

HiFill® POM CO 2320 LE BL138

 Techmer Polymer Modifiers - *Acetal (POM) Copolymer*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Appearance	<ul style="list-style-type: none"> Blue
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.42		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.010 to 0.015	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	380000	psi	ASTM D638
Tensile Strength (Yield)	8900	psi	ASTM D638
Tensile Strength (Break)	8200	psi	ASTM D638
Tensile Elongation (Break)	30	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.2	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	170	°F
Drying Time	1.0 to 3.0	hr
Rear Temperature	350 to 390	°F
Middle Temperature	360 to 400	°F
Front Temperature	370 to 410	°F
Nozzle Temperature	380 to 420	°F
Processing (Melt) Temp	360 to 420	°F
Mold Temperature	75 to 175	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

Notes

¹ Typical properties: these are not to be construed as specifications.

