

**HiFill® POM CO GF25 CC**

Techmer Polymer Modifiers - Acetal (POM) Copolymer

**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Features	• Chemically Coupled • Copolymer
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.58		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.25	%	ASTM D570
<b>Mechanical</b>			
Tensile Strength (Break)	16000	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	1.10E+6	psi	ASTM D790
Flexural Strength	23100	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (73°F, 0.125 in)	1.1	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	8.0	ft·lb/in	ASTM D4812
<b>Hardness</b>			
Rockwell Hardness (M-Scale)	84		ASTM D785
<b>Thermal</b>			
Deflection Temperature Under Load (66 psi, Unannealed)	325	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	330	°F	ASTM D648
Melting Temperature	329	°F	
CLTE - Flow	2.1E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	500	V/mil	ASTM D149
<b>Flammability</b>			
Flame Rating	HB		UL 94

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	160	°F
Drying Time	1.0	hr
Rear Temperature	350 to 380	°F
Middle Temperature	370 to 410	°F
Front Temperature	360 to 390	°F
Nozzle Temperature	350 to 400	°F
Processing (Melt) Temp	380 to 420	°F
Mold Temperature	180 to 250	°F

