

#### Product description

Emission optimized, rapidly solidifying copolymeric polyacetal for injection molding. Contains a mold release agent.

Abbreviated designation according to ISO 1043-1: POM  
Designation according to ISO 9988-1: POM-K, M-GNR, 05-002

#### Processing

This formulation was developed to achieve low emission and smell. It can be processed on usual injection molding machines. Significant advantages of the kind described over conventional polyacetals could be proven in many cases, cannot be guaranteed, however, due to the large number of parameters that may be of influence.

In order to obtain best emission performance it is recommended to process at comparatively low melt temperatures and to avoid high screw speed, high shear and long cycle times. Additional information is available upon request.

General processing information is available from the Ultraform brochure and the product safety data sheet.

#### Physical form and storage

Ultraform® is supplied in the form of granules having a bulk density of approx. 850 g/l. Standards packs are the 25 kg PE bag and the 1000 kg Oktabin (octagonal container). Ultraform® is not subject to change when it is stored in dry, ventilated rooms. After relatively long storage (>1 year) or when handling material from previously opened containers, preliminary drying is recommended in order to remove any moisture which has been absorbed.

#### Product safety

Ultraform® is not a hazardous material as defined in the German Ordinance on Hazardous Materials.

If Ultraform® is processed properly little or no formaldehyde occurs in the region of the processing machine. Measures should be taken to ensure ventilation and venting of the work area, preferably by means of an extraction hood over the barrel unit.

Ultraform® decomposes when subjected to excessive heat. The decomposition products formed in this case consist almost exclusively of formaldehyde, a gas which has a pungent smell even at very low concentrations and irritates the mucous membranes. Decomposition can rapidly result in the build-up of a high gas pressure in the barrel of the processing unit. If the die is sealed there may be a sudden release of pressure via the filling hopper.

Contamination of Ultraform® by thermoplastics that cause decomposition of polyacetals, e.g. PVC or plastics containing halogenated fire protection agents, must be avoided under all circumstances. Even small quantities can cause uncontrolled and rapid decomposition of Ultraform® during processing.

Pellets and finished parts must not be allowed to come into contact with strong acids (especially concentrated hydrochloric acid) since they cause Ultraform® to decompose.

Detailed safety and environmental information is contained in the Ultraform® brochure and the material safety data sheet. Both are available from the PlasticsPortal, [www.plasticsportal.net](http://www.plasticsportal.net), or the Ultra-Infopoint under phone +49-621-60-78780 or fax +49-621-60-78730.

#### Note

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed. In order to check the availability of products please contact us or our sales agency.

Typical values for uncoloured product at 23 °C <sup>1)</sup>	Test method <sup>2)</sup>	Unit	Values <sup>3)</sup>
<b>Properties</b>			
Polymer abbreviation	-	-	<b>POM</b>
Density	ISO 1183	kg/m <sup>3</sup>	<b>1400</b>
Water absorption, equilibrium in water at 23°C	similar to ISO 62	%	<b>0.8</b>
Moisture absorption, equilibrium 23°C/50% r.h.	similar to ISO 62	%	<b>0.2</b>
<b>Processing</b>			
Processing: Injection moulding (M), Extrusion (E), Blow moulding (B)	-	-	<b>M</b>
Melting temperature, DSC	ISO 11357-1/-3	°C	<b>166</b>
Melt volume-flow rate MVR at 190 °C and 2.16 kg	ISO 1133	cm <sup>3</sup> /10min	<b>25</b>
Melt temperature, injection moulding	-	°C	<b>190 - 220</b>
Mould temperature, injection moulding	-	°C	<b>60 - 100</b>
<b>Flammability</b>			
UL94 rating at 1,6 mm thickness	UL-94	class	<b>HB</b>
Automotive materials (thickness d >= 1mm)	-	-	<b>+</b>
<b>Mechanical properties</b>			
Tensile modulus	ISO 527-1/-2	MPa	<b>2700</b>
Yield stress, 50 mm/min	ISO 527-1/-2	MPa	<b>62</b>
Yield strain, 50 mm/min	ISO 527-1/-2	%	<b>9</b>
Nominal strain at break, 50 mm/min	ISO 527-1/-2	%	<b>25</b>
Charpy unnotched impact strength (23°C)	ISO 179/1eU	kJ/m <sup>2</sup>	<b>150</b>
Charpy notched impact strength (23°C)	ISO 179/1eA	kJ/m <sup>2</sup>	<b>5</b>
<b>Thermal properties</b>			
HDT A (1.80 MPa)	ISO 75-1/-2	°C	<b>90</b>
Max. service temperature (short cycle operation)	-	°C	<b>100</b>
Coefficient of linear thermal expansion, longitudinal (23-55)°C	ISO 11359-1/-2	E-4/°C	<b>1.5</b>
<b>Electrical properties</b>			
Relative permittivity (1 MHz)	IEC 60250	-	<b>3.8</b>
Dissipation factor (1 MHz)	IEC 60250	E-4	<b>50</b>
Volume resistivity	IEC 60093	Ohm*m	<b>1E13</b>
Surface resistivity	IEC 60093	Ohm	<b>1E13</b>
Comparative tracking index, CTI, test liquid A	IEC 60112	-	<b>600</b>

## Footnotes

1) If product name or properties don't state otherwise.

2) Specimens according to CAMPUS.

3) The asterisk symbol "\*" signifies inapplicable properties.