

**Plaslube® AC-80/TF/10**

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

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• PTFE Lubricant: 10%		
Features	• Lubricated		
Uses	• Bearings	• Gears	
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		
Processing Method	• Injection Molding		

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.46		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.020	in/in	ASTM D955
Water Absorption (24 hr)	0.26	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (73°F)	6600	psi	ASTM D638
Flexural Modulus (73°F)	330000	psi	ASTM D790
Flexural Strength (73°F)	10100	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.17		
vs. Steel - Static	0.10		
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	210	°F	ASTM D648
CLTE - Flow	1.3E-5	in/in/°F	ASTM D696

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	1.0 to 2.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	350 to 370	°F
Middle Temperature	370 to 390	°F
Front Temperature	360 to 380	°F
Nozzle Temperature	350 to 370	°F
Processing (Melt) Temp	370 to 400	°F
Mold Temperature	170 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 100	psi

**Injection Notes**

Screw Speed: Medium  
 Recommendations for Molding and Tool Conditions: Well vented  
 Moisture Content, as received: Product is packaged at 0.2% or less.  
 Drying not normally required. Dry at 180°F for 1 to 2 hours if necessary.

