



Edgetek™ AT-15GF/000 BLACK

Acetal (POM) Copolymer

Key Characteristics

General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.50	1.50	ASTM D792
Molding Shrinkage - Flow	7.0E-3 to 0.013 in/in	0.70 to 1.3 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	9860 psi	68.0 MPa	ASTM D638
Tensile Elongation ² (Break)	3.0 %	3.0 %	ASTM D638
Flexural Modulus ³	754000 psi	5200 MPa	ASTM D790
Flexural Strength ³	16000 psi	110 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm)	0.94 ft·lb/in	50 J/m	
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	275 °F	135 °C	
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	1.0E+15 ohms	1.0E+15 ohms	ASTM D257
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.06 in (1.6 mm))	HB	HB	UL 94

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	194 to 212 °F	90.0 to 100 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Rear Temperature	338 to 410 °F	170 to 210 °C
Middle Temperature	338 to 410 °F	170 to 210 °C
Front Temperature	338 to 410 °F	170 to 210 °C
Mold Temperature	140 to 176 °F	60.0 to 80.0 °C

Injection Notes
Injection Pressure: MED-HIGH
Hold Pressure: MED-HIGH
Screw Speed: MODERATE
Back Pressure: LOW

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Notes¹ Typical values are not to be construed as specifications.² 0.20 in/min (5.0 mm/min)³ 0.051 in/min (1.3 mm/min)**CONTACT INFORMATION****Americas**United States - Avon Lake
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