

## POM | KEPITAL F20-02 | 标准牌号

- 普通注塑成型的中粘度牌号
- 注塑成型应用的普通牌号

物理性能	测试标准	单位	数值
密度	ISO 1183	g/cm <sup>3</sup>	1.41
熔融指数	ISO 1133	g/10min	9
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	100
燃烧性	UL94	-	HB
熔点(10 °C/min)	ISO 11357	°C	165
线膨胀系数	ISO 11359	X 10 <sup>-5</sup> / °C	12

机械性能	测试标准	单位	数值
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	87
弯曲模量	ISO 178	MPa	2,550
简支梁缺口冲击强度	ISO 179	kJ/m <sup>2</sup>	6.5

电性能	测试标准	单位	数值
表面电阻率	IEC 60093	Ω	1x10 <sup>16</sup>
体积电阻率	IEC 60093	Ω · cm	1x10 <sup>14</sup>
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 3h ~ 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 C ~ 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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