

HiFill® POM CO GF10 BK

Techmer Polymer Modifiers - Acetal (POM) Copolymer

General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Glass Fiber, 10% Filler by Weight
Features	<ul style="list-style-type: none"> Copolymer
Appearance	<ul style="list-style-type: none"> Black
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.47		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.010 to 0.015	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	520000	psi	ASTM D638
Tensile Strength (Yield)	9800	psi	ASTM D638
Tensile Strength (Break)	9500	psi	ASTM D638
Tensile Elongation (Break)	4.6	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.90	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	170	°F
Drying Time	1.0 to 3.0	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	75 to 175	°F
Injection Rate	Moderate-Fast	
Back Pressure	25.0 to 50.0	psi
Screw Speed	Moderate	

