

Plaslube® AC-80/TF/10 NAT

Techmer Polymer Modifiers - Acetal (POM) Copolymer

General Information
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Material Status	• Commercial: Active
Availability	• North America
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	7380	psi	ISO 527-2
Tensile Strength (Break)	7600	psi	ASTM D638
Tensile Elongation (Break)	31	%	ASTM D638
Tensile Strain (Break)	25	%	ISO 527-2
Flexural Modulus	332000	psi	ASTM D790
Flexural Strength	10500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.90	ft·lb/in	ASTM D256
Notched Izod Impact Strength (0.125 in)	2.3	ft·lb/in ²	ISO 180

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	

