

ACETAL COPOLYMER AC90

AC90 is an acetal copolymer with a viscosity suitable for general purpose injection molding applications; it is internally lubricated for ease of mold release.

Acetal copolymer is a highly crystalline engineering thermoplastic based on trioxane, polymerized with a comonomer to provide exceptional thermal stability both in processing and for molded parts which may be exposed to high temperature environments.

AC90 exhibits the characteristics of a true engineering material: predictability of performance in a wide range of environments and for long periods of time. Performance characteristics combine excellent strength, rigidity and toughness, a unique resilience, outstanding static and dynamic fatigue resistance, natural lubricity and resistance to a very wide range of solvents, oils, greases and chemicals, including strong alkalis. Extremely low moisture absorption results in excellent dimensional stability, and therefore an ability to hold precision tolerances in parts exposed to a wide range of humidity.

Versatility and reliability make **AC90** the cost-effective material of choice for a wide range of applications in all major end-use categories.

<u>PROPERTY</u>	<u>TYPICAL PROPERTIES</u>				<u>S.I.</u>	<u>VALUE</u>
	<u>ASTM</u> <u>TEST METHOD</u>	<u>ENGLISH</u> <u>UNITS</u>	<u>VALUE</u>	<u>UNITS</u>		
Melting Range	D789	°F	320-329	°C	160-165	
Specific Gravity	D792	-	1.41	-	1.41	
Water Absorption (24 hours immersion)	D570	%	0.16	%	0.16	
Heat Deflection Temperature at 264 lbs/in ² (1.82 MPa)	D648	°F	230	°C	136	
Mold Shrinkage Guideline* (Flow / Transverse Direction)	1/8" section	%	2.5 / 1.8	%	2.5 / 1.8	
Tensile Strength at Yield	D638	lbs/in ²	9,400	MPa	65	
Elongation, at Break	D638	%	35-45	%	35-45	
Flexural Strength	D790	lbs/in ²	13,250	MPa	91	
Flexural Modulus	D790	lbs/in ²	360,000	MPa	2,483	
Izod Impact Strength (Notched, 1/8" specimen)	D256	ft. lbs/in of notch	1.4	J/m	75	
Tensile Impact Strength (Type S specimen)	D1822	lbs/in ²	60	kJ/m ²	126	
Rockwell Hardness	D785	M scale	M80	-	-	

*** Please review shrinkage projections for specific applications with an MDE Technical Representative.**

All data generated using test specimens injection molded from natural color material. Inclusion of color pigments or other additives may change some or all of these test results. Tests are conducted at 23°C and 50% relative humidity unless otherwise stated.

These mechanical property test data have been developed using injection molded specimens tested under standardized conditions; furthermore, many of the mechanical properties of thermoplastic materials can be influenced by changes in processing conditions, environmental factors such as temperature and humidity, and rate of application of stress. Therefore, these test results, which characterize typical production material, should not be used either to establish specification limits or alone as the basis for engineering design.

AC90

Processing Guidelines

Pre-heating

Although acetal copolymer resins and compounds do not normally require to be dried before processing, drying is suggested if due to storage or weather conditions, moisture may have condensed on the surface of the pellets. Drying conditions would typically combine a material temperature of 170-190°F with a drying time of 1-2 hours in an air circulating or de-humidifying dryer.

Temperature Guidelines

The following temperature guidelines are suggested for general use **if a machine can be selected where shot size is 40-70% of nominal machine capacity.**

<u>Tool Surface Temperature (°F)</u>	<u>Melt Temperatures (°F)</u>			<u>Typical Cylinder Temperatures (°F)</u>		
	<u>Max.</u>	<u>Preferred</u>	<u>Min.</u>	<u>Front</u>	<u>Center</u>	<u>Rear</u>
180-240	420	380-400	350	390	380	370

- A mold surface temperature in the range of 180-200°F can significantly improve surface appearance, helps consistency of mold fill and therefore consistency of dimensions, minimizes the effect of weld lines and will realize best molded part performance.
- Mold cavity temperatures in the range of 200-240°F are suggested for precision molding, or to achieve exceptional surface appearance. Temperatures at these levels can normally be achieved by conventional mold heaters, using water, provided the water supply is at a minimum of 30 p.s.i. gauge. Extreme care is required, however, to minimize the risk of water line breakage - the use of appropriately rated flexible hose and fittings is a mandatory safety precaution.

Injection Speed

Optimum injection speed is dependent on part geometry, gate location and size, and the melt temperature. To achieve good surface appearance, injection speeds should be high enough to ensure that the cavity is filled before the resin starts to solidify. With thin section parts, high injection speeds are usually required to fill the cavity before the melt freezes. Local surface flaws such as jetting and gate blush can be minimized by careful adjustments of injection speed. For some components, a very slow injection speed combined with a high molding tool temperature can minimize such flaws and produce excellent surface appearance.

Gate Size

Experience has shown that for conventionally gated cavities, a generous gate size assists the production of parts of not only best performance, but also optimum surface appearance. A land-length maximum of 0.040 inches also helps to minimize injection pressure losses. As a guide, gate area should be at least 50% of the cross-sectional area of the part next to the gate. Multi-cavity tools for smaller thin wall parts have been very successfully pin or sub-gated.

Screw Forward Time

Adequate screw forward time under follow-up pressure is critical to ensure proper packing before gate freeze, during which time it is essential to maintain a "cushion" of 1/8" - 1/4". Optimum screw forward time can be judged by a part weight vs. forward time plot. Avoid overpacking, which can generate molded-in stresses.

Screw Recovery

It is recommended that back pressure of about 50 p.s.i. gauge be applied to the screw to help development of a homogeneous melt, and to ensure consistent shot volume. Screw rotation should also be as slow as possible consistent with cycle time goals, usually 40-80 r.p.m.

Mold Shrinkage

Standard ASTM test specimens are used to develop shrinkage guidelines. Test specimens are end-gated, 1/8 inch thickness, and molded at conditions recommended for this formulation. **Actual shrinkage in molded parts will depend on several variables, including processing conditions, part configuration and gate location, both of which influence material flow direction, and wall section thickness.**