

KOPEL® KP3855FB

Injection Molding, PEL, General Purpose, High flow

Application

Automotive(Air Bag Cover)

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	–	1.18
Melt Flow Index	240 °C, 2.16kg	ASTM D1238	g/10min	15
Shrinkage		ASTM D955	%	1.2~1.6
Water Absorption	23°C, H ₂ O, 24hr	ASTM D570	%	0.5
Mechanical				
Tensile Strength at Break (3.2mm)	200 mm/min	ASTM D638	MPa	30
Elongation at Break (3.2mm)	200 mm/min	ASTM D638	%	450
Flexural Strength (3.2mm)	200 mm/min	ASTM D790	MPa	–
Flexural Modulus (3.2mm)	200 mm/min	ASTM D790	MPa	–
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 °C		J/m	NB
	–30 °C		J/m	NB
Shore hardness	D scale	ASTM D2240	–	55
Thermal				
Melting Point	20 °C/min	ASTM D1525	°C	223
Vicat softening temperature	10N	ASTM D1525	°C	165
Flammability(0.8mm)		UL94	Class	HB
Electrical				
Dielectric Strength		IEC 60243	kV/mm	
Volume Resistivity		IEC 60093	Ω · cm	
Surface Resistivity		IEC 60093	Ω /sq	

※ 1Mpa = 10.197162 Kg/cm², 1J/m = 0.10197 Kg · cm/cm, (Test specimen Thickness)

Updated: 2020-06-04

The values of each item in this document provide general information about the product and may be different from actual ones as reference dimensions for customer's convenience of material selection. This information cannot be viewed as a Certificate of Analysis(COA) issued by the Company to customers, nor can it be used as a basis for legal disputes such as lawsuits. The value of each item cannot be compared with the measurement result of other environment, equipment and method because it is measured under the specific condition using the existing measurement equipment and external authorized agency equipment. The characteristics described above are subject to change, and you are solely responsible for the determination and use of this product. In addition, these materials do not apply when adding pigments and other additives to the product depending on the customer's purpose of use. The value of the shrinkage factor in the above data is the value measured under the specific injection condition using our standard test piece and may be changed according to other test piece (product) and condition. Therefore, it is the customer's responsibility to apply the correction by considering the required characteristics of the molded product, the mold design condition, the product shape, the injection conditions, etc. Even if there is a difference in the shrinkage rate of the product in the mold manufactured by applying this shrinkage ratio, we also assume no guarantee or liability.

Processing Guide (Injection Molding)

Drying Temperature(℃)	100~110	(Dehumidifying Dryer)		
Drying Time(hr)	3~8			
Processing Moisture Contents(%)	≤ 0.1			
Cylinder Temperature(℃)	Nozzle	Front	Middle	Rear
	220~240	220~240	210~230	190~210
Mold Temperature(℃)	20~40			

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