

# KEPITAL® F25-03HT

A friction & wear-resistance (medium-viscosity) grade for general injection molding  
Kepital® F25-03HT 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.

## Rheological properties

Moulding shrinkage range, parallel	2.0 %	ISO 294-4, 2577
------------------------------------	-------	-----------------

## 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
Poisson's ratio	0.405	

## 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

## Flammability

Burning Behav. at thickness h	HB class	UL 94
-------------------------------	----------	-------

## Electrical properties

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

## 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

# KEPITAL® F25-03HT

## Additional information

Injection molding

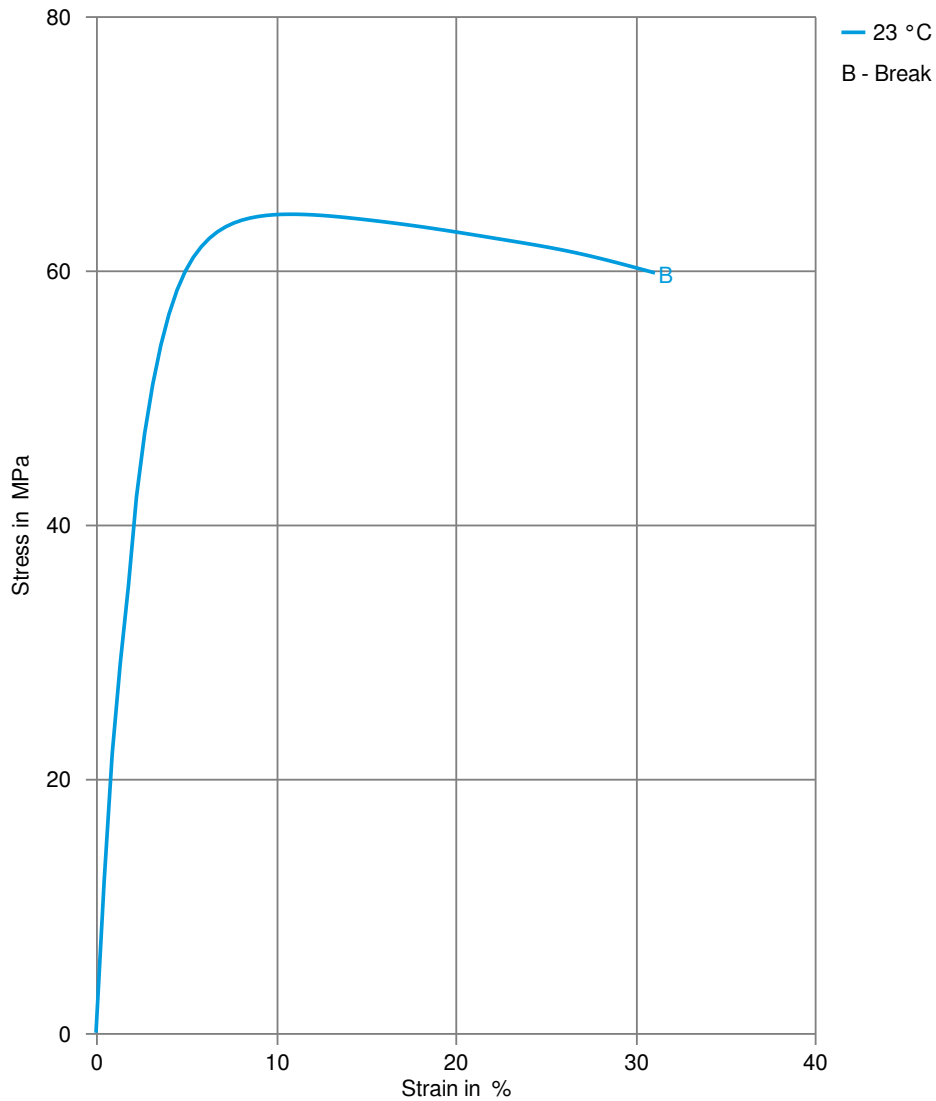
mold temperature: 60°C ~ 80°C (140°F ~ 176°F)

barrel temperature: 170°C ~ 190°C (338°F ~ 374°F)

