



Technical Data Sheet

Grade

MWR POM1115

Product Description:

Acetal Homopolymer Medium Flow

Physical Properties	Method	English	SI
Specific Gravity	D 792	-	1.420
Melt Flow Rate (190/2.16)	D 1238	-	15 g/10 minutes
Linear Mold Shrinkage (Typical)	D 955	0.020 in/in	0.020 mm/mm
Mechanical Properties	Method	English	SI
Tensile Strength at Yield	D 638	10000 psi	69.0 Mpa
Tensile Elongation at Yield	D 638	15.0 %	15.0 %
Flexural Modulus (Tangent)	D 790	430000 psi	2970 Mpa
Izod Impact (notched)	D 256	1.5 ft-lb/in	80 J/m
Hardness (Rockwell)	D 785	120 R	-
Thermal Properties	Method	English	SI
Heat Deflection Temperature at 66 psi	D 648	320 F	160 C
Heat Deflection Temperature at 264 psi	D 648	200 F	93 C
Processing (Injection Molding)		English	SI
Drying Temperature		175 F	79 C
Drying Time		3 hrs	3 hrs
Max Moisture Content		0.20 %	0.20 %
Rear Barrel Temperature		380 F	193 C
Middle Barrel Temperature		390 F	199 C
Front Barrel Temperature		400 F	204 C
Nozzle Temperature		400 F	204 C
Stock Temperature		410 F	210 C
Mold Temperature		180 F	82 C

Comments:

1. Mold temperatures as high as 180 °F can be used. Higher mold temperatures yield improved appearance.
2. Drying is not absolutely necessary but will improve appearance and processing.

Values shown are averages and not to be construed as specifications.

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