

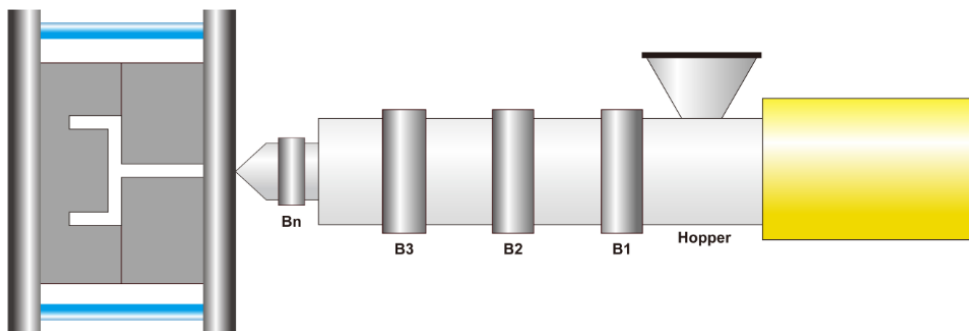
POM | KEPITAL® H100 | Standard Grade

- A POM homo-polymer
- A high-viscosity grade for general injection molding
- Features high stiffness and superior toughness
- Suitable for injection molding of thick-walled, void free, and sink mark-reduced parts

General information	Test Standard	Unit	Value
Polymer abbreviation	ISO 1043	-	POM
Physical properties	Test Standard	Unit	Value
Density	ISO 1183	g/cm ³	1.42
Melt flow rate	ISO 1133	g/10 min	2.5
Water absorption(23 °C / 50 % RH)	ISO 62	%	0.2
Thermal properties	Test Standard	Unit	Value
Heat deflection temperature(1.8 MPa)	ISO 75	°C	95
Flammability	UL 94	-	HB
Melting point(10 °C/min)	ISO 11357	°C	175
Coefficient of linear thermal expansion	ISO 11359	X 10 ⁻⁵ /°C	
Mechanical properties	Test Standard	Unit	Value
Tensile strength	ISO 527	MPa	70
Tensile strain at yield	ISO 527	%	21
Nominal strain at break	ISO 527	%	45
Tensile modulus	ISO 527	MPa	3,100
Flexural strength	ISO 178	MPa	92
Flexural modulus	ISO 178	MPa	2,750
Charpy impact strength(notched, @ 23°C)	ISO 179/1eA	kJ/m ²	11.0
Charpy impact strength(notched, @ -30°C)	ISO 179/1eA	kJ/m ²	8.0
Electrical properties	Test Standard	Unit	Value
Surface resistivity	IEC 60093	Ω	
Volume resistivity	IEC 60093	Ω · cm	
Dielectric strength	IEC 60243-1	kV/mm	
Others	Test Standard	Unit	Value
Mold shrinkage(parallel)	ISO 294-4	%	2.2

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Injection molding conditions



Pre-drying(Suggested max. moisture : 0.1 %)

It is recommend to dry material at 80 °C ~ 100 °C(176 °F~ 212 °F) for 3 h ~ 4 h if necessary.

Temperature

Mold temperature : 60 °C ~ 90 °C(140 °F~ 194 °F)

Barrel temperature : 190 °C ~ 220 °C(374 °F ~ 428 °F)

Mold	Bn (Nozzle)	B3 (Metering)	B2 (Compression)	B1 (Feeding)	Hopper
60 ~ 80 °C	190 ~ 220 °C	200 ~ 210 °C	190 ~ 200 °C	180 C ~ 190 °C	60 ~ 80 °C
140 ~ 176 °F	374 ~ 428 °F	392 ~ 410 °F	374 ~ 392 °F	356 ~ 374 °F	140 ~ 176 °F

Plastication

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

Back pressure : maximum 20 bar

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