



## Edgetek™ AT-20GB/000 BK017

Acetal (POM) Copolymer

### Key Characteristics

| General                |                                    |
|------------------------|------------------------------------|
| Material Status        | • Commercial: Active               |
| Regional Availability  | • Asia Pacific                     |
| Filler / Reinforcement | • Glass Bead, 20% Filler by Weight |
| Appearance             | • Black                            |
| Processing Method      | • Injection Molding                |

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

| Physical                                                                               | Typical Value (English) | Typical Value (SI) | Test Method |
|----------------------------------------------------------------------------------------|-------------------------|--------------------|-------------|
| Density / Specific Gravity                                                             | 1.53                    | 1.53               | ASTM D792   |
| Molding Shrinkage - Flow                                                               | 0.014 to 0.018 in/in    | 1.4 to 1.8 %       | ASTM D955   |
| Mechanical                                                                             | Typical Value (English) | Typical Value (SI) | Test Method |
| Tensile Strength <sup>2</sup>                                                          | 6530 psi                | 45.0 MPa           | ASTM D638   |
| Flexural Modulus <sup>3</sup>                                                          | 370000 psi              | 2550 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<br>73°F (23°C), 0.126 in (3.20 mm)                                 | 0.81 ft·lb/in           | 43 J/m             | ASTM D256   |
| Thermal                                                                                | Typical Value (English) | Typical Value (SI) | Test Method |
| Deflection Temperature Under Load<br>264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm) | 214 °F                  | 101 °C             | ASTM D648   |
| 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 to 90 °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 to 85 °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.

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

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



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