

**HiFill® POM CO ML2 NAT**

Techmer Polymer Modifiers - Acetal (POM) Copolymer

**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Additive	• Molybdenum Disulfide Lubricant
Features	• Lubricated
Appearance	• Natural Color
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.43		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	0.010 to 0.013	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	325000	psi	ASTM D638
Tensile Strength (Yield)	8700	psi	ASTM D638
Tensile Strength (Break)	8000	psi	ASTM D638
Tensile Elongation (Break)	25	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	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	50.0 to 100	psi
Screw Speed	Slow	

