

**HiFill® AC-80/FE/10 NAT**

 Techmer Polymer Modifiers - *Acetal (POM) Copolymer*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Appearance	• Natural Color
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density	1.48	g/cm <sup>3</sup>	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8800	psi	ASTM D638
Tensile Elongation (Break)	21	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.94	ft·lb/in	ASTM D256
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+10 to 1.0E+14	ohms	ASTM D257

**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	365 to 425	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

