

DURACON® M270LV

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		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	27	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	23.0	cm ³ /10min	ISO 1133
Water Absorption (23°C, 24 hr)	0.60	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2650	MPa	ISO 527-2
Tensile Stress	63.0	MPa	ISO 527-2
Nominal Tensile Strain at Break	30	%	ISO 527-2
Flexural Modulus	2400	MPa	ISO 178
Flexural Stress	86.0	MPa	ISO 178
Coefficient of friction-Dynamic			JIS K7218
-- ¹	0.370		JIS K7218
-- ²	0.470		JIS K7218
Color Number	CF2001/CD3069		
Specific Wear			JIS K7218
-- ³		10 ⁻³ mm ³ /N·km	JIS K7218
-- ⁴	1.50	10 ⁻³ mm ³ /N·km	JIS K7218
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)	95.0	°C	ISO 75-2/A
Linear thermal expansion coefficient			Internal method
Flow: 23 to 55°C	1.1E-4	cm/cm/°C	Internal method
Lateral: 23 to 55°C	1.1E-4	cm/cm/°C	Internal method
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	3.0E+16	ohms	IEC 60093

Volume Resistivity	3.0E+14	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
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 + alpha

Cooling: Plasticizing time or ejection capable time

NOTE

1. vs M90-44, pressure 0.06MPa, 15cm/s
2. vs C-Steel, pressure 0.49MPa, 30cm/s
3. vs C-Steel, steel side, pressure 0.49MPa, 30cm/s
4. vs C-Steel, material side, pressure 0.49MPa, 30cm/s

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