

Plaslube® AC-81/TF/15

Acetal (POM) Homopolymer
Techmer Engineered Solutions

Message:
Acetal Homopolymer is the specific generic type.

General Information			
Additive	PTFE Lubricant (15%)		
Features	Lubricated		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.50	g/cm ³	ASTM D792
Molding Shrinkage - Flow	2.2	%	ASTM D955
Water Absorption (24 hr)	0.23	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	56.5	MPa	ASTM D638
Flexural Modulus	2620	MPa	ASTM D790
Flexural Strength (Yield)	80.7	MPa	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.16		
vs. Steel - Static	0.080		
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	59	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	102	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	71.1	°C	
Drying Time	2.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	177 to 193	°C	
Middle Temperature	188 to 210	°C	
Front Temperature	182 to 199	°C	
Nozzle Temperature	177 to 204	°C	
Processing (Melt) Temp	193 to 216	°C	
Mold Temperature	82.2 to 121	°C	
Injection Rate	Moderate		
Back Pressure	0.345 to 0.689	MPa	

Screw Speed

70 to 80

rpm

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

