

HiFill® CONC POM CO SL20

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
Additive	<ul style="list-style-type: none"> Silicone Lubricant
Features	<ul style="list-style-type: none"> Lubricated
Appearance	<ul style="list-style-type: none"> Natural Color
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.31		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.015 to 0.018	in/in	ASTM D955
Water Absorption (24 hr)	0.21	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	6000	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	200000	psi	ASTM D790
Flexural Strength	8000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	4.0	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	78		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	300	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	200	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	2.0 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	360 to 415	°F
Mold Temperature	75 to 150	°F
Injection Rate		Slow
Back Pressure	25.0 to 75.0	psi
Screw Speed		Slow-Moderate

