



Technical Data Sheet

Grade

MWR POM1200-02

Product Description:

Acetal Copolymer 9 Melt Black Recycled Grade

Physical Properties	Method	English	SI
Specific Gravity	D 792	-	1.410
Melt Flow Rate (190/2.16)	D 1238	-	9.0 g/10 minutes
Melt Point	D 789	329 F	165 C
Linear Mold Shrinkage (Typical)	D 955	0.022 in/in	0.022 mm/mm

Mechanical Properties	Method	English	SI
Tensile Strength at Yield	D 638	8500 psi	58.62 Mpa
Tensile Elongation at Yield	D 638	10.0 %	10.0 %
Flexural Modulus (Tangent)	D 790	370000 psi	2550 Mpa

Thermal Properties	Method	English	SI
Heat Deflection Temperature at 66 psi	D 648	316 F	158 C
Heat Deflection Temperature at 264 psi	D 648	214 F	101 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	120 F	49 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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