

POM | KEPITAL F15-33 | 标准牌号

- 普通注塑成型的中高粘度牌号
- 改良了韧性和成型周期的特性

物理性能	测试标准	单位	数值
密度	ISO 1183	g/cm ³	1.41
熔融指数	ISO 1133	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
热变形温度(1.8 MPa)	ISO 75	°C	96
燃烧性	UL 94	-	HB
熔点(10 °C/min)	ISO 11357	°C	165
线膨胀系数	ISO 11359	X 10 ⁻⁵ /°C	12

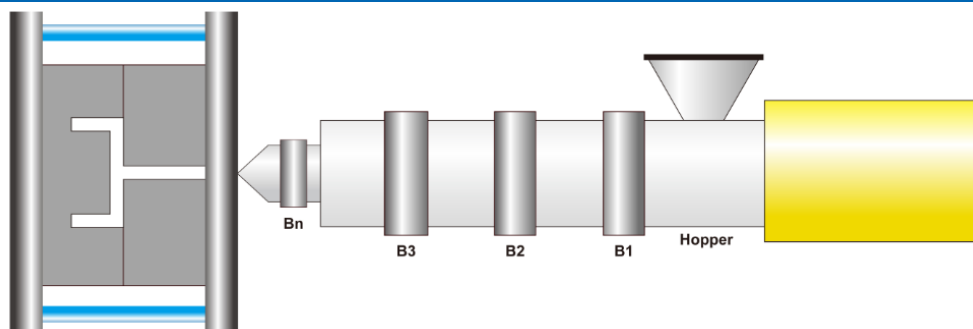
机械性能	测试标准	单位	数值
拉伸模量	ISO 527	MPa	2,400
拉伸强度	ISO 527	MPa	65
屈服伸长率	ISO 527	%	10
断裂伸长率	ISO 527	%	35
弯曲强度	ISO 178	MPa	84
弯曲模量	ISO 178	MPa	2,450
简支梁缺口冲击强度	ISO 179	kJ/m ²	7.0

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, 3 h ~ 4 h

温度

模具温度: 60 °C ~ 80 °C

料筒温度: 180 °C ~ 210 °C

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 ~ 180 °C	60 ~ 80 °C

塑化

螺杆转速: 150 mm/s ~ 200 mm/s

背压: 最大 20 bar

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