



## 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 <sup>1</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / 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 <sup>2</sup>	9860 psi	68.0 MPa	ASTM D638
Tensile Elongation <sup>2</sup> (Break)	3.0 %	3.0 %	ASTM D638
Flexural Modulus <sup>3</sup>	754000 psi	5200 MPa	ASTM D790
Flexural Strength <sup>3</sup>	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 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 to 80 °C

#### Injection Notes

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

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## 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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