

Acetal copolymer resin natural medium fluidity and lubricated to improve injection and moulding process, is appropriate for any injection technical piece of general applications.

TECHNICAL DATA SHEET

		STANDARD	UNIT	DRY	CONDITIONED
GENERALS	Density	ISO 1183	gr/cm ³	1,41	
	Melt Flow Index	ISO 1133	gr/10 min.	~13	
	Humidity Pelets	ISO 1110	%	0,2	
	Hardness	SHORE D	Points	81	
	Mold Shrinkage	-	%	~2	

		STANDARD	UNIT	DRY	CONDITIONED
MECHANICAL	Tensile Strength	ISO 527	N/mm ²	63	
	Elongation at break	ISO 527	%	55	
	Tensile Modulus	ISO 527	N/mm ²	2800	
	Charpy Impact	23 °C ISO 179	Kj/m ²	72	
		-40 °C ISO 179	Kj/m ²	-	
	Charpy Impact	23 °C ISO 179	Kj/m ²	6	
-40 °C ISO 179		Kj/m ²	-		

		STANDARD	UNIT	DRY	CONDITIONED
ELECTRICAL	Surface Resistivity	IEC 93	Ohm	10 ¹⁶	
	Dielectric strength	IEC 243	Kv/mm	19	
	Tracking index (C.T.I.)	IEC 112	Kv/mm		

		STANDARD	UNIT	DRY	CONDITIONED
THERMAL	Deflection Temp. Under Load	0,4 N ISO 75/A	°C	160	
		(H.D.T.)	1,8 N ISO 75/A	°C	110
	VICAT Temperatura	ISO 306	°C	165	

- The values provided in this data sheet correspond to our knowledge. All products must be subjected to in company test by the user before application.
- These data do not release you from the obligation to test our products as to their suitability for the intended processes and final use.
- These data may not valid such material used in combination with any other materials or additives or in - any process.
- Triesa assumes no liability and makes no warranties of any kind, expressed or implied how to use this information data.
- UL measurements are done in our lab according to this norm.

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	STANDARD	UNIT	DRY	CONDITIONED
OTHERS	UL - Flammability	UL-94	-	HB
	Glow Wire	IEC 695	°C	-
	Fammability speed	FMV 302	mm/min.	<100
	Ashes	Triesa Test	%	-
	Water absorption (24h)	ISO 62	%	~0,2
	Lubricated			YES

RECOMMENDED VALUES

PROCESSING	Drying Material	2h - 4h 80-90°C
	Mold. Temperature	40°C-70°C
	Processing Temperature	180°C-200°C
	Back Temperature	170°C-185°C
	Middle Temperature	185°C-190°C
	Nozzle Temperature	190°C-205°C
	Hold Pressure	70 - 100 Mpa

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SOURCE: Triesa Quality Control; Last update: 15/05/2020