



**Product Data Sheet &  
General Processing Conditions**

**EMI 861  
Acetal (POM)  
EMI/RFI Shielding  
Stainless Steel Fiber**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.48	1.48	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0100 - 0.0300 in/in	1.00 - 3.00 %	D 955
<b>MECHANICAL</b>			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.5 ft-lbs/in	80 J/m	D 256
unnotched 1/8 in (3.2 mm) section	15.0 ft-lbs/in	801 J/m	D 4812
Tensile Strength	8000 psi	55 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.40 x 10 <sup>6</sup> psi	2758 MPa	D 638
Flexural Strength	12000 psi	83 MPa	D 790
Flexural Modulus	0.40 x 10 <sup>6</sup> psi	2758 MPa	D 790
<b>ELECTRICAL</b>			
Volume Resistivity	< 1E-1 ohm.cm	< 1E-1 ohm.cm	D 257
Surface Resistivity	< 1E2 ohm/sq	< 1E2 ohm/sq	D 257

**PROPERTY NOTES**

Data herein is typical and not to be construed as specifications.  
Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

**GENERAL PROCESSING FOR INJECTION MOLDING**

	<b>English</b>	<b>SI Metric</b>
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	360 - 425 °F	182 - 218 °C
Mold Temperature	180 - 225 °F	82 - 107 °C
Drying	2 hrs @ 140 - 175 °F	2 hrs @ 60 - 79 °C
Moisture Content	0.15 %	0.15 %
Dew Point	-20 °F	-29 °C