



**Product Data Sheet &
General Processing Conditions**

**EMI 863
Acetal (POM)
Stainless Steel Fiber
Electrically Conductive
EMI/RFI/ESD Protection**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	20 %	20 %	
Specific Gravity	1.57	1.57	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0200 - 0.0320 in/in	2.00 - 3.20 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.9 ft-lbs/in	48 J/m	D 256
unnotched 1/8 in (3.2 mm) section	3.5 ft-lbs/in	187 J/m	D 4812
Tensile Strength	5800 psi	40 MPa	D 638
Tensile Elongation	3.0 - 6.0 %	3.0 - 6.0 %	D 638
Tensile Modulus	0.49 x 10 ⁶ psi	3379 MPa	D 638
Flexural Strength	9800 psi	68 MPa	D 790
Flexural Modulus	0.44 x 10 ⁶ psi	3034 MPa	D 790

ELECTRICAL

Volume Resistivity	< 1E0 ohm.cm	< 1E0 ohm.cm	D 257
Surface Resistivity	< 1E3 ohm/sq	< 1E3 ohm/sq	D 257
Surface Resistance	< 1E2 ohm	< 1E2 ohm	ESD STM11.11
Static Decay	< 0.50 s	< 0.50 s	FTMS101C 4046.1

THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	208 °F	98 °C	D 648
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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

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	350 - 415 °F	177 - 213 °C
Mold Temperature	160 - 210 °F	71 - 99 °C
Drying	2 hrs @ 140 - 175 °F	2 hrs @ 60 - 79 °C
Moisture Content	0.15 %	0.15 %
Dew Point	-20 °F	-29 °C