

HiFill® POM CO GB10 X

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

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.43		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	340000	psi	ASTM D638
Tensile Strength (Yield)	7000	psi	ASTM D638
Tensile Elongation (Break)	20	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.3	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	0.00 to 100	psi
Screw Speed	Slow-Moderate	

