

PRL AH-GP1

Acetal (POM) Homopolymer
Polymer Resources Ltd.

Message:

PRL AH-GP1 is a polyoxymethylene (POM) homopolymer product. It can be processed by extrusion or injection molding and is available in North America. Features include:
flame retardant/rated flame
ROHS certification
Homopolymer
heat stabilizer

General Information			
Additive	heat stabilizer		
Features	Homopolymer		
	Good melt strength		
	Low liquidity		
	Thermal Stability		
RoHS Compliance	RoHS compliance		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/1.05 kg)	1.0 - 3.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.8 - 2.2	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, 3.18mm	67.6	MPa	ASTM D638
Fracture, 3.18mm	67.6	MPa	ASTM D638
Flexural Modulus (3.18 mm)	2830	MPa	ASTM D790
Flexural Strength (3.18 mm)	94.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	120	J/m	ASTM D256
Dart Drop Impact (3.18 mm)	22.6	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.18mm	166	°C	ASTM D648
1.8 MPa, unannealed, 3.18mm	110	°C	ASTM D648
Flammability	Nominal Value		Test Method

Flame Rating		UL 94
1.59 mm	HB	UL 94
3.18 mm	HB	UL 94

Injection	Nominal Value	Unit
Drying Temperature	76.7 - 82.2	°C
Drying Time	2.0 - 4.0	hr
Drying Time, Maximum	8.0	hr
Rear Temperature	193 - 204	°C
Middle Temperature	196 - 207	°C
Front Temperature	199 - 210	°C
Processing (Melt) Temp	199 - 210	°C
Mold Temperature	79.4 - 98.9	°C

Extrusion	Nominal Value	Unit
Drying Temperature	76.7 - 82.2	°C
Drying Time	2.0 - 4.0	hr
Cylinder Zone 1 Temp.	193 - 204	°C
Cylinder Zone 2 Temp.	196 - 207	°C
Cylinder Zone 3 Temp.	199 - 210	°C
Melt Temperature	193 - 210	°C
Die Temperature	79.4 - 98.9	°C

Extrusion instructions

Drying Temperature: do not exceed 8 hours

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