

HiFill® POM M90-44 Artic White II

Techmer Polymer Modifiers - Acetal (POM) Homopolymer

General Information
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Material Status	• Commercial: Active
Availability	• North America
Appearance	• White
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.42		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	9.2	g/10 min	ASTM D1238
Moisture (311°F)	0.030	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8800	psi	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.1	ft·lb/in	ASTM D256

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	

