

# KEPITAL® F25-03HT LOF

POM, low emission, a friction & wear-resistance (medium-viscosity) grade for general injection molding

- Kepital® F25-03HT LOF is a friction & wear-resistance (medium-viscosity) grade for general injection molding.
- Suitable for applications requiring reduced impact noise and good friction and wear resistance.
- A low-emission grade featured improved heat stability.

## Product information

Part Marking Code	> POM <	ISO 11469
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## Rheological properties

Moulding shrinkage range, parallel	2.0 %	ISO 294-4, 2577
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## Typical mechanical properties

Tensile Modulus	2700 MPa	ISO 527-1/-2
Yield stress, 50mm/min	64 MPa	ISO 527-1/-2
Yield strain, 50mm/min	9 %	ISO 527-1/-2
Nominal strain at break	30 %	ISO 527-1/-2
Flexural Modulus	2600 MPa	ISO 178
Flexural Strength	90 MPa	ISO 178
Charpy notched impact strength, 23°C	6 kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	5 kJ/m <sup>2</sup>	ISO 179/1eA

## Thermal properties

Melting temperature, 10°C/min	170 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	100 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	120 E-6/K	ISO 11359-1/-2

## Flammability

Burning Behav. at thickness h	HB class	UL 94
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## Electrical properties

Volume resistivity	1E12 Ohm.m	IEC 62631-3-1
Surface resistivity	1E16 Ohm	IEC 62631-3-2
Electric strength	19 kV/mm	IEC 60243-1

## Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Density	1410 kg/m <sup>3</sup>	ISO 1183

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## Injection

Drying Temperature	80 - 90 °C
Drying Time, Dehumidified Dryer	3 - 4 h
Processing Moisture Content	0.1 %
Max. mould temperature	60 - 80 °C
Back pressure	2 MPa

## Additional information

Injection molding	mold temperature: 60°C ~ 80°C (140°F ~ 176°F) barrel temperature: 170°C ~ 190°C (338°F ~ 374°F) screw speed: 150mm/s ~ 200mm/s back pressure: max. 20 bar
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## Processing Texts

Pre-drying	It is recommended to dry material at 80°C ~ 90°C (176°F ~ 194°F) for 3h ~ 4h if necessary. suggest max. moisture: 0.1%
Injection molding	mold temperature: 60°C ~ 80°C (140°F ~ 176°F) barrel temperature: 170°C ~ 190°C (338°F ~ 374°F) screw speed: 150mm/s ~ 200mm/s back pressure: max. 20 bar

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