

ASTATAL™ F3054

Acetal (POM) Homopolymer
Marplex Australia Pty. Ltd.

Message:

ASTATAL™ F3054 is a low viscosity (high melt flow) UV stabilized grade in the ASTATAL™ range suited to general purpose injection moulding applications. F3054 offers an excellent balance of processability, rigidity, frictional wear, heat and chemical resistance and UV resistance.

General Information			
Additive	UV Stabilizer		
Features	General Purpose		
	Good Chemical Resistance		
	Good Processability		
	Good Stiffness		
	Good UV Resistance		
	Good Wear Resistance		
	High Flow		
	Low Viscosity		
	Medium Heat Resistance		
Uses	General Purpose		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	27	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	2.0	%	ASTM D955
Water Absorption (24 hr)	0.22	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	80		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	62.3	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	50	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2620	MPa	ASTM D790
Flexural Strength ⁴ (6.40 mm)	91.2	MPa	ASTM D790
Shear Strength (2.00 mm)	54.9	MPa	ASTM D732
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	54	J/m	ASTM D256
Tensile Impact Strength (1.60 mm)	98.0	kJ/m ²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	158	°C	

1.8 MPa, Unannealed, 6.40 mm	110	°C	
Melting Temperature	165	°C	DSC
CLTE - Flow	1.3E-4	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating (0.800 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 90.0	°C	
Drying Time	2.0 to 3.0	hr	
Rear Temperature	165 to 185	°C	
Middle Temperature	175 to 195	°C	
Front Temperature	185 to 205	°C	
Processing (Melt) Temp	190 to 210	°C	
Mold Temperature	50.0 to 90.0	°C	
Injection Pressure	60.0 to 130	MPa	
Injection Rate	Moderate-Fast		
Back Pressure	0.500 to 2.50	MPa	
Screw Speed	40 to 60	rpm	
Clamp Tonnage	3.0 to 5.0	kN/cm ²	
NOTE			
1.	20 mm/min		
2.	20 mm/min		
3.	2.8 mm/min		
4.	2.8 mm/min		

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