



Ultraform® H 2320 006 AT

BASF Corporation - Acetal (POM) Copolymer

Saturday, November 2, 2019

General Information

Product Description

Ultraform H 2320 006 AT is a POM with high molecular weight grade for injection molding.

Typical applications include thick-walled articles.

General

Material Status	• Commercial: Active
Availability	• North America
Features	• High Molecular Weight
Uses	• Thick-walled Parts
Agency Ratings	• EC 1907/2006 (REACH)
RoHS Compliance	• RoHS Compliant
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	2.90	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	2.1	%	
Flow	2.1	%	
Water Absorption (Saturation, 73°F)	0.90	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	377000	psi	ISO 527-2
Tensile Stress (Yield, 73°F)	8990	psi	ISO 527-2
Tensile Strain (Yield, 73°F)	11	%	ISO 527-2
Nominal Tensile Strain at Break (73°F)	30	%	ISO 527-2
Tensile Creep Modulus (1000 hr)	189000	psi	ISO 899-1
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-22°F	2.6	ft·lb/in ²	
73°F	3.1	ft·lb/in ²	
Charpy Unnotched Impact Strength			ISO 179
-22°F	95	ft·lb/in ²	
73°F	120	ft·lb/in ²	
Notched Izod Impact Strength			ISO 180
-22°F	3.3	ft·lb/in ²	
73°F	3.1	ft·lb/in ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	203	°F	ISO 75-2/A
Melting Temperature (DSC)	329	°F	ISO 3146
CLTE - Flow (73 to 131°F)	6.7E-5	in/in/°F	ISO 11359-2

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Thermal	Nominal Value	Unit	Test Method
RTI Elec			UL 746
0.030 in	221	°F	
0.06 in	221	°F	
0.12 in	221	°F	
RTI Imp			UL 746
0.06 in	194	°F	
0.12 in	194	°F	
RTI Str			UL 746
0.06 in	194	°F	
0.12 in	221	°F	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+13	ohms·cm	IEC 60093
Dielectric Constant (1 MHz)	3.80		IEC 60250
Dissipation Factor (1 MHz)	5.0E-3		IEC 60250
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flammability Classification			IEC 60695-11-10, -20
0.030 in	HB		
0.06 in	HB		
0.12 in	HB		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176 to 230	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.15	%
Processing (Melt) Temp	374 to 446	°F
Mold Temperature	140 to 248	°F
Injection Pressure	508 to 1020	psi

Notes

¹ Typical properties: these are not to be construed as specifications.