

Ultraform® N 2640 E4

Acetal (POM) Copolymer

BASF Corporation

Message:

Elastomer-modified injection molding grade with high toughness and high weld line strength.

General Information			
Additive	Impact modifier		
Features	Impact modification		
	Copolymer		
	Good toughness		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS compliance		
Forms	Particles		
Processing Method	Injection molding		
Resin ID (ISO 1043)	POM-HI		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm³	ISO 1183
Apparent Density	0.85	g/cm³	
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	3.00	cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.8	%	ISO 294-4
Flow direction	1.8	%	ISO 294-4
Water Absorption			ISO 62
Saturated, 23°C	0.90	%	ISO 62
Equilibrium, 23°C, 50% RH	0.20	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	88.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1700	MPa	ISO 527-2
Tensile Stress (Yield)	40.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	7.3	%	ISO 527-2/50
Nominal Tensile Strain at Break	> 50	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	8.5	kJ/m²	ISO 179/1eA
23°C	15	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU

-30°C	240	kJ/m ²	ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	75.0	°C	ISO 75-2/A
Melting Temperature	166	°C	ISO 11357-3
CLTE - Flow (23 to 55°C)	1.4E-4	cm/cm/°C	ISO 11359-2
Maximum operating temperature-short cycle operation	100	°C	
ISO Type	POM-K, M-GNPR, 01-001		ISO 9988-1
Screw Speed		mm/sec	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093
Relative Permittivity (1 MHz)	3.40		IEC 60250
Dissipation Factor (1 MHz)	8.0E-3		IEC 60250
Comparative Tracking Index (Solution A)	600	V	IEC 60112
Injection	Nominal Value	Unit	
Drying Temperature	100	°C	
Drying Time	3.0	hr	
Suggested Max Moisture	0.20	%	
Hopper Temperature	200	°C	
Rear Temperature	200	°C	
Middle Temperature	200	°C	
Front Temperature	200	°C	
Nozzle Temperature	200	°C	
Processing (Melt) Temp	190 - 220	°C	
Mold Temperature	60.0 - 80.0	°C	
Injection instructions			
Residence Time : <10 min			

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