

Technical Data Sheet

Schulaform 9F DB RED964100

Acetal (POM) Copolymer

Product Description

High viscosity POM

Processing Method Injection Molding**Attribute** High Viscosity**Resin ID** POM

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (190 °C/2.16 kg)	3.0	cm ³ /10 min	ISO 1133
Density, (Method A)	1.41	g/cm ³	ISO 1183
Mechanical			
Tensile Stress at Yield, (Type 1A, 50 mm/min)	61.0	MPa	ISO 527-2
Tensile Strain at Yield, (Type 1A, 50 mm/min)	11	%	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	2500	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	13	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	10	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	No Break		ISO 179
(-30 °C, Type 1, Edgewise)	No Break		ISO 179
Hardness			
Ball Indentation Hardness, (H 358/30)	140	MPa	ISO 2039-1
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	147	°C	ISO 306
(A (10N), 50 °C/h)	162	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	150	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	89.0	°C	ISO 75-2/A
RTI Elec, (1.5 mm)	50.0	°C	UL 746B
RTI Imp, (1.5 mm)	50.0	°C	UL 746B
RTI Str, (1.5 mm)	50.0	°C	UL 746B
Electrical			
Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1

Comparative Tracking Index (CTI)	600	V	IEC 60112
Surface Resistivity	>1.0E+15	ohm	IEC 60093

Flammable

Burning Rate			
(2.00 mm)	44	mm/min	FMVSS 302
(2.00 mm)	44	mm/min	ISO 3795
Glow Wire Flammability Index			
(1.5 mm)	650	°C	IEC 60695-2-12
(3.0 mm)	625	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			
(1.5 mm)	675	°C	IEC 60695-2-13
(3.0 mm)	650	°C	IEC 60695-2-13

UL Information

Flammability Classification			
(1.5 mm)	HB		IEC 60695-11-10, -20
(3.0 mm)	HB		IEC 60695-11-10, -20
UL File Number	E86615		

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	100	°C
Suggested Max Moisture	0.040 to 0.10	%
Processing (Melt) Temp	190 to 210	°C
Mold Temperature	60 to 120	°C