

**Plaslube® AC-81/SI/2**

Techmer Polymer Modifiers - Acetal (POM) Homopolymer

**Product Description**

Acetal Homopolymer is the specific generic type.

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Additive	• Lubricant: 2%		
Features	• Homopolymer	• Lubricated	
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		

**ASTM & ISO Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.40		ASTM D792
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Strength (Yield)	8200	psi	ASTM D638
Flexural Modulus	410000	psi	ASTM D790
Flexural Strength (Yield)	12500	psi	ASTM D790
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (264 psi, Unannealed)	242	°F	ASTM D648

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	160	°F
Drying Time	2.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	350 to 380	°F
Middle Temperature	370 to 410	°F
Front Temperature	360 to 390	°F
Nozzle Temperature	350 to 400	°F
Processing (Melt) Temp	380 to 420	°F
Mold Temperature	180 to 250	°F
Injection Rate	Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	70 to 80	rpm

