

KOCETAL® CF704

Acetal (POM) Copolymer
Kolon Plastics, Inc.

Message:
Kocetal CF704 is carbon fiber reinforced grade for high stiffness and electrical conductivity.

General Information			
Filler / Reinforcement	Carbon Fiber		
Features	Conductive		
	High Stiffness		
RoHS Compliance	RoHS Compliant		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.46	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50	%	ASTM D955
Water Absorption (Equilibrium, 23°C, 60%RH)	0.22	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	95		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 23°C)	120	MPa	ASTM D638
Tensile Elongation (Yield, 23°C)	4.0	%	ASTM D638
Flexural Modulus (23°C)	13700	MPa	ASTM D790
Flexural Strength (23°C)	175	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	40	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	165	°C	
1.8 MPa, Unannealed	162	°C	
Melting Temperature	166	°C	
CLTE - Flow	3.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+3	ohms	ASTM D257
Volume Resistivity	1.0E+2	ohms · cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method

Flame Rating	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	3.0	hr
Suggested Max Regrind	30	%
Rear Temperature	170 to 190	°C
Middle Temperature	190 to 210	°C
Front Temperature	200 to 220	°C
Nozzle Temperature	200 to 220	°C
Processing (Melt) Temp	165 to 220	°C
Mold Temperature	70.0 to 120	°C
Injection Pressure	68.6 to 118	MPa
Holding Pressure	98.1	MPa
Back Pressure	1.96 to 4.90	MPa

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