Generic Acetal (POM) Homopolymer - Glass Fiber

Acetal (POM) Homopolymer

Generic

Message:

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General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.47 - 1.63	g/cm³	ASTM D792
Molding Shrinkage			
Flow: 23°C	0.30 - 1.7	%	ASTM D955
23°C	1.2 - 1.7	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.18 - 0.90	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (23°C)	82 - 120		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (23°C)	4650 - 11000	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield, 23°C	59.3 - 68.1	MPa	ASTM D638
Fracture, 23°C	53.7 - 70.4	MPa	ASTM D638
23°C	66.8 - 78.2	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	2.6 - 4.2	%	ASTM D638
Flexural Modulus (23°C)	3000 - 7600	MPa	ASTM D790
Flexural Strength (23°C)	69.6 - 198	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C)	33 - 72	J/m	ASTM D256
Unnotched Izod Impact (23°C)	33 - 430	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	159 - 253	°C	ASTM D648
1.8 MPa, not annealed	144 - 165	°C	ASTM D648
Melting Temperature	175 - 177	°C	
CLTE - Flow	4.6E-5 - 8.0E-5	cm/cm/°C	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity (23°C)	1.0E+14 - 1.0E+16	ohms·cm	ASTM D257
Dielectric Strength (23°C)	16	kV/mm	ASTM D149

Injection	Nominal Value	Unit
Drying Temperature	80.0 - 121	°C
Drying Time	1.9 - 4.0	hr
Rear Temperature	182 - 206	°C
Middle Temperature	199 - 206	°C
Front Temperature	206 - 216	°C
Processing (Melt) Temp	200 - 215	°C
Mold Temperature	89.3 - 96.7	°C
Back Pressure	0.258 - 2.04	MPa
Screw Speed	45	rpm

Injection instructions

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