

Plaslube® POM HO S/AL 5004 BK

Techmer Polymer Modifiers - Acetal (POM) Homopolymer

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Aramid Fiber
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.42		ASTM D792
Molding Shrinkage - Flow (0.125 in)	9.0E-3 to 0.011	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	450000	psi	ASTM D638
Tensile Strength (Yield)	8500	psi	ASTM D638
Tensile Strength (Break)	8500	psi	ASTM D638
Tensile Elongation (Break)	9.0	%	ASTM D638
Flexural Modulus	430000	psi	ASTM D790
Flexural Strength	13000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.90	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	360 to 390	°F
Middle Temperature	370 to 400	°F
Front Temperature	380 to 410	°F
Nozzle Temperature	390 to 420	°F
Processing (Melt) Temp	360 to 420	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

