

HiFill® POM CO BK MB

Techmer Polymer Modifiers - *Acetal (POM) Copolymer*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.41		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	370000	psi	ASTM D638
Tensile Strength (Yield)	9000	psi	ASTM D638
Tensile Elongation (Break)	25	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.5	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	325 to 360	°F
Middle Temperature	350 to 400	°F
Front Temperature	370 to 420	°F
Nozzle Temperature	350 to 380	°F
Processing (Melt) Temp	375 to 420	°F
Mold Temperature	140 to 175	°F
Injection Rate	Slow-Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	Slow-Moderate	

Notes

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

