

POM | KEPITAL F15-33 | 改善韧性

- 普通注塑成型的韧性改良 (中高粘度) 牌号
- 改良了成型周期的特性

基本信息	测试标准	单位	数值
聚合物	ISO 1043	-	POM

物理性能	测试标准	单位	数值
密度	ISO 1183 (GB/T 1033)	g/cm ³	1.41
熔体质量流动速率	ISO 1133 (GB/T 3682)	g/10min	6
吸水率(23 °C / 50 % RH)	ISO 62	%	0.2

热性能	测试标准	单位	数值
1.8 MPa 负荷变形温度	ISO 75 (GB/T 1634)	°C	96
燃烧性	UL94	-	HB
熔融温度	ISO 11357 (GB/T 19466)	°C	165
线膨胀系数	ISO 11359	X 10 ⁻⁵ / °C	12

机械性能	测试标准	单位	数值
拉伸模量	ISO 527 (GB/T 1040)	MPa	2,600
屈服应力	ISO 527 (GB/T 1040)	MPa	65
屈服拉伸应变	ISO 527 (GB/T 1040)	%	10
断裂标称应变	ISO 527 (GB/T 1040)	%	35
弯曲强度	ISO 178 (GB/T 9341)	MPa	84
弯曲模量	ISO 178 (GB/T 9341)	MPa	2,450
简支梁缺口冲击强度 (23°C)	ISO 179/1eA (GB/T 1043/1eA)	kJ/m ²	7.0
简支梁缺口冲击强度 (-30°C)	ISO 179/1eA (GB/T 1043/1eA)	kJ/m ²	6.0

电性能	测试标准	单位	数值
表面电阻率	IEC 60093	Ω	1x10 ¹⁶
体积电阻率	IEC 60093	Ω · cm	1x10 ¹⁴
介电强度	IEC 60243-1	kV/mm	19

其他	测试标准	单位	数值
收缩率(流动方向, Φ = 100 mm, t = 3 mm)	KEP 方法	%	2.0

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注塑条件



预干燥(建议最大吸水率为 : 0.1 %)

推荐干燥条件 80 °C ~ 100 °C (176 °F ~ 212 °F) 3h ~ 4 h

温度

模具温度: 60°C ~ 80 °C(140 °F ~ 176 °F)

料筒温度: 180 °C ~ 210 °C(356 °F ~ 410 °F)

模具	Bn (喷嘴)	B3 (计量)	B2 (压缩)	B1 (喂料)	料斗
60 ~ 80 °C	180 ~ 210 °C	190 ~ 200 °C	180 ~ 190 °C	170 C ~ 180 °C	60 ~ 80 °C
140 ~ 176 °F	356 ~ 410 °F	374 ~ 392 °F	356 ~ 374 °F	338 ~ 356 °F	140 ~ 176 °F

塑化

螺杆转速: 150 mm/s ~ 200 mm/s

背压: 最大 20 bar

联系方式

188 6269 1890

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