

## Plaslube® HO TL15

Techmer Polymer Modifiers - Acetal (POM) Homopolymer

### General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Additive	• PTFE Lubricant
Features	• Homopolymer • Lubricated
Appearance	• Colors Available
Processing Method	• Injection Molding

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.52		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.020	in/in	ASTM D955
Water Absorption (24 hr)	0.15	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	7200	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	400000	psi	ASTM D790
Flexural Strength	11000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	0.90	ft-lb/in	ASTM D256
Unnotched Izod Impact (73°F, 0.125 in)	5.0	ft-lb/in	ASTM D4812
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	79		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	320	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	215	°F	ASTM D648
Melting Temperature	324	°F	
CLTE - Flow	5.5E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	500	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		UL 94

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	160	°F
Drying Time	2.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	350 to 380	°F
Middle Temperature	370 to 410	°F
Front Temperature	360 to 390	°F
Nozzle Temperature	350 to 400	°F
Processing (Melt) Temp	380 to 420	°F
Mold Temperature	180 to 250	°F
Injection Rate	Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	70 to 80	rpm

