

Clariant Acetal HP-MF1

Acetal (POM) Homopolymer

Clariant Corporation

Message:

Clariant Acetal HP-MF1 is an Acetal (POM) Homopolymer material. It is available in North America for injection molding.

General Information			
Features	General Purpose		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.43	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)	1.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	2.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	65.5	MPa	ASTM D638
Tensile Elongation (Break)	60	%	ASTM D638
Flexural Modulus	2140	MPa	ASTM D790
Flexural Strength	75.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	80	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	166	°C	
1.8 MPa, Unannealed	130	°C	
Melting Temperature	177	°C	
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	2.0	hr	
Suggested Max Regrind	25	%	
Rear Temperature	171 to 182	°C	
Middle Temperature	185 to 193	°C	
Front Temperature	196 to 202	°C	
Nozzle Temperature	204 to 218	°C	
Mold Temperature	60.0 to 90.6	°C	
Injection Pressure	34.5 to 138	MPa	
Back Pressure	0.00 to 10.3	MPa	
Screw Speed	30 to 60	rpm	

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Recommended distributors for this material

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