



# Edgetek™ AT-25GB/000 NATURAL

## Acetal (POM) Copolymer

### Key Characteristics

General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Bead, 25% Filler by Weight
Appearance	• Natural Color
Processing Method	• Injection Molding

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

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.59	1.59	ASTM D792
Molding Shrinkage - Flow	0.013 to 0.018 in/in	1.3 to 1.8 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength <sup>2</sup>	5220 psi	36.0 MPa	ASTM D638
Flexural Modulus <sup>3</sup>	377000 psi	2600 MPa	ASTM D790
Flexural Strength <sup>3</sup>	8990 psi	62.0 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)	0.73 ft·lb/in	39 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)	223 °F	106 °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 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

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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)**CONTACT INFORMATION****Americas**United States - Avon Lake  
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