

Chemical abbreviation according to ISO 1043-1: POM Molding compound 29988- POM-K, M-GNR, 03-002 POM copolymer Standard-Injection molding type with high rigidity, hardness and toughness; good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation. The products are in compliance with EU regulations (EC) No 1935/2004, (EC) No 2023/2006 and (EU) 10/2011, USA FDA 21 CFR Titles 174 – 199, and Chinese food contact regulations GB4806.1, GB31603 and GB9685.

Ranges of applications: automotive engineering, precision engineering, electric and electronical industry, domestic appliances.

### Product information

Part Marking Code	POM		ISO 11469
Rheological properties			
Melt volume-flow rate	-	cm <sup>3</sup> /10min	ISO 1133
Temperature	190		
Load	2.16	kg	
Typical mechanical properties			
Tensile Modulus	2700	MPa	ISO 527-1/-2
Yield stress, 50mm/min	64	MPa	ISO 527-1/-2
Yield strain, 50mm/min	10	%	ISO 527-1/-2
Nominal strain at break	30		ISO 527-1/-2
Charpy notched impact strength, 23°C	6	kJ/m²	ISO 179/1eA
Thermal properties			
Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
Other properties			
Density	1410	kg/m³	ISO 1183
Injection			
-	100 100	°C	
Drying Temperature Drying Time, Dehumidified Dryer	100 - 120 3 - 4		
Processing Moisture Content	0.15		
Screw tangential speed	0.2 - 0.21		
Max. mould temperature	80 - 120		
Back pressure		MPa	
Injection speed	slow-medium		
Characteristics			

### Additives

Release agent



Additional information	
,	Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.
	Melt temperature 190-210 °C Mould temperature 80-120 °C
Film extrusion	Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.
	Melt temperature 180-190 °C
Other extrusion	
	Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.
	Melt temperature 180-190 °C
Sheet extrusion	
	Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.
	Melt temperature 180-190 °C
Processing Texts	
Pre-drying	Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying may be necessary to prevent splay and odor problems.
Longer pre-drying times/storage	The product can then be stored in standard conditions until processed.
Injection molding	Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.
	Melt temperature 190-210 °C Mould temperature 80-120 °C



Injection molding Preprocessing



General drying is not necessary due to low moisture absorption of the resin.

In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120  $^{\circ}$ C / max. 40 mm layer / 3 to 6 hours) is recommended.

Max. Water content 0,2 %

Injection molding Postprocessing

Conditioning e.g. moisturizing is not necessary.

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