

SCHULAFORM® 9 A TF 20

Acetal (POM) Copolymer
Engineering Plastics

Product Description

20% PTFE modified POM

General

Filler / Reinforcement	• PTFE Fiber, 20% Filler by Weight
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.51 g/cm³	1.51 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	10 cm³/10min	10 cm³/10min	ISO 1133
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	334000 psi	2300 MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	6670 psi	46.0 MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	7.0 %	7.0 %	ISO 527-2/1A/50
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			
-22°F (-30°C)	1.4 ft·lb/in²	3.0 kJ/m²	ISO 179/1A
73°F (23°C)	1.9 ft·lb/in²	4.0 kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			
-22°F (-30°C)	26 ft·lb/in²	55 kJ/m²	ISO 179/1U
73°F (23°C)	28 ft·lb/in²	58 kJ/m²	ISO 179/1eU
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	284 °F	140 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	205 °F	96.0 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	324 °F	162 °C	ISO 306/A50
--	288 °F	142 °C	ISO 306/B50
Electrical	Nominal Value (English)	Nominal Value (SI)	Test Method
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1
Comparative Tracking Index	600 V	600 V	IEC 60112
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 in (2.00 mm)	1.9 in/min	48 mm/min	ISO 3795
0.0787 in (2.00 mm)	1.9 in/min	48 mm/min	FMVSS 302
Flame Rating			UL 94
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	
Glow Wire Flammability Index			IEC 60695-2-12
0.06 in (1.5 mm)	1110 °F	600 °C	
0.12 in (3.0 mm)	1110 °F	600 °C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.06 in (1.5 mm)	1160 °F	625 °C	
0.12 in (3.0 mm)	1160 °F	625 °C	

Technical Data Sheet

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	212 °F	100 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	374 to 428 °F	190 to 220 °C
Mold Temperature	140 to 248 °F	60 to 120 °C

Notes

These are typical property values not to be construed as specification limits.