

Technical Data Sheet

SCHULAFORM[®] 9 F

Acetal (POM) Copolymer
Engineering Plastics

Product Description

High viscosity POM

General

Features	• High Viscosity
UL File Number	• E86615
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• POM

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.41 g/cm ³	1.41 g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	3.00 cm ³ /10min	3.00 cm ³ /10min	ISO 1133
Molding Shrinkage	1.5 to 2.5 %	1.5 to 2.5 %	ISO 294-4
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	363000 psi	2500 MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	8850 psi	61.0 MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	11 %	11 %	ISO 527-2/1A/50
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	4.8 ft·lb/in ²	10 kJ/m ²	
73°F (23°C)	6.2 ft·lb/in ²	13 kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	No Break	No Break	
73°F (23°C)	No Break	No Break	
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Ball Indentation Hardness (H 358/30)	20300 psi	140 MPa	ISO 2039-1
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	302 °F	150 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	192 °F	89.0 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	324 °F	162 °C	ISO 306/A50
--	297 °F	147 °C	ISO 306/B50
RTI Elec (0.06 in (1.5 mm))	122 °F	50.0 °C	UL 746
RTI Imp (0.06 in (1.5 mm))	122 °F	50.0 °C	UL 746
RTI Str (0.06 in (1.5 mm))	122 °F	50.0 °C	UL 746
Electrical	Nominal Value (English)	Nominal Value (SI)	Test Method
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1
Comparative Tracking Index	600 V	600 V	IEC 60112

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Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 in (2.00 mm)	1.7 in/min	44 mm/min	ISO 3795
0.0787 in (2.00 mm)	1.7 in/min	44 mm/min	FMVSS 302
Flammability Classification			IEC 60695-11-10, -20
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	
Glow Wire Flammability Index			IEC 60695-2-12
0.06 in (1.5 mm)	1200 °F	650 °C	
0.12 in (3.0 mm)	1160 °F	625 °C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.06 in (1.5 mm)	1250 °F	675 °C	
0.12 in (3.0 mm)	1200 °F	650 °C	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	212 °F	100 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	374 to 410 °F	190 to 210 °C
Mold Temperature	140 to 248 °F	60 to 120 °C

Notes

These are typical property values not to be construed as specification limits.