

Product Texts

Chemical abbreviation according to ISO 1043-1: POM
 Molding compound ISO 29988-POM-K,,M-GCL,01-002

Stiff-flowing type for injection molding and extrusion with high impact toughness and good tracking resistance over a high range of temperature; UV-stabilized with carbon black, good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation.

Ranges of applications: injection molding thick-walled, void-free molded parts; extrusion e.g. for boards and pipes, exterior applications.

Flammability @1.6mm nom. HB -
 thickn.
 Flammability at thickness h (3 HB UL recognition (h)
 mm)

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	2.5	cm ³ /10min	ISO 1133
Temperature	190	°C	-
Load	2.16	kg	-
^[C] Molding shrinkage, parallel	2.1	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.8	%	ISO 294-4, 2577
^[C] Density of melt	1200	kg/m ³	-
^[C] Thermal conductivity of melt	0.155	W/(m K)	-
^[C] Spec. heat capacity of melt	2210	J/(kg K)	-
^[C] Ejection temperature	140	°C	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2600	MPa	ISO 527
^[C] Yield stress	62	MPa	ISO 527
^[C] Yield strain	9	%	ISO 527
^[C] Nominal strain at break	32	%	ISO 527
^[C] Charpy impact strength, +23°C	250	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	250	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	8.5	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	7	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	165	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	101	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	110	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
^[C] Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
Yellow Card available	yes	-	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 100Hz	4	-	IEC 62631-2-1
^[C] Relative permittivity, 1MHz	4	-	IEC 62631-2-1

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POM

Celanese

[C] Dissipation factor, 100Hz	15	E-4	IEC 62631-2-1
[C] Dissipation factor, 1MHz	50	E-4	IEC 62631-2-1
[C] Volume resistivity	1E12	Ohm*m	IEC 62631-3-1
[C] Surface resistivity	1E14	Ohm	IEC 62631-3-2
[C] Electric strength	35	kV/mm	IEC 60243-1

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
[C] Water absorption	0.65	%	Sim. to ISO 62
[C] Humidity absorption	0.2	%	Sim. to ISO 62
[C] Density	1410	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics**Processing**

Injection Molding, Film Extrusion, Profile Extrusion, Sheet Extrusion, Other Extrusion, Blow Molding

Delivery form

Pellets

Additives

Release agent

Special Characteristics

U.V. stabilized or stable to weather

Features

Copolymer

Other text information**Injection molding**

General drying is not necessary due to low moisture absorption of the resin.

In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended.

Max. Water content 0,2 %
Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.

Conditioning e.g. moisturizing is not necessary.

Film extrusion

General drying is not necessary due to low moisture absorption of the resin.

In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended.

Max. Water content 0,2 %

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature 180-190 °C

Conditioning e.g. moisturizing is not necessary.

In case of very thick wall thickness profiles after-annealing it is recommended to reduce internal stress.

Annealing temperature 130-140 °C
Annealing time 10 min/mm thickness

Other extrusion

General drying is not necessary due to low moisture absorption of the resin.

In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended.

Max. Water content 0,2 %

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature 180-190 °C

Conditioning e.g. moisturizing is not necessary.

In case of very thick wall thickness profiles after-annealing it is recommended to reduce internal stress.

Annealing temperature 130-140 °C
Annealing time 10 min/mm thickness

Profile extrusion

General drying is not necessary due to low moisture absorption of the resin.

In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended.

Max. Water content 0,2 %

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature 180-190 °C

Conditioning e.g. moisturizing is not necessary.

In case of very thick wall thickness profiles after-annealing it is recommended to reduce internal stress.

Annealing temperature 130-140 °C
Annealing time 10 min/mm thickness

Sheet extrusion

General drying is not necessary due to low moisture absorption of the resin.

In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended.

Max. Water content 0,2 %

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature 180-190 °C

Conditioning e.g. moisturizing is not necessary.

In case of very thick wall thickness profiles after-annealing it is recommended to reduce internal stress.

Annealing temperature 130-140 °C
Annealing time 10 min/mm thickness

Blow molding

General drying is not necessary due to low moisture absorption of the resin.

In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended.

Max. Water content 0,2 %

Standard extruders with plasticating screws (20 to 25 D) will fit.

Melt temperature 180-190 °C
Mould-surface temperature 60-100 °C

Conditioning e.g. moisturizing is not necessary.