

# DURACON® TR-20LV

Acetal (POM) Copolymer

Polyplastics Co., Ltd.

## Message:

Low VOC, Mineral Reinforced

| General Information                               |                   |           |                 |
|---------------------------------------------------|-------------------|-----------|-----------------|
| Filler / Reinforcement                            | Mineral filler    |           |                 |
| Features                                          | Low VOC           |           |                 |
|                                                   | Fill              |           |                 |
| Forms                                             | Particle          |           |                 |
| Processing Method                                 | Injection molding |           |                 |
| Part Marking Code (ISO 11469)                     | >POM-TD15         |           |                 |
| Physical                                          | Nominal Value     | Unit      | Test Method     |
| Density                                           | 1.53              | g/cm³     | ISO 1183        |
| Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)         | 22                | g/10 min  | ISO 1133        |
| Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)       | 17.0              | cm³/10min | ISO 1133        |
| Water Absorption (23°C, 24 hr)                    | 0.50              | %         | ISO 62          |
| Hardness                                          | Nominal Value     | Unit      | Test Method     |
| Rockwell Hardness (M-Scale)                       | 75                |           | ISO 2039-2      |
| Mechanical                                        | Nominal Value     | Unit      | Test Method     |
| Tensile Modulus                                   | 4250              | MPa       | ISO 527-2       |
| Tensile Stress                                    | 55.0              | MPa       | ISO 527-2       |
| Tensile Strain (Break)                            | 8.0               | %         | ISO 527-2       |
| Flexural Modulus                                  | 3900              | MPa       | ISO 178         |
| Flexural Stress                                   | 90.0              | MPa       | ISO 178         |
| Impact                                            | Nominal Value     | Unit      | Test Method     |
| Charpy Notched Impact Strength                    | 3.0               | kJ/m²     | ISO 179/1eA     |
| Thermal                                           | Nominal Value     | Unit      | Test Method     |
| Heat Deflection Temperature (1.8 MPa, Unannealed) | 123               | °C        | ISO 75-2/A      |
| Linear thermal expansion coefficient              |                   |           | Internal method |
| Flow: 23 to 55°C                                  | 8.0E-5            | cm/cm/°C  | Internal method |
| Lateral: 23 to 55°C                               | 8.0E-5            | cm/cm/°C  | Internal method |
| Flammability                                      | Nominal Value     |           | Test Method     |
| Flame Rating                                      | HB                |           | UL 94           |
| Additional Information                            | Nominal Value     |           |                 |
| Color Number                                      | CF2001            |           |                 |

| 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

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