



Edgetek™ AT-30GF/000 BK004

Acetal (POM) Copolymer

Key Characteristics

| General | |
|------------------------|-------------------------------------|
| Material Status | • Commercial: Active |
| Regional Availability | • Asia Pacific |
| Filler / Reinforcement | • Glass Fiber, 30% Filler by Weight |
| Appearance | • Black |
| Processing Method | • Injection Molding |

Technical Properties ¹

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|---|-------------------------|--------------------|-------------|
| Specific Gravity | 1.62 | 1.62 | ASTM D792 |
| Molding Shrinkage - Flow | 4.0E-3 to 0.010 in/in | 0.40 to 1.0 % | ASTM D955 |
| Mechanical | Typical Value (English) | Typical Value (SI) | Test Method |
| Tensile Strength ² | 14500 psi | 100 MPa | ASTM D638 |
| Flexural Modulus ³ | 1.07E+6 psi | 7350 MPa | ASTM D790 |
| Flexural Strength ³ | 23200 psi | 160 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) | 0.84 ft·lb/in | 45 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) | 320 °F | 160 °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 | 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 | 374 to 392 °F | 190 to 200 °C |
| Middle Temperature | 374 to 392 °F | 190 to 200 °C |
| Front Temperature | 374 to 392 °F | 190 to 200 °C |
| Mold Temperature | 167 to 185 °F | 75.0 to 85.0 °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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