

ASTATAL™ F2054

Acetal (POM) Homopolymer
Marplex Australia Pty. Ltd.

Message:

ASTATAL™ F2054 is the standard weather resistant medium viscosity (medium melt flow) grade in the ASTATAL™ range and is suited for general purpose injection moulding applications requiring high UV resistance. ASTATAL™ F2054 is only available in a natural (white) colour. Typical applications include automotive interior window winders, interior doorhandles, water irrigation valves and nozzles assemblies as well domestic interior curtain sliders and wheels.

General Information			
Features	General Purpose		
	Good UV Resistance		
	Good Weather Resistance		
	Medium Flow		
	Medium Viscosity		
Uses	Automotive Applications		
	Automotive Interior Parts		
	General Purpose		
	Handles		
	Valves/Valve Parts		
	Wheels		
Appearance	Natural Color		
	White		
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)	9.0	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)	59.8	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	60	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2550	MPa	ASTM D790
Flexural Strength ⁴ (6.40 mm)	86.3	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)	120	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	0.100 to 0.500	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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