteners and switches.

General Information			
Additive	Impact Modifier		
Features	Good Flexibility		
	Impact Modified		
Uses	Fasteners		
	Switches		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	9.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.7	%	ASTM D955
Water Absorption (Equilibrium, 23°C, 60%RH)	0.25	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	76		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 23°C)	43.0	MPa	ASTM D638
Tensile Elongation (Yield, 23°C)	85	%	ASTM D638
Flexural Modulus (23°C)	1700	MPa	ASTM D790
Flexural Strength (23°C)	60.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	144	°C	
1.8 MPa, Unannealed	82.0	°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	160 to 180	°C	
Middle Temperature	180 to 200	°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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