WEROFORM® POM C9021 UNV RC SW

WEROFORM®
Engineering compounds

Polyacetal-copolymer
unreinforced, black

Physical properties		Test method	Specimen	Units	Typical value
Specific gravity		ISO 1183-3		g/cm³	1,41
Water absorption	23°C / 24h	ISO 62	MPTS ISO 3167 A	%	<0,1
Mechanical properties at 23°C / 50% rh					
Tensile strength	dry, @50 mm/min	ISO 527	MPTS ISO 3167 A	MPa	55
Elongation at maximum force	dry, @50 mm/min	ISO 527	MPTS ISO 3167 A	%	10
Modulus of elasticity	dry, @1 mm/min	ISO 527	MPTS ISO 3167 A	GPa	2,5
Charpy impact strength	dry	ISO 179 1eU	80x10x4mm	kJ/m²	60
Charpy impact strength	dry		80x10x4mm	kJ/m²	60
Charpy impact strength, notched	dry	ISO 179 1eA	80x10x4mm	kJ/m²	4,5

Main features

Reduced moment of inertia compared with metal parts.

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Recommended processing parameters

General		
Avoid melt temperature above 215°C! Ventilation of machinery is recommended.		
Predrying		
It is advisable to predry the granulate with a suitable dryer immediately before processing. The granulate may absorb moisture from the environment.		
Dryer type	Temperature °C	Drying time in h
Dehumidifying dryer	75	2 - 8
Air-Circulation Dryer	120	2 - 4
Processing		
Zone 1	°C	175 - 190
Zone 2	°C	185 - 205
Zone 3	°C	180 - 200
Nozzle	°C	175 - 200
Mold	°C	80 - 120
Melt temperature	°C	200
In general this product can be processed on conventional injection moulding machines while observing the usual technical guidelines. Any added fibrous materials or fillers may have an abrasive effect. In this case the cylinder and screw should be protected against wear as is usual in the processing of reinforced thermoplastic materials. Lengthy dwell times for the melts in the cylinder should be avoided. Lower the temperatures during interruptions!		
Delivery form & storage		
Unless indicated otherwise, the material is delivered as 3mm long pellets in sealed bags on pallets. Preferably storage should be effected in dry and normally temperatured rooms.		
Additional information		
If originally sealed containers are used, it is normally possible to omit the predrying stage. If PTFE containing materials are not predried, an increase in deposits inside the mould may occur. The processing notes provided merely represent a recommendation for general use. Due to the large variety of machines, geometries and volumes of parts, etc., it may be necessary to employ different settings according to the specific application. Please contact us for further information.		

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