

4POM® 23I00000

Acetal (POM) Homopolymer
4Plas

Message:

4POM 23I00000 is a MFI 2.5 Unfilled POM

General Information			
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)	2.5	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2800	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	67.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	15	%	ISO 527-2/5
Flexural Modulus ¹ (23°C)	2500	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	kJ/m ²	ISO 179/B
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	156	°C	ISO 75-2/B
Melting Temperature ²	165	°C	ISO 11357
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	100 - 120	°C	
Drying Time	3.0	hr	
Processing (Melt) Temp	180 - 220	°C	
Mold Temperature	60.0 - 100	°C	
Injection Rate	Moderate-Fast		
Holding Pressure	80.0 - 100	MPa	
Screw Speed	300	rpm	
Injection instructions			
Feed Throat Temperature: 30 - 50 °CBack Pressure: Low			
NOTE			
1.	2.0 mm/min		
2.	10 K/min		

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