



# DURACON® HP25X

## Polyplastics - Acetal (POM) Copolymer

### General Information

#### Product Description

High Rigidity

High Viscosity

#### General

Features	• Copolymer	• High Rigidity	• High Viscosity
UL File Number	• E45034		
Forms	• Pellets		
Processing Method	• Injection Molding		
Part Marking Code (ISO 11469)	• >POM<		

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

Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	2.5	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	2.2	cm <sup>3</sup> /10min	ISO 1133
Molding Shrinkage <sup>2</sup>			ISO 294-4
Across Flow : 0.0787 in	2.7	%	
Flow : 0.0787 in	2.4	%	
Water Absorption (24 hr, 73°F, 0.0394 in)	0.60	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	421000	psi	ISO 527-1
Tensile Stress	9860	psi	ISO 527-2
Nominal Tensile Strain at Break	35	%	ISO 527-2
Flexural Modulus	384000	psi	ISO 178
Flexural Stress	13300	psi	ISO 178
Coefficient of Friction			JIS K7218
Dynamic <sup>3</sup>	0.37		
vs. Steel - Dynamic <sup>4</sup>	0.40		
Wear Factor			JIS K7218
140 psi, 59 ft/min <sup>5</sup>	< 0.50	10 <sup>-10</sup> in <sup>3</sup> ·min/ft·lb·hr	
140 psi, 59 ft/min <sup>6</sup>	40	10 <sup>-10</sup> in <sup>3</sup> ·min/ft·lb·hr	
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	5.2	ft·lb/in <sup>2</sup>	ISO 179/1eA
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	90		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed	203	°F	
CLTE - Flow (73 to 131°F)	6.1E-5	in/in/°F	Internal Method
CLTE - Transverse (73 to 131°F)	6.1E-5	in/in/°F	Internal Method

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Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093
Electric Strength (0.118 in)	480	V/mil	IEC 60243-1
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Additional Information	Nominal Value	Unit	
Color Number	CF2001		

#### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 60x60x2mmt, Cavity Pressure 60 MPa

<sup>3</sup> vs M90-44, 0.06 MPa, 15 cm/s

<sup>4</sup> 0.98 MPa, 30 cm/s

<sup>5</sup> vs C-Steel, Steel Side

<sup>6</sup> vs C-Steel, Material Side