# YUNCON® M350

**Acetal (POM) Copolymer**

云南云天化股份有限公司
YUNNAN YUNTIANHUA CO., LTD

| General | | | |
|---|---|---|---|
| Material Status | • Superhigh-flow grad, with mininized mold deposit | | |
| Features | • Acid Resistant | • Good Abrasion Resistance | • High Hardness |
| | • Bacteria Resistant | • Good Chemical Resistance | • Low Warpage |
| | • Solvent Resistant | • Good Dimensional Stability | • Low Friction |
| | • Fatigue Resistant | • Good Electrical Properties | • Super high Flow |
| Uses | •Lighters | • aerosol bottles | • fasteners |
| Forms | • Pellets | | |
| Processing Method | • Injection Molding | | |

| Physical properties | Value | Unit | Test Standard |
|---|---|---|---|
| Density | 1.41 | $g/cm^3$ | ISO 1183 |
| Melt Mass-Flow Rate (MFR) (190℃/2.16Kg) | 35 | g/10min | ISO 1133 |
| Water Absorption (24 hr, 23℃) | 0.5 | % | ISO 62 |
| **Mechanical properties** | **Value** | **Unit** | **Test Standard** |
| Tensile Stress at yield | 62 | MPa | ISO 527-2 |
| Tensile modulus | 2700 | MPa | ISO 527-2 |
| Strain at break | 20 | % | ISO 527-2 |
| Flexural strength | 89 | MPa | ISO 178 |
| Flexural modulus | 2600 | MPa | ISO 178 |
| Charpy notched impact strength | 4.0 | $KJ/m^2$ | ISO 179/1eA |
| **Thermal properties** | **Value** | **Unit** | **Test Standard** |
| Heat Deflection Temperature 1.8Mpa, Unannealed | 98 | ℃ | ISO 75 |
| **Flammability properties** | **Value** | **Unit** | **Test Standard** |
| Flame Rating-UL | HB | class | UL94 |

Notes to users

Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural materal. These values alone do not represent a sufficient basis for any part design and are not intended for use in establing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data valuse.

## Recommended Injection Molding Conditions

- Material Drying : 80 – 90℃, 3-4 hours
- Cylinder Temperature:

  Nozzle : 180 - 210 (℃)

  Front Section : 190 – 210 (℃)

  Center Section : 170 – 200 (℃)

  Rear Section : 160 – 180 (℃)
- Melt Temperature : 180 – 210 (℃)
- Mold Temperature : 60 – 90 (℃)

  (Precision parts are often molede at a mold at a mold temperature as high as 120℃)
- Pressure :

  Injection Pressure : 50 – 100 Mpa

  Holding Pressure : 30 – 80 Mpa

  Back Pressure : 0 – 0.5 MPa
- Screw Rotational Speed : 50 – 120 rpm

## Acquired Certifications of Yuntianhua POM

| | | |
|---|---|---|
| • RoHS test | • PFOS test | • Halogen element test |
| • SVHC test | • DMF test | • EN1186btest |
| • DBT&TBT test | • EN71-3 test | • Certification W18 test |
| • Certification FDA | • Certification UL | • Certification NSF |

For details, please contact Yuntianhua technicians.

## Contact information

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