

Clariant Acetal CA9000NAT

Acetal (POM) Copolymer

Clariant Corporation

Message:

Clariant Acetal CA9000NAT is a polyoxymethylene (POM) copolymer material. This product is available in North America and is processed by injection molding.

General Information			
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.40	g/cm ³	ASTM D792
Molding Shrinkage - Flow	2.4	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	60.0	MPa	ASTM D638
Tensile Elongation (Break)	50	%	ASTM D638
Flexural Modulus	2590	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	64	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	107	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	93.3	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	177 - 199	°C	
Middle Temperature	182 - 204	°C	
Front Temperature	193 - 216	°C	
Nozzle Temperature	199 - 218	°C	
Processing (Melt) Temp	199 - 213	°C	
Mold Temperature	87.8 - 135	°C	
Injection Pressure	8.27	MPa	
Holding Pressure	2.76	MPa	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	30 - 60	rpm	
Injection instructions			

Secondary Injection Pressure: 600 psi

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