

Edgetek™ AT-25CF/000 BK001

Acetal (POM) Copolymer

PolyOne Corporation

Message:

25% carbon fiber filled POM compound

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 25% filler by weight		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.47	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.10 - 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	95.0	MPa	ASTM D638
Flexural Modulus ²	13100	MPa	ASTM D790
Flexural Strength ³	140	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	35	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	160	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0 - 1.0E+3	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	180 - 210	°C	
Middle Temperature	180 - 210	°C	
Front Temperature	180 - 210	°C	
Mold Temperature	40.0 - 90.0	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	5.0 mm/min		
2.	1.3 mm/min		
3.	1.3 mm/min		

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