

Plaslube® AC-80/TF/20 NATL

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 |
| Additive | <ul style="list-style-type: none"> PTFE Lubricant |
| Features | <ul style="list-style-type: none"> Lubricated |
| Appearance | <ul style="list-style-type: none"> Natural Color |
| Processing Method | <ul style="list-style-type: none"> Injection Molding |

Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|-------------------------------------|-----------------|----------|-------------|
| Density / Specific Gravity | 1.51 | | ASTM D792 |
| Molding Shrinkage - Flow (0.125 in) | 9.0E-3 to 0.011 | in/in | ASTM D955 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus | 290000 | psi | ASTM D638 |
| Tensile Strength (Yield) | 7000 | psi | ASTM D638 |
| Tensile Strength (Break) | 6500 | psi | ASTM D638 |
| Tensile Elongation (Break) | 25 | % | ASTM D638 |
| Flexural Modulus | 330000 | psi | ASTM D790 |
| Flexural Strength | 10000 | psi | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (0.125 in) | 0.70 | ft·lb/in | ASTM D256 |

Processing Information

| Injection | Nominal Value | Unit |
|------------------------|---------------|------|
| Drying Temperature | 150 | °F |
| Drying Time | 2.0 to 3.0 | hr |
| Rear Temperature | 350 to 390 | °F |
| Middle Temperature | 360 to 400 | °F |
| Front Temperature | 370 to 410 | °F |
| Nozzle Temperature | 380 to 420 | °F |
| Processing (Melt) Temp | 360 to 420 | °F |
| Mold Temperature | 75 to 150 | °F |
| Injection Rate | Slow | |
| Back Pressure | 25.0 to 75.0 | psi |
| Screw Speed | Slow-Moderate | |

