Plaslube® AC-80/SI/2

Techmer Polymer Modifiers - *Acetal (POM) Homopolymer*

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

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.40		ASTM D792
Water Absorption (24 hr)	0.030	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break, 73°F)	8000	psi	ASTM D638
Flexural Modulus (73°F)	350000	psi	ASTM D790
Flexural Strength (Break, 73°F)	12000	psi	ASTM D790
Compressive Strength	10000	psi	ASTM D695
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.11		
vs. Steel - Static	0.080		
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	1.6	ft·lb/in	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	115		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	230	°F	ASTM D648
CLTE - Flow	5.0E-5	in/in/°F	ASTM D696
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	HB		UL 94

Additional Information

Coefficient of Friction, Static, Thrust washer, 40psi, ambient temp.: 0.08
Coefficient of Friction, Dynamic, Thrust washer, 40psi, 50 ft/min, ambient temp.: 0.11
Limiting PV, Thrust washer, 100 FPM, ambient temperature: 8E3

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