

Duratuf™ 809

Acetal (POM) Copolymer

Technical Polymers, LLC

Message:

Duratuf™809 is a polyoxymethylene (POM) copolymer material. This product is available in North America and is processed by injection molding.

Duratuf™The main features of the 809 are:

flame retardant/rated flame

Medium viscosity

General Information			
Features	Medium viscosity		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (23°C)	62.1	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	40	%	ASTM D638
Flexural Modulus (23°C)	2480	MPa	ASTM D790
Flexural Strength (23°C)	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	59	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	158	°C	ASTM D648
1.8 MPa, not annealed	110	°C	ASTM D648
Melting Temperature	166	°C	DSC
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+13	ohms · cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Additional Information			
Tensile Elongation, ASTM D638: >40%Volum Resistivity, ASTM D257: >1e13 ohm-cm			
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Drying Time	2.0 - 4.0	hr	
Processing (Melt) Temp	182 - 199	°C	
Mold Temperature	65.6 - 98.9	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.103 - 0.345	MPa	
Screw Speed	25 - 75	rpm	

Clamp Tonnage	3.4 - 5.5	kN/cm ²
Cushion	3.18 - 12.7	mm
Screw L/D Ratio	20.0:1.0	
Screw Compression Ratio	2.5:1.0	

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