

HM270

Polyoxymethylene-POM

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Description	Application
◆ Injection molding grade	◆ Electronics & Electrical
◆ Good flowability	◆ Automotive

Physical	Method	Condition	Unit	Typical Value
Specific Gravity	ISO 1183	23°C	g/cm ³	1.41
Melt Index	ISO 1133	190°C, 2.16kg	g/10min	27
Molding Shrinkage	ISO 294-4	23°C, 24hr	%	1.8-2.2
Mechanical				
Tensile Strength	ISO 527-2	50mm/min	MPa	62
Tensile Elongation	ISO 527-2	50mm/min	%	25
Flexural Strength	ISO 178	2mm/min	MPa	86
Flexural Modulus	ISO 178	2mm/min	MPa	2455
Charpy impact strength	ISO 179/1eA	Notched, 23°C	kJ/m ²	5
Thermal				
HDT	ISO 75-2	1.8MPa, Unannealed	°C	93
Other				
Flammability	UL94	3.0mm	class	HB
Processing Parameter				
Pre-Dry	80~90°C, 3~4 hr			
Cylinder Temperature-Rear	160~180°C			
Cylinder Temperature-Middle	170~200°C			
Cylinder Temperature-Front	190~210°C			
Mold Temperature	60~90°C			
Back Pressure	< 4MPa			

NOTE:

- [1] Typical values are only for material selection purpose, should not be interpreted as specification.
- [2] Pigments can affect properties. Different color may have different properties.
- [3] The process parameters are for reference only. The above process can be adjusted properly according to different models and product requirements.

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