

# KOCETAL® K300

Polyacetal, General Purpose, Injection Molding, Medium-Viscosity

Properties	Measurement condition	Test Method	Unit	Typical value
<b>Physical</b>				
Density		ISO 1183	g/cm <sup>3</sup>	1.41
Melt flow rate	190 °C, 2.16 kg	ISO 1133	g/10min	9.5
Melt volume rate	190 °C, 2.16 kg	ISO 1133	cm <sup>3</sup> /10min	8.5
Molding shrinkage	Parallel	ISO 294-4	%	1.8 ~ 2.0
	Normal			1.8 ~ 2.0
Water absorption	23 °C, 50% RH	ISO 62	%	0.22
<b>Mechanical</b>				
Tensile strength at yield	50 mm/min	ISO 527	MPa	64
Tensile strain at yield	50 mm/min	ISO 527	%	11
Nominal strain at break	50 mm/min	ISO 527	%	30
Flexural strength	2 mm/min	ISO 178	MPa	85
Flexural modulus	2 mm/min	ISO 178	MPa	2,500
Charpy impact strength (Notched)	23°C	ISO 179/1eA	kJ/m <sup>2</sup>	7.0
	-30°C			5.5
Rockwell hardness	M scale	ISO 2039-2	-	80
<b>Thermal</b>				
Melting temperature	20 °C/min	ISO 11357-1	°C	167
Heat deflection temperature	1.8 MPa	ISO 75	°C	95
Coeff. of linear thermal expansion		ISO 11359	× 10 <sup>-5</sup> /°C	
Flammability		UL 94	Class	HB
<b>Electrical</b>				
Dielectric strength		IEC 60243	kV/mm	
Volume resistivity		IEC 60093	Ω·cm	
Surface resistivity		IEC 60093	Ω	

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## Processing Guide (Injection Molding)

Drying Temperature(℃)	80 ~ 90	(Dehumidifying Dryer)		
Drying Time(hr)	3 ~ 5			
Processing Moisture Contents(%)	≤ 0.1			
Cylinder Temperature(℃)	<b>Nozzle</b> 180 ~ 200	<b>Front</b> 180 ~ 200	<b>Middle</b> 170 ~ 190	<b>Rear</b> 160 ~ 180
Mold Temperature(℃)	60 ~ 100			

## Contact Us

[www.kolonenp.com](http://www.kolonenp.com)

### Domestic Sales

TEL : +82-2-3677-3621 / FAX : +82-2-3677-3556

### Domestic Sales(Yeongnam)

TEL : +82-53-253-3792 / FAX : +82-53-253-3793

### Global Sales

TEL : +82-2-3677-3623 / FAX : 02-3677-3558

### R&D Division

TEL : +82-54-421-1490 / FAX : +82-54-421-1449

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