screw speed: 150mm/s ~ 200mm/s

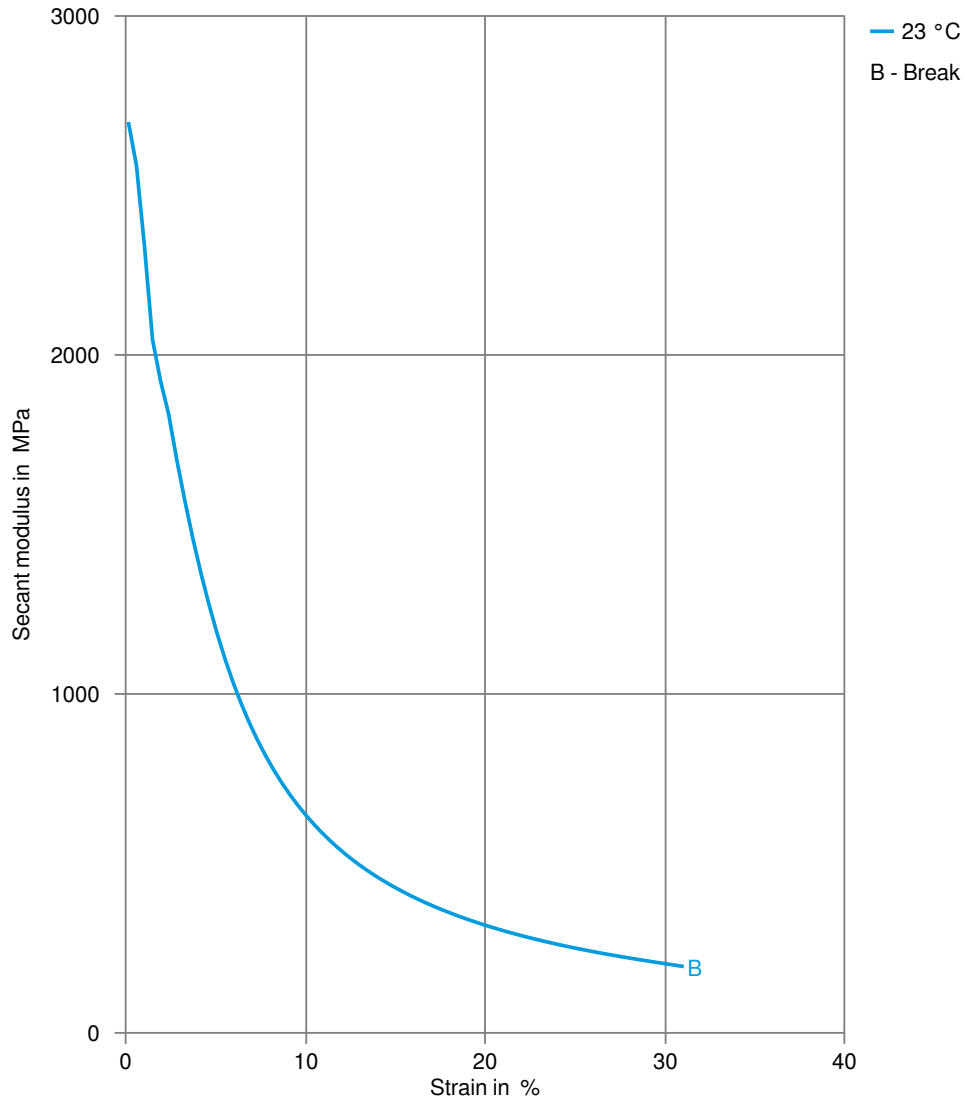
back pressure: max. 20 bar

## Stress-strain



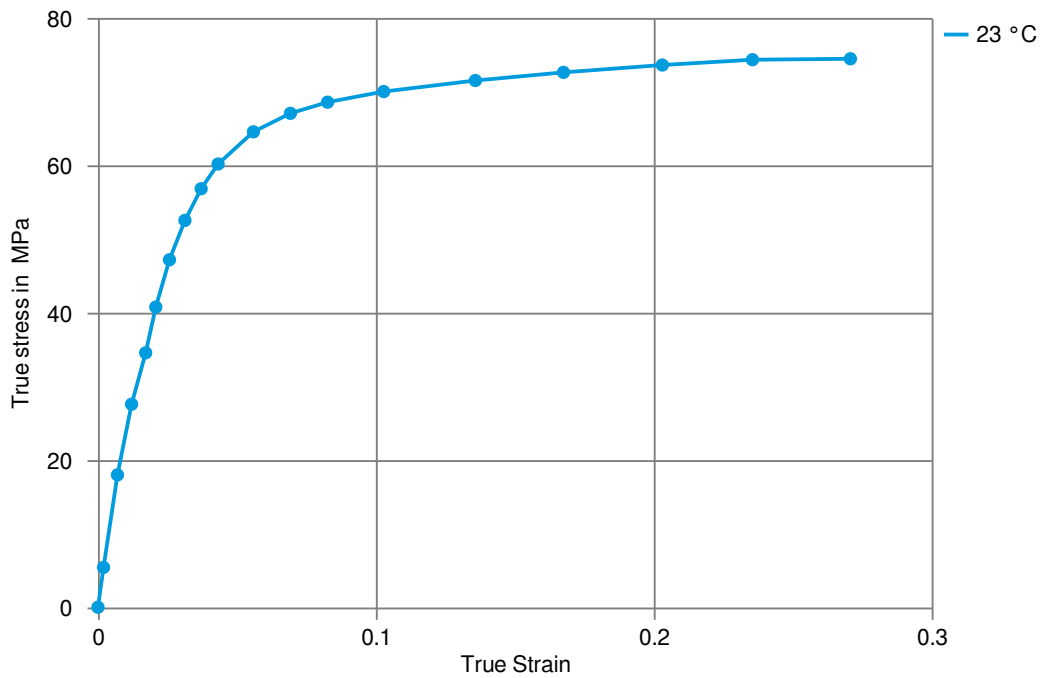
# KEPITAL® F25-03HT

## Secant modulus-strain



# KEPITAL® F25-03HT

## True stress-strain



# KEPITAL® F25-03HT

## 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

---