

Electrafil® POM CO CF10 BK

Techmer Polymer Modifiers - Acetal (POM) Copolymer

General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber, 10% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.44		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.010 to 0.020	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.10E+6	psi	ASTM D638
Tensile Strength (Yield)	11000	psi	ASTM D638
Tensile Strength (Break)	10500	psi	ASTM D638
Tensile Elongation (Break)	2.7	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.90	ft·lb/in	ASTM D256
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	< 1.0E+4	ohms	ASTM D257

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	1.0 to 2.0	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	365 to 415	°F
Mold Temperature	50 to 150	°F
Injection Rate	Moderate-Fast	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Moderate	

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