

Plaslube® POM CO E TL20

Techmer Polymer Modifiers - Acetal (POM) Copolymer

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Additive	• PTFE Lubricant
Features	• Copolymer • Lubricated • Wear Resistant
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Extrusion

Properties ¹

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)	0.17	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	6900	psi	ASTM D638
Tensile Elongation (Yield)	10	%	ASTM D638
Flexural Modulus	305000	psi	ASTM D790
Flexural Strength	10800	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.15		
vs. Steel - Static	0.17		
Wear Factor	14	10 ⁻¹⁰ in ³ ·min/ft·lb·hr	ASTM D3702
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.4	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	81		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)	210	°F	ASTM D648
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

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.

Notes

¹ Typical properties: these are not to be construed as specifications.

