

Acetal homopolymer resin natural medium fluidity, lubricated, is a medium viscosity resin which combines good physical properties and good injection.

		STANDARD	UNIT	DRY	CONDITIONED
GENERALS	Density	ISO 1183	gr/cm ³	1,42	
	Melt Flow Index	ISO 1133	gr/10 min.	~14	
	Humidity Pelets	ISO 1110	%	0,2	
	Hardness	SHORE D	Points	83	
	Mold Shrinkage	-	%	~2	

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MECHANICAL	Tensile Strength	ISO 527	N/mm ²	70	
	Elongation at break	ISO 527	%	30	
	Tensile Modulus	ISO 527	N/mm ²	3000	
	Charpy Impact	23 °C ISO 179	Kj/m ²	NB	
		-40 °C ISO 179	Kj/m ²	-	
	Charpy Impact	23 °C ISO 179	Kj/m ²	8	
-40 °C ISO 179		Kj/m ²	-		

		STANDARD	UNIT	DRY	CONDITIONED
ELECTRICAL	Surface Resistivity	IEC 93	Ohm	10 ¹⁵	
	Dielectric strength	IEC 243	Kv/mm	32	
	Tracking index (C.T.I.)	IEC 112	Kv/mm		

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THERMAL	Deflection Temp. Under Load	0,4 N ISO 75/A	°C	165	
		(H.D.T.)	1,8 N ISO 75/A	°C	95
	VICAT Temperatura	ISO 306	°C	160	

- 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.

V3.00/2021

		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	%	~0,3	
	Lubricated			YES	

RECOMMENDED VALUES

PROCESSING	Drying Material	2h - 4h 80-90°C
	Mold. Temperature	70°C-90°C
	Processing Temperature	190°C-200°C
	Back Temperature	180°C-185°C
	Middle Temperature	190°C-195°C
	Nozzle Temperature	200°C-210°C
	Hold Pressure	70 - 100 Mpa

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