

Generic Acetal (POM) Copolymer - Glass Bead

Acetal (POM) Copolymer

Generic

Message:

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General Information			
Filler / Reinforcement	Glass beads		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.47 - 1.70	g/cm ³	ASTM D792
23°C	1.47 - 1.64	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	5.0 - 22	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	3.80 - 17.0	cm ³ /10min	ISO 1133
Molding Shrinkage			
Flow: 23°C	0.47 - 2.5	%	ASTM D955
23°C	1.3 - 2.0	%	ISO 294-4
Water Absorption			
23°C, 24 hr	0.19 - 0.50	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.16 - 0.80	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (23°C)	75 - 110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	2000 - 7050	MPa	ASTM D638
23°C	2980 - 4100	MPa	ISO 527-2
Tensile Stress			
Yield, 23°C	35.0 - 50.0	MPa	ISO 527-2
Fracture, 23°C	37.0 - 60.0	MPa	ISO 527-2
23°C	35.8 - 82.8	MPa	ASTM D638
Tensile Elongation			
Yield, 23°C	8.1 - 10	%	ASTM D638
Yield, 23°C	4.0 - 8.0	%	ISO 527-2
Fracture, 23°C	1.5 - 16	%	ASTM D638
Fracture, 23°C	4.8 - 20	%	ISO 527-2
Flexural Modulus			
23°C	2470 - 4170	MPa	ASTM D790
23°C	1900 - 4900	MPa	ISO 178

Flexural Strength			
23°C	55.2 - 103	MPa	ASTM D790
23°C	60.0 - 110	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	2.0 - 4.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	20 - 60	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	29 - 58	J/m	ASTM D256
23°C	2.9 - 6.0	kJ/m ²	ISO 180
Unnotched Izod Impact (23°C)	310 - 550	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	160 - 163	°C	ASTM D648
1.8 MPa, not annealed	102 - 161	°C	ASTM D648
1.8 MPa, not annealed	93.5 - 125	°C	ISO 75-2/A
Melting Temperature			
--	166	°C	
--	165 - 167	°C	ISO 11357-3
CLTE - Flow	6.3E-5 - 8.1E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity			
--	1.0E+15 - 1.0E+16	ohms	ASTM D257
--	1.0E+13 - 1.0E+16	ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+14 - 3.5E+14	ohms·cm	ASTM D257, IEC 60093
Dielectric Strength			
23°C	18 - 19	kV/mm	ASTM D149
23°C	20 - 40	kV/mm	IEC 60243-1
Dissipation Factor (23°C)	6.0E-3 - 0.030		IEC 60250
Comparative Tracking Index	598 - 600	V	IEC 60112
Injection	Nominal Value	Unit	
Drying Temperature	81.5 - 121	°C	
Drying Time	2.0 - 3.5	hr	
Suggested Max Moisture	0.10 - 0.15	%	
Suggested Max Regrind	15	%	
Rear Temperature	175 - 200	°C	
Middle Temperature	184 - 200	°C	
Front Temperature	195 - 216	°C	
Nozzle Temperature	191 - 200	°C	
Processing (Melt) Temp	200 - 208	°C	
Mold Temperature	79.3 - 107	°C	
Injection Pressure	85.3 - 121	MPa	
Back Pressure	0.250 - 1.05	MPa	

Injection instructions

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