

Plaslube® AC-81/TF/15 NAT

Techmer Polymer Modifiers - Acetal (POM) Homopolymer

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.50		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.020 to 0.024	in/in	ASTM D955
Water Absorption (24 hr)	0.23	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	8000	psi	ASTM D638
Tensile Elongation (Break)	7.5	%	ASTM D638
Flexural Modulus	360000	psi	ASTM D790
Flexural Strength	12000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	1.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	220	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
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

