

HiFill® POM CO GF25 TS15 BK

 Techmer Polymer Modifiers - *Acetal (POM) Copolymer*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Additive	• Lubricant
Features	• Lubricated
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.62		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	990000	psi	ASTM D638
Tensile Strength (Yield)	7000	psi	ASTM D638
Tensile Strength (Break)	6800	psi	ASTM D638
Tensile Elongation (Break)	1.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.60	ft·lb/in	ASTM D256

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	370 to 425	°F
Mold Temperature	100 to 150	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Moderate	

Notes

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

