

**HiFill® TPX-POM-09005 Cool GY810878**

 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>
Additive	<ul style="list-style-type: none"> <li>Lubricant</li> </ul>
Features	<ul style="list-style-type: none"> <li>Lubricated</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Grey</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

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

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.41		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 0.010	in/in	ASTM D955
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	400000	psi	ASTM D638
Tensile Strength (Yield)	8000	psi	ASTM D638
Tensile Strength (Break)	7500	psi	ASTM D638
Tensile Elongation (Break)	35	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	1.0	ft·lb/in	ASTM D256

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	150	°F
Drying Time	2.0 to 3.0	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 425	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

