

HiFill® POM CO 1000

Techmer Polymer Modifiers - Acetal (POM) Copolymer

General Information
General

Material Status	• Commercial: Active
Availability	• North America
Features	• Copolymer
Appearance	• Colors Available • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.41		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.018	in/in	ASTM D955
Water Absorption (24 hr)	0.14	%	ASTM D570
Mechanical			
Tensile Modulus	400000	psi	ASTM D638
Tensile Strength (Yield)	8800	psi	ASTM D638
Tensile Elongation (Yield)	10	%	ASTM D638
Flexural Strength	11800	psi	ASTM D790
Impact			
Notched Izod Impact (73°F, 0.125 in)	1.2	ft·lb/in	ASTM D256
Hardness			
Rockwell Hardness (R-Scale)	100		ASTM D785
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	315	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	230	°F	ASTM D648
CLTE - Flow	1.2E-5	in/in/°F	ASTM D696
Electrical			
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	450	V/mil	ASTM D149
Flammability			
Flame Rating	HB		UL 94

Processing Information

	Nominal Value	Unit
Injection		
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.

