

**HiFill® POM 0168 S2 LE BL339**

 Techmer Polymer Modifiers - *Acetal (POM) Copolymer*
**General Information**
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Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Blue</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.71		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.010 to 0.020	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	450000	psi	ASTM D638
Tensile Strength (Yield)	7700	psi	ASTM D638
Tensile Elongation (Break)	10	%	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	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	375 to 420	°F
Processing (Melt) Temp	360 to 425	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

**Notes**
<sup>1</sup> Typical properties: these are not to be construed as specifications.
