

DURACON® M25-34

Acetal (POM) Copolymer

Polyplastics Co., Ltd.

Message:

Extrusion Molding

General Information			
UL File Number	E45034		
Forms	Particle		
Processing Method	Extrusion		
	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)	2.5	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	2.20	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	80		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-2
Tensile Stress	59.0	MPa	ISO 527-2
Nominal Tensile Strain at Break	40	%	ISO 527-2
Flexural Modulus	2350	MPa	ISO 178
Flexural Stress	81.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	8.0	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	90.0	°C	ISO 75-2/A
Linear thermal expansion coefficient			Internal method
Flow: 23 to 55°C	1.2E-4	cm/cm/°C	Internal method
Lateral: 23 to 55°C	1.2E-4	cm/cm/°C	Internal method
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength (3.00 mm)	19	kV/mm	IEC 60243-1
Flammability	Nominal Value	Unit	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 + alphaCooling: Plasticizing time or ejection capable time

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