

# HiFill® MD POM 0167 LE

Acetal (POM) Copolymer  
Techmer Engineered Solutions

Message:  
Acetal Copolymer, Metallic Filler, Activated for X-Ray Detection, Low Extractables for FDA Compliant Applications

| General Information                       |                        |                   |             |
|-------------------------------------------|------------------------|-------------------|-------------|
| Filler / Reinforcement                    | Metal                  |                   |             |
| Features                                  | Copolymer              |                   |             |
|                                           | Low Extractables       |                   |             |
|                                           | Metal Detectable       |                   |             |
| Agency Ratings                            | FDA Unspecified Rating |                   |             |
| Appearance                                | Colors Available       |                   |             |
| Forms                                     | Pellets                |                   |             |
| Processing Method                         | Injection Molding      |                   |             |
| Physical                                  | Nominal Value          | Unit              | Test Method |
| Specific Gravity                          | 1.67                   | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (190°C/2.16 kg) | 9.0                    | g/10 min          | ASTM D1238  |
| Molding Shrinkage - Flow (3.18 mm)        | 1.6                    | %                 | ASTM D955   |
| Water Absorption (24 hr)                  | 0.20                   | %                 | ASTM D570   |
| Hardness                                  | Nominal Value          | Unit              | Test Method |
| Rockwell Hardness (R-Scale)               | 100                    |                   | ASTM D785   |
| Mechanical                                | Nominal Value          | Unit              | Test Method |
| Tensile Strength (Break)                  | 51.7                   | MPa               | ASTM D638   |
| Tensile Elongation (Break)                | 40                     | %                 | ASTM D638   |
| Flexural Modulus                          | 3030                   | MPa               | ASTM D790   |
| Flexural Strength (Break)                 | 82.7                   | MPa               | ASTM D790   |
| Impact                                    | Nominal Value          | Unit              | Test Method |
| Notched Izod Impact (23°C, 3.18 mm)       | 59                     | J/m               | ASTM D256   |
| Thermal                                   | Nominal Value          | Unit              | Test Method |
| Deflection Temperature Under Load         |                        |                   | ASTM D648   |
| 0.45 MPa, Unannealed                      | 160                    | °C                |             |
| 1.8 MPa, Unannealed                       | 110                    | °C                |             |
| CLTE - Flow                               | 2.2E-5                 | cm/cm/°C          | ASTM D696   |
| Electrical                                | Nominal Value          | Unit              | Test Method |
| Volume Resistivity                        | 1.0E+14                | ohms · cm         | ASTM D257   |
| Injection                                 | Nominal Value          | Unit              |             |
| Drying Temperature                        | 71.1                   | °C                |             |

|                        |             |    |
|------------------------|-------------|----|
| Drying Time            | 1.0         | hr |
| Rear Temperature       | 177 to 193  | °C |
| Middle Temperature     | 188 to 210  | °C |
| Front Temperature      | 182 to 199  | °C |
| Nozzle Temperature     | 177 to 204  | °C |
| Processing (Melt) Temp | 193 to 216  | °C |
| Mold Temperature       | 82.2 to 121 | °C |

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