

DURACON® M90-07

Acetal (POM) Copolymer

Polyplastics Co., Ltd.

Message:

Black color concentrate

General Information			
UL File Number	E66328		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Part Marking Code (ISO 11469)	>POM-CD10		
Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	5.0	g/10 min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	80		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Linear thermal expansion coefficient			Internal method
Flow: 23 to 55°C	1.1E-4	cm/cm/°C	Internal method
Lateral: 23 to 55°C	1.1E-4	cm/cm/°C	Internal method
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Additional Information	Nominal Value		
Color Number	K30680		
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: 5-50 mm/sInjection Holding pressure: Gate sealing time + alphaCooling: Plasticizing time or ejection capable time

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