

**Electrafil® POM CO AS BK**

Techmer Polymer Modifiers - Acetal (POM) Copolymer

**General Information**
**General**

Material Status	• Commercial: Active
Availability	• North America
Additive	• Antistatic
Features	• Antistatic • Conductive
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.38		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.018	in/in	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
<b>Mechanical</b>			
Tensile Strength (Yield)	8000	psi	ASTM D638
Tensile Elongation (Break)	30	%	ASTM D638
Flexural Modulus	200000	psi	ASTM D790
Flexural Strength	11000	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (0.125 in)	1.1	ft·lb/in	ASTM D256
<b>Hardness</b>			
Rockwell Hardness (R-Scale)	100		ASTM D785
<b>Thermal</b>			
Deflection Temperature Under Load (264 psi, Unannealed)	210	°F	ASTM D648
CLTE - Flow	4.0E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
Surface Resistivity	1.0E+6 to 1.0E+8	ohms	ASTM D257
Volume Resistivity	1.0E+7 to 1.0E+9	ohms·cm	ASTM D257
<b>Flammability</b>			
Flame Rating (0.06 in)	HB		UL 94

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
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.

