

4POM® 10I30000

Acetal (POM) Homopolymer
4Plas

Message:

4POM 10I30000 is a MFI 27 Unfilled POM

General Information			
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	27	g/10 min	ISO 1133
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.22	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	80		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2850	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	40	%	ISO 527-2/5
Flexural Modulus ² (23°C)	2700	MPa	ISO 178
Flexural Stress	93.0	MPa	ISO 178
Shear Strength	54.9	MPa	ASTM D732
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	6.0	kJ/m ²	ISO 180/1A
Tensile Impact Strength	98.1	kJ/m ²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	100	°C	ISO 75-2/B
Vicat Softening Temperature	103	°C	ISO 306/B
Melting Temperature ³	165	°C	ISO 11357
CLTE - Flow	1.3E-4	cm/cm/°C	ASTM D696
Heat Distortion	158	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms · cm	IEC 60093
Dielectric Strength	19	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	3.70		ASTM D150
Dissipation Factor (1 MHz)	7.0E-3		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (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 °C Back Pressure: Low

NOTE

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| 1. | 24 Hrs |
| 2. | 2.0 mm/min |
| 3. | 10 K/min |

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