

4POM® 9I15100

Acetal (POM) Homopolymer

4Plas

Message:

4POM 9I15100 is a MFI 9 PTFE Lubricated POM

General Information			
Additive	Lubricant		
Features	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.50	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	9.0	g/10 min	ISO 1133
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2500	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	67.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	24	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	5.0	kJ/m ²	ISO 180/1A
23°C	5.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	155	°C	ISO 75-2/B
1.8 MPa, not annealed	85.0	°C	ISO 75-2/A
Melting Temperature ²	165	°C	ISO 11357
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.750 mm	HB		UL 94
1.60 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	100 - 120	°C	
Drying Time	3.0	hr	
Processing (Melt) Temp	180 - 220	°C	
Mold Temperature	60.0 - 100	°C	

Injection Rate	Moderate-Fast	
Holding Pressure	80.0 - 100	MPa
Screw Speed	300	rpm

Injection instructions

Feed Throat Temperature: 30 - 50 °CBack Pressure: Low

NOTE

1.	24 Hrs
2.	10 K/min

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

