

KEPITAL® F20-33

POM, unfilled, medium viscosity, improved toughness

A toughness-improved (medium viscosity) grade for general injection molding.

Features: improved molding cycle, toughness and wear resistance

Product information

Part Marking Code	> POM <	ISO 11469
-------------------	---------	-----------

Rheological properties

Moulding shrinkage range, parallel	2.0 %	ISO 294-4, 2577
------------------------------------	-------	-----------------

Typical mechanical properties

Tensile Modulus	2750 MPa	ISO 527-1/-2
Yield stress, 50mm/min	65 MPa	ISO 527-1/-2
Yield strain, 50mm/min	10 %	ISO 527-1/-2
Nominal strain at break	33 %	ISO 527-1/-2
Flexural Modulus	2550 MPa	ISO 178
Flexural Strength	87 MPa	ISO 178
Charpy notched impact strength, 23°C	6.5 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	5.5 kJ/m ²	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	165 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	100 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	120 E-6/K	ISO 11359-1/-2

Electrical properties

Volume resistivity	1E12 Ohm.m	IEC 62631-3-1
Surface resistivity	1E16 Ohm	IEC 62631-3-2
Electric strength	19 kV/mm	IEC 60243-1

Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Density	1410 kg/m ³	ISO 1183

Injection

Drying Temperature	80 - 90 °C
Drying Time, Dehumidified Dryer	3 - 4 h
Processing Moisture Content	0.1 %
Max. mould temperature	60 - 80 °C
Back pressure	2 MPa

KEPITAL® F20-33

Additional information

Injection molding

mold temperature: 60°C ~ 80°C (140°F ~ 176°F)
barrel temperature: 170°C ~ 210°C (338°F ~ 410°F)
screw speed: 150mm/s ~ 200mm/s
back pressure: max. 20 bar

Processing Texts

Pre-drying

It is recommended to dry material at 80°C ~ 90°C (176°F ~ 194°F) for 3h ~ 4h if necessary.
suggest max. moisture: 0.1%

Injection molding

mold temperature: 60°C ~ 80°C (140°F ~ 176°F)
barrel temperature: 170°C ~ 210°C (338°F ~ 410°F)
screw speed: 150mm/s ~ 200mm/s
back pressure: max. 20 bar

Other Approvals

Other Approvals

OEM	Specification	Additional Information
GM	GMW22P-POM-C2	Fuel Compatible (replaced GMP.POM.005)