

Plaslube® AC-80/TF/10

Techmer Polymer Modifiers - Acetal (POM) Copolymer

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Additive	• PTFE Lubricant: 10%
Features	• Lubricated
Uses	• Bearings • Gears
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.46		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.020	in/in	ASTM D955
Water Absorption (24 hr)	0.26	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (73°F)	6600	psi	ASTM D638
Flexural Modulus (73°F)	330000	psi	ASTM D790
Flexural Strength (73°F)	10100	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.17		
vs. Steel - Static	0.10		
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	210	°F	ASTM D648
CLTE - Flow	1.3E-5	in/in/°F	ASTM D696

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	1.0 to 2.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	350 to 370	°F
Middle Temperature	370 to 390	°F
Front Temperature	360 to 380	°F
Nozzle Temperature	350 to 370	°F
Processing (Melt) Temp	370 to 400	°F
Mold Temperature	170 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 100	psi

Injection Notes

Screw Speed: Medium
 Recommendations for Molding and Tool Conditions: Well vented
 Moisture Content, as received: Product is packaged at 0.2% or less.
 Drying not normally required. Dry at 180°F for 1 to 2 hours if necessary.

