ASTATAL™ F30

Acetal (POM) Homopolymer

Marplex Australia Pty. Ltd.

Message:

ASTATAL™ F3001 / F3002 / F3003 are the low viscosity (high melt flow) grades in the ASTATAL™ range and are suited to general purpose injection moulding applications. Offering an exceptional combination of processability, rigidity, frictional wear, heat and chemical resistance, typical applications include camera components, fountain pen nibs and electronic calculator buttons.
Note: [No mould release = 01] / [Standard mould release = 02] / [Low mould deposit = 03].
Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTATAL™ F3003W].

General Information	
Features	General Purpose
	Good Chemical Resistance
	Good Processability
	Good Stiffness
	Good Wear Resistance
	High Flow
	Low Viscosity
	Medium Heat Resistance
Uses	Camera Applications
	Electrical/Electronic Applications
	General Purpose
	Writing Instruments
Processing Method	Injection Molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	27	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	2.0	%	ASTM D955
Water Absorption (24 hr)	0.22	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (M-Scale)	80		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1] (3.20 mm)	62.3	MPa	ASTM D638
Tensile Elongation [2] (Break, 3.20 mm)	50	%	ASTM D638
Flexural Modulus [3] (6.40 mm)	2620	MPa	ASTM D790
Flexural Strength [4] (6.40 mm)	91.2	MPa	ASTM D790
Shear Strength (2.00 mm)	54.9	MPa	ASTM D732
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.20 mm)	54	J/m	ASTM D256

Tensile Impact Strength (1.60 mm)	98.0	kJ/m²	ASTM D1822
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	158	°C	
1.8 MPa, Unannealed, 6.40 mm	110	°C	
Melting Temperature	165	°C	DSC
CLTE - Flow	1.3E-4	cm/cm/°C	ASTM D696
Flammability	**Nominal Value**		**Test Method**
Flame Rating (0.800 mm)	HB		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80.0 to 90.0	°C	
Drying Time	2.0 to 3.0	hr	
Rear Temperature	165 to 185	°C	
Middle Temperature	175 to 195	°C	
Front Temperature	185 to 205	°C	
Processing (Melt) Temp	190 to 210	°C	
Mold Temperature	50.0 to 90.0	°C	
Injection Pressure	60.0 to 130	MPa	
Injection Rate	Moderate-Fast		
Back Pressure	0.500 to 2.50	MPa	
Screw Speed	40 to 60	rpm	
Clamp Tonnage	3.0 to 5.0	kN/cm²	
NOTE			
1.	20 mm/min		
2.	20 mm/min		
3.	2.8 mm/min		
4.	2.8 mm/min		

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