



## Plaslube® AC-80/TF/20

Techmer Polymer Modifiers - Acetal (POM) Copolymer

### General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Asia Pacific • Europe • Latin America • North America
Additive	• PTFE Lubricant: 20%
Features	• Copolymer • Lubricated
Uses	• Bearings • Gears
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.51		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.020	in/in	ASTM D955
Water Absorption (24 hr)	0.23	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (73°F)	6000	psi	ASTM D638
Flexural Modulus (73°F)	310000	psi	ASTM D790
Flexural Strength (73°F)	9300	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.15		
vs. Steel - Static	0.070		
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	0.90	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	212	°F	ASTM D648
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.: 0.07		
Coefficient of Friction, Dynamic, Thrust washer, 40psi, 50 ft/min, ambient temp.: 0.15			
Limiting PV, Thrust washer, 100 FPM, ambient temp.: 1.3E4			

### 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.

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