



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 ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.46	1.46	ASTM D792
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	8270 psi	57.0 MPa	ASTM D638
Flexural Modulus ³	2.12E+6 psi	14600 MPa	ASTM D790
Flexural Strength ³	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 to 90 °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 to 90 °C

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

Notes

¹ 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)

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