

DURACON® GH-25LV

Acetal (POM) Copolymer

Polyplastics Co., Ltd.

Message:

Low VOC

General Information			
Features	Low VOC		
Forms	Particle		
Processing Method	Injection molding		
Part Marking Code (ISO 11469)	>POM-GF25		
Physical	Nominal Value	Unit	Test Method
Density	1.59	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	7.0	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	5.00	cm ³ /10min	ISO 1133
Water Absorption (23°C, 24 hr)	0.70	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	95		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8500	MPa	ISO 527-2
Tensile Stress	126	MPa	ISO 527-2
Tensile Strain (Break)	2.3	%	ISO 527-2
Flexural Modulus	7600	MPa	ISO 178
Flexural Stress	190	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	6.0	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	162	°C	ISO 75-2/A
Linear thermal expansion coefficient			Internal method
Flow: 23 to 55°C	3.0E-5	cm/cm/°C	Internal method
Lateral: 23 to 55°C	9.0E-5	cm/cm/°C	Internal method
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Additional Information	Nominal Value		
Color Number	CF3500		
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	3.0 - 4.0	hr	

Processing (Melt) Temp	190 - 210	°C
Mold Temperature	60.0 - 80.0	°C
Injection Pressure	49.0 - 98.0	MPa
Screw Speed	100 - 150	rpm

Injection instructions

Injection Speed: 5-50mm/s (0.3-3m/min)Molding Cycle:

Injection Holding Pressure: Gate sealing time + α

Cooling: Plasticizing time or ejection capable time

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