

HiFill® POM CO TL5 LE WT101

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

Material Status	• Commercial: Active
Availability	• North America
Additive	• PTFE Lubricant
Features	• Low Extractables • Lubricated
Appearance	• White
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 Strength (Yield)	8500	psi	ASTM D638
Tensile Elongation (Break)	26	%	ASTM D638

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	1.0 to 2.0	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	365 to 420	°F
Mold Temperature	75 to 150	°F
Injection Rate	Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

