

**Kocetal® EL304**

(POM+TPE)

Kolon Industries

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	9	g/10min	ISO 1133
Temperature	190	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	1.7	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	9	g/10min	ASTM D 1238
Temperature	190	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.017	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Strength	40	MPa	ISO 527
Flexural modulus, 23°C	1750	MPa	ISO 178
Charpy notched impact strength, +23°C	10	kJ/m <sup>2</sup>	ISO 179/1eA
Rockwell hardness	M 76	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Strength	43	MPa	ASTM D 638
Elongation at Break	85	%	ASTM D 638
Flexural Modulus	1700	MPa	ASTM D 790
Flexural Strength	60	MPa	ASTM D 790
Rockwell Hardness	M 76	-	ASTM D 785
Izod Impact notched, 1/8 in	110	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	80	°C	ISO 75-1/-2
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	0.8	mm	-
Coefficient of Thermal Expansion, MD	130	E-6/K	ASTM D 696
DTUL @ 66 psi	144	°C	ASTM D 648
DTUL @ 264 psi	82	°C	ASTM D 648
Melting Temperature	166	°C	ASTM D 3418
<b>Electrical properties</b>			
<b>ISO Data</b>			
Volume resistivity	1E12	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Electric strength	19	kV/mm	IEC 60243-1
<b>ASTM Data</b>			
Dielectric Strength, Short Time	19	kV/mm	ASTM D 149
Dissipation Factor, 1 MHz	0.006	-	ASTM D 150
Surface Resistivity	>1E15	Ohm	ASTM D 257
Volume Resistivity	1E14	Ohm*cm	ASTM D 257
<b>Other properties</b>			
Density	1360	kg/m <sup>3</sup>	ISO 1183
Water Absorption, 24hr	0.25	%	ASTM D 570
Density	1360	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	80 - 90	°C	-
Pre-drying - Time	3	h	-
Melt temperature	≤220	°C	-

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Mold temperature	<b>60 - 80</b>	°C	-
Zone 1	<b>180</b>	°C	-
Zone 2	<b>190</b>	°C	-
Zone 3	<b>190</b>	°C	-
Nozzle temperature	<b>200</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Chemical Resistance**

General Chemical Resistance

**Special Characteristics**

High impact or impact modified

**Regional Availability**

North America, Asia Pacific