

Plaslube® AC-80/TF/2

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: 2%
Features	• Lubricated
Uses	• Bearings • Gears
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.41		ASTM D792
Mechanical			
Tensile Strength (Break, 73°F)	8500	psi	ASTM D638
Flexural Modulus (73°F)	350000	psi	ASTM D790
Flexural Strength (Break, 73°F)	12000	psi	ASTM D790
Impact			
Notched Izod Impact (73°F, 0.125 in)	0.70	ft·lb/in	ASTM D256
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	245	°F	ASTM D648

Processing Information

	Nominal Value	Unit
Injection		
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.

