



Polyacetal Resin

				Reinforced/Filled			
Properties	Test Method	Terms	Units	FG2025	MF3020	FB2025	FC2020D
				Glassfiber Reinforced	Milledfiber Reinforced	Glassbead Filled	Electro-Conductive
				Glassfiber	Milledfiber	-	Carbonfiber
				25%	20%	-	20%
Physical properties							
Density	ISO 1183	-	g/cm³	1.59	1.55	1.59	1.46
Water absorption	-	23degC, 60%RH	%	0.20	0.20	0.20	0.36
Rheological properties							
Melt Mass-flow Rate	ISO 1133	Temperature Load	g/10min	9.0	20	5.0	3.5
Melt Volume-flow Rate			cm³/10min	6.3	15	3.8	3.2
			degC	190	190	190	190
			kg	2.16	2.16	2.16	2.16
Moulding shrinkage (3mmt)	-	MD TD	%	0.6 -	1.7 -	1.6 -	0.4 -
Mechanical properties							
Tensile modulus	ISO 527-1 , 527-2	-	MPa	10000	4500	4000	17000
Yield stress			-	-	-	-	
Yield strain			%	-	-	-	-
Nominal strain at break			-	-	-	-	-
Stress at break			MPa	140	60	60	130
Strain at break		%	3.0	4.0	6.0	1.5	
Flexural strength	ISO 178	-	MPa	210	100	100	200
Flexural modulus				9100	3900	3700	16000
Charpy impact strength	ISO 179-1 , 179-2	23 degC	kJ/m²	60	40	60	-
Charpy notched impact strength		23 degC	kJ/m²	9.0	4.0	4.0	-
Thermal properties							
Melting temperature	ISO 11357-3		degC	166	166	166	166
Temperature of deflection under load	ISO 75-1 , 75-2	1.80MPa 0.45MPa	degC	162 164	118 160	115 158	162 164
Coefficient of Linear thermal expansion	ISO 11359-2	MD TD	1/degC	3.0E-05 1.1E-04	- -	- -	- -
Flammability	UL94	0.8mmt	-	HB	HB	HB	HB
Electrical properties							
Relative permittivity	IEC 60250	100Hz 1MHz	- -	4.1 4.1	- -	- -	- -
Dissipation factor	IEC 60250	100Hz 1MHz	- -	0.003 0.008	- -	- -	- -
Volume resistivity	IEC 60093	-	ohm-m	1.E+12	-	-	2.E+00
Surface resistivity	IEC 60093	-	ohm	1.E+16	-	-	2.E+02
Electric strength	IEC 60243-1	1mmt 3mmt	MV/m	25 16	- -	- -	- -
Comparative tracking index	IEC 60112	-	-	600	-	-	-

The listed properties are portrayed as general information only and are not product specifications.

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