



**Product Data Sheet &
General Processing Conditions**

**ESD 800
Acetal (POM)
ESD Protection
Electrically Conductive**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.37	1.37	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0100 - 0.0250 in/in	1.00 - 2.50 %	D 955
MECHANICAL			
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	No Break	No Break	D 4812
Tensile Strength	6200 psi	43 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.25 x 10 ⁶ psi	1724 MPa	D 638
Flexural Strength	9000 psi	62 MPa	D 790
Flexural Modulus	0.28 x 10 ⁶ psi	1931 MPa	D 790
ELECTRICAL			
Volume Resistivity	< 1E4 ohm.cm	< 1E4 ohm.cm	D 257
Surface Resistivity	< 1E6 ohm/sq	< 1E6 ohm/sq	D 257
Surface Resistance	< 1E5 ohm	< 1E5 ohm	ESD STM11.11
Static Decay MIL-PRF-81705D, 5kV to 50 V, 12% RH	< 2.00 s	< 2.00 s	FTMS101C 4046.1

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	360 - 425 °F	182 - 218 °C
Mold Temperature	175 - 225 °F	79 - 107 °C
Drying	2 hrs @ 250 °F	2 hrs @ 121 °C
Moisture Content	0.15 %	0.15 %
Dew Point	-25 °F	-32 °C

PROCESSING NOTES

Desiccant Type Dryer Required.