

POM | KEPITAL TE-24(FU2020) | 耐冲击牌号

- 普通注塑成型的韧性改良中高粘度牌号
- 应用于耐冲击性、韧性需求的部件

物理性能	测试标准	单位	数值
密度	ISO 1183	g/cm ³	1.35
熔融指数	ISO 1133	g/10min	6
吸水率(23 °C / 50 % RH)	ISO 62	%	0.24

热性能	测试标准	单位	数值
热变形温度(1.8 MPa)	ISO 75	°C	66
燃烧性	UL94	-	HB
熔点(10 °C/min)	ISO 11357	°C	165
线膨胀系数	ISO 11359	X 10 ⁻⁵ /°C	13

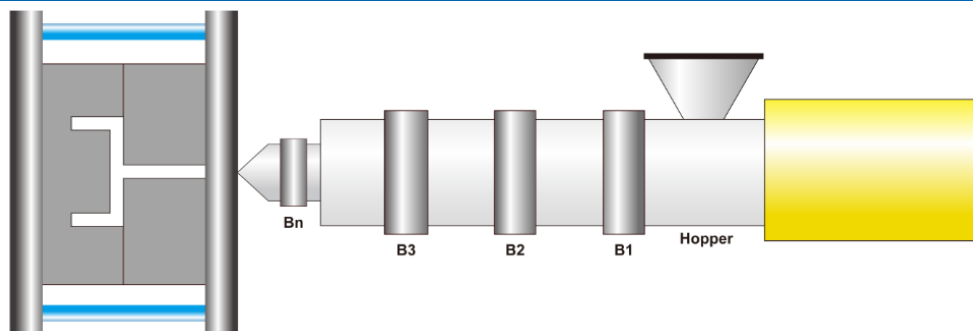
机械性能	测试标准	单位	数值
拉伸强度	ISO 527	MPa	41
屈服伸长率	ISO 527	%	13
断裂伸长率	ISO 527	%	>60
弯曲强度	ISO 178	MPa	53
弯曲模量	ISO 178	MPa	1,450
简支梁缺口冲击强度	ISO 179	kJ/m ²	18.0

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	21

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	%	1.7

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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: 40°C ~ 60 °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
40°C ~ 60 °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

联系方式

总部

Mapo-daero 119 (Gongdeok-dong) Hyeoseong Bldg.
4thfloor, Mapo-gu, Seoul, Korea
Tel 82-2-707-6840 ~ 8, Telefax 82-2-714-9235

KEP Europe GmbH

Rheingastrasse 190-196 D-65203 Wiesbaden
Germany
Tel +49 (0)611 962-7381, Telefax +49 (0)611 962-9132

KEP 美国

106 North Denton Tap Road Suite 210-202 Coppell,
TX 75019, USA
Tel +1 888 KEPITAL, Telefax +1 888 537-3291

KEP 中国

上海市长宁区遵义路 100 号虹桥 南丰城 A1905
Tel +86 21 6237-1972, Telefax +86 21 6237-1803

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