

## POM | KEPITAL FG2025 LOF | Reinforced · filled grade

- A 25% glass fiber-reinforced grade for general injection molding.
- Suitable for parts requiring extremely high strength, high stiffness, high deflection temperature and excellent creep resistance.
- A low-emission grade featuring improved heat stability.

General information	Test Standard	Unit	Value
Polymer abbreviation	ISO 1043	-	POM-GF25

Physical properties	Test Standard	Unit	Value
Density	ISO 1183	g/cm <sup>3</sup>	1.58
Melt flow rate	ISO 1133	g/10 min	8.1
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	-
Flammability	UL 94	-	HB
Melting point(10 °C/min)	ISO 11357	°C	165
Coefficient of linear thermal expansion	ISO 11359	X 10 <sup>-5</sup> /°C	-

Mechanical properties	Test Standard	Unit	Value
Tensile strength	ISO 527	MPa	140
Tensile strain at yield	ISO 527	%	-
Strain at break	ISO 527	%	2.0
Flexural strength	ISO 178	MPa	210
Flexural modulus	ISO 178	MPa	8,100
Charpy impact strength(Notched)	ISO 179/1eA	kJ/m <sup>2</sup>	8.4

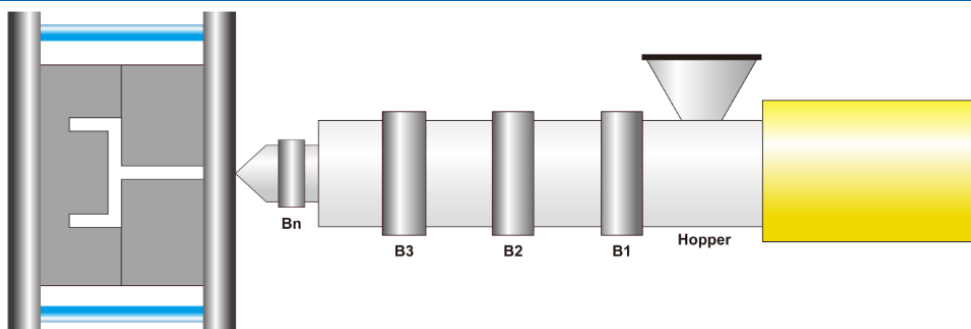
Electrical properties	Test Standard	Unit	Value
Surface resistivity	IEC 60093	Ω	1x10 <sup>16</sup>
Volume resistivity	IEC 60093	Ω · cm	1x10 <sup>14</sup>
Dielectric strength	IEC 60243-1	kV/mm	-

Others	Test Standard	Unit	Value
Mold shrinkage(flow direction, Φ = 100 mm, t = 3 mm)	KEP Method	%	-

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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 ~ 80 °C(140 °F ~ 176 °F)

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

Mold	Bn (Nozzle)	B3 (Metering)	B2 (Compression)	B1 (Feeding)	Hopper
60 ~ 80 °C	180 ~ 190 °C	170 ~ 180 °C	170 ~ 180 °C	170 C ~ 180 °C	60 ~ 80 °C
140 ~ 176 °F	356 ~ 374 °F	338 ~ 356 °F	338 ~ 356 °F	338 ~ 356 °F	140 ~ 176 °F

### Plastification

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

Back pressure : maximum 20 bar

### Contact information

#### Headquarters

14<sup>th</sup> Floor, OCI BLDG., Sogong-ro, Jung-gu  
Seoul, 04532, Republic of Korea  
Tel 82-2-728-7441~8, Telefax 82-2-714-9235

#### KEP Europe GmbH

Rheingaustrasse 190-196 D-65203 Wiesbaden Germany  
Tel +49 (0)611 962-7381, Telefax +49 (0)611 962-9132

#### KEP Americas

106 North Denton Tap Road Suite 210-202 Coppell,  
TX 75019, USA  
Tel +1 888 KEPITAL, Telefax +1 888 537-3291

#### KEP China

Room T2-903C, No.2 building. SOHO Tianshan Plaza. No.1717  
Tianshan Rd. Changning Dstrct. Shanghai. China  
Tel +86 21 6237-1972, Telefax +86 21 6237-1803

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