HIVAL® 1609 NAT

Acetal (POM) Copolymer

Nexeo Solutions, LLC.

Message:

HIVAL®1609 NAT is a polyoxymethylene (POM) copolymer material. This product is available in North America and is processed by injection molding. HIVAL®The main features of 1609 NAT are: ROHS certification.

General Information			
RoHS Compliance	RoHS compliance		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.41	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	9.00	cm³/10min	ISO 1133
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2650	MPa	ISO 527-2
Tensile Stress (Yield)	65.0	MPa	ISO 527-2
Tensile Strain (Break)	35	%	ISO 527-2
Flexural Modulus	2600	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact	69	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	154	°C	ASTM D648
1.8 MPa, not annealed	98.9	°C	ASTM D648
Peak Melting Temperature	167	°C	ASTM D3418
Injection	**Nominal Value**	**Unit**	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	191 - 210	°C	
Middle Temperature	210 - 216	°C	
Front Temperature	218 - 227	°C	
Nozzle Temperature	218 - 227	°C	
Processing (Melt) Temp	191 - 229	°C	
Mold Temperature	80.0 - 90.0	°C	
Injection Pressure	2.76 - 10.3	MPa	
Back Pressure	1.03 - 3.45	MPa	
Injection instructions			

Injection Speed: Slow - FastAvoid excessive melt temperatures and long residence times as this could lead to thermal degradation.

Recommended distributors for this material

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