

Plaslube® AC-80/TF/20 BK1941

 Techmer Polymer Modifiers - *Acetal (POM) Copolymer*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Appearance	<ul style="list-style-type: none"> Black
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.50	g/cm ³	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7500	psi	ASTM D638
Tensile Stress (Yield)	6930	psi	ISO 527-2
Flexural Modulus	318000	psi	ASTM D790
Flexural Modulus	315000	psi	ISO 178
Flexural Strength	10100	psi	ASTM D790
Flexural Stress	9650	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
0.125 in	0.75	ft·lb/in	ASTM D256
0.125 in	0.61	ft·lb/in	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	176	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	154	°F	ISO 75-2/A

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	

