KEPITAL® FG2025

POM-GF25 — Korea Engineering Plastics Co. Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**7**	g/10min	ISO 1133
Molding shrinkage, parallel	**0.5**	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	**7**	g/10min	ASTM D 1238
Temperature	**190**	°C	-
Load	**2.16**	kg	-
Mold Shrinkage, MD	**0.005**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**9000**	MPa	ISO 527
Tensile Strength	**160**	MPa	ISO 527
Strain at break	**3**	%	ISO 527
Flexural modulus, 23°C	**8250**	MPa	ISO 178
Charpy notched impact strength, +23°C	**8**	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**8**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**165**	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**162**	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	**30**	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	**HB**	class	IEC 60695-11-10

Electrical properties	Value	Unit	Test Standard
ISO Data			
Surface resistivity	**>1E15**	Ohm	IEC 62631-3-2
Electric strength	**23**	kV/mm	IEC 60243-1

Other properties	Value	Unit	Test Standard
Humidity absorption	**0.2**	%	Sim. to ISO 62
Density	**1590**	kg/m³	ISO 1183
Density	**1590**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80 - 100**	°C	-
Pre-drying - Time	**3 - 4**	h	-
Processing humidity	**≤0.1**	%	-
Mold temperature	**60 - 80**	°C	-
Feed temperature	**60 - 80**	°C	-
Zone 1	**170 - 180**	°C	-
Zone 2	**180 - 190**	°C	-
Zone 3	**190 - 200**	°C	-
Nozzle temperature	**180 - 210**	°C	-
Back pressure	**2**	MPa	-

Characteristics

Processing

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Features

Creep Resistance

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