

**HiFill® POM HO GB20 LE**

Techmer Polymer Modifiers - Acetal (POM) Homopolymer

**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Bead
Features	• Homopolymer • Low Extractables
Appearance	• Colors Available
Processing Method	• Injection Molding

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.55		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.022	in/in	ASTM D955
Water Absorption (24 hr)	0.20	%	ASTM D570
<b>Mechanical</b>			
Tensile Strength (Break)	6200	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	600000	psi	ASTM D790
Flexural Strength	12200	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (73°F, 0.125 in)	0.60	ft-lb/in	ASTM D256
<b>Hardness</b>			
Rockwell Hardness (R-Scale)	100		ASTM D785
<b>Thermal</b>			
Deflection Temperature Under Load (66 psi, Unannealed)	318	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	249	°F	ASTM D648
CLTE - Flow	3.5E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	450	V/mil	ASTM D149
<b>Flammability</b>			
Flame Rating (0.06 in)	HB		UL 94

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	200	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	380 to 425	°F
Middle Temperature	380 to 425	°F
Front Temperature	380 to 425	°F
Processing (Melt) Temp	380 to 440	°F
Mold Temperature	180 to 220	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 60	rpm

