

Tarnoform® 411

Acetal (POM) Copolymer

Grupa Azoty S.A.

Message:

Tarnoform® 411 - is the easy flowing, internally strengthened grade for injection-moulding of thin-walled parts of very high mechanical requirements, exhibit low mould deposit.

General Information			
Features	Good Flow		
Uses	Appliances		
	Automotive Applications		
	Electrical/Electronic Applications		
	Household Goods		
	Thin-walled Parts		
Appearance	Black		
Forms	Granules		
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)	13	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	11.5	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (2.00 mm)	2.0	%	ISO 294-4
Water Absorption			ISO 62
Saturation, 23°C	0.65	%	
Equilibrium, 23°C, 50% RH	0.20	%	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	170	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3000	MPa	ISO 527-2/1
Tensile Stress (Yield)	65.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	10	%	
Break	30	%	
Flexural Modulus ¹	2700	MPa	ISO 178
Flexural Stress ²	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	6.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	170	kJ/m ²	ISO 179/1eU

Notched Izod Impact Strength	6.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	120	°C	ISO 75-2/A
Vicat Softening Temperature	155	°C	ISO 306/B
Melting Temperature	172	°C	ISO 11357-3
CLTE - Flow (23 to 55°C)	1.1E-4	cm/cm/°C	ISO 11359-2
Limit of Temperature - a few hours operation	110	°C	
Burning Rate	< 100	mm/min	FMVSS 302
ISO Type	POM-K, M-GNR, 04-002		ISO 1874
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Electric Strength (2.00 mm)	25	kV/mm	IEC 60243-1
Dielectric Constant (1 Hz)	3.80		IEC 60250
Comparative Tracking Index (Solution A)	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.20 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	< 0.10	%	
Suggested Max Regrind	10	%	
Processing (Melt) Temp	180 to 230	°C	
Mold Temperature	60.0 to 120	°C	
Injection Pressure	60.0 to 120	MPa	
Injection Rate	Slow-Moderate		
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		

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