Tenac™-C Z4520

Acetal (POM) Copolymer

Asahi Kasei Plastics North America Inc.

General	
Material Status	• Commercial: Active
Availability	• North America
Forms	• Pellets

Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR)	9.3	g/10 min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	2.5	%	
Flow	2.2	%	

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2600	MPa	ISO 527-2
Tensile Stress (Yield)	64.0	MPa	ISO 527-2
Tensile Strain (Break)	34	%	ISO 527-2
Flexural Modulus	2500	MPa	ISO 178
Flexural Strength	85.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	5.80	kJ/m²	ISO 179

Additional Information

The values shown for Molding Shrinkage, ISO 294-4, were tested in accordance with Asahi test methods.

Injection	Nominal Value	Unit
Drying Temperature	82.2	°C
Drying Time	3.0 to 4.0	hr
Rear Temperature	180 to 190	°C
Middle Temperature	190 to 200	°C
Front Temperature	200 to 210	°C
Nozzle Temperature	200 to 210	°C
Mold Temperature	48.9	°C
Injection Pressure	75.8 to 138	MPa
Holding Pressure	75.8 to 138	MPa
Back Pressure	0.345	MPa
Screw Speed	20 to 100	rpm
Screw Compression Ratio	3.0:1.0 to 4.5:1.0	

Injection Notes

Mold Temperature: > 120°F
Injection Speed: 1-5 Seconds
Drying Conditions: Usually not necessary
Cooling Time: Short
Screw Type: General
Slightly longer cycle times may be required to mold wall thicknesses over 1/4 inch.
Slightly higher injection pressures and mold temperatures may be required to mold wall thicknesses below 0.100 inches.

Notes

[1] Typical properties: these are not to be construed as specifications.

Revision History
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