



**Product Data Sheet &
General Processing Conditions**

**PermaStat PLUS® 800
Acetal (POM)
Permanently Static Dissipative
ESD Protection**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.33	1.33	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0190 - 0.0270 in/in	1.90 - 2.70 %	D 955
MECHANICAL			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	2.5 ft-lbs/in	133 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	6000 psi	41 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.18 x 10 ⁶ psi	1241 MPa	D 638
Flexural Strength	6500 psi	45 MPa	D 790
Flexural Modulus	0.20 x 10 ⁶ psi	1379 MPa	D 790
ELECTRICAL			
Volume Resistivity	1E7 - 9.9E8 ohm.cm	1E7 - 9.9E8 ohm.cm	D 257
Surface Resistivity	1E8 - 9.9E9 ohm/sq	1E8 - 9.9E9 ohm/sq	D 257
Surface Resistance	1E7 - 9.9E8 ohm	1E7 - 9.9E8 ohm	ESD STM11.11
Static Decay	< 0.50 s	< 0.50 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	350 - 400 °F	177 - 204 °C
Mold Temperature	180 - 250 °F	82 - 121 °C
Drying	2 hrs @ 250 °F	2 hrs @ 121 °C
Moisture Content	0.15 %	0.15 %
Dew Point	-25 °F	-32 °C

PROCESSING NOTES

Do not exceed 520 °F (270 °C) melt temperature.
Desiccant Type Dryer Required.