

ISOTAL™ C27

Acetal (POM) Copolymer
SABIC Innovative Plastics Europe

Message:
General purpose, unfilled polyacetal (POM) copolymer resin.

General Information			
Features	Copolymer		
	General Purpose		
Uses	General Purpose		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	27	g/10 min	ISO 1133
Molding Shrinkage - Flow	2.0 to 2.7	%	ISO 294-4
Water Absorption (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	114		ISO 2039-2
Ball Indentation Hardness (H 358/30)	140	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3000	MPa	ISO 527-2
Tensile Stress (Yield)	65.0	MPa	ISO 527-2
Tensile Strain			ISO 527-2
Yield	8.0	%	
Break	30	%	
Flexural Modulus	2600	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	kJ/m ²	ISO 179/1eA
Notched Izod Impact Strength (23°C)	6.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	120	°C	ISO 75-2/A
Vicat Softening Temperature	150	°C	ISO 306/B120
Electrical	Nominal Value	Unit	Test Method
Electric Strength (in Air)	25	kV/mm	IEC 60243-1
Injection	Nominal Value	Unit	Test Method
Processing (Melt) Temp	185 to 200	°C	

Mold Temperature	75.0 to 95.0	°C
Injection Pressure	74.9	MPa
Injection Rate	Moderate	

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