



# Edgetek™ AT-25CF/000 BK001

## Acetal (POM) Copolymer

### Key Characteristics

Product Description	
25% carbon fiber filled POM compound	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Carbon Fiber, 25% Filler by Weight
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

### Technical Properties <sup>1</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.46	1.46	ASTM D792
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength <sup>2</sup>	8270 psi	57.0 MPa	ASTM D638
Flexural Modulus <sup>3</sup>	2.12E+6 psi	14600 MPa	ASTM D790
Flexural Strength <sup>3</sup>	10900 psi	75.0 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)	1.0 ft-lb/in	55 J/m	
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	1.0 to 1.0E+3 ohms	1.0 to 1.0E+3 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	176 to 194 °F	80.0 to 90.0 °C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Rear Temperature	356 to 410 °F	180 to 210 °C
Middle Temperature	356 to 410 °F	180 to 210 °C
Front Temperature	356 to 410 °F	180 to 210 °C
Mold Temperature	104 to 194 °F	40.0 to 90.0 °C

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

### Notes

<sup>1</sup> Typical values are not to be construed as specifications.

<sup>2</sup> 0.20 in/min (5.0 mm/min)

<sup>3</sup> 0.051 in/min (1.3 mm/min)

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