



**Product Data Sheet &
General Processing Conditions**

**ZOVGOV® M23M2
Acetal (POM)
Mineral**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

| PERMANENCE | English | SI Metric | ASTM TEST |
|--|-----------------------|------------------|------------------|
| Primary Additive | 10 % | 10 % | |
| Specific Gravity | 1.47 | 1.47 | D 792 |
| Molding Shrinkage 1/8 in (3.2 mm) section | 0.0200 - 0.0300 in/in | 2.00 - 3.00 % | D 955 |

MECHANICAL

| | | | |
|--|----------------------------|----------|--------|
| Impact Strength, Izod notched 1/8 in (3.2 mm) section | 1.2 ft-lbs/in | 64 J/m | D 256 |
| unnotched 1/8 in (3.2 mm) section | 18.0 ft-lbs/in | 961 J/m | D 4812 |
| Tensile Strength | 7500 psi | 52 MPa | D 638 |
| Tensile Elongation | > 10.0 % | > 10.0 % | D 638 |
| Tensile Modulus | 0.45 x 10 ⁶ psi | 3103 MPa | D 638 |
| Flexural Strength | 11000 psi | 76 MPa | D 790 |
| Flexural Modulus | 0.40 x 10 ⁶ psi | 2758 MPa | D 790 |

ELECTRICAL

| | | | |
|--------------------|---------------|---------------|-------|
| Volume Resistivity | > 1E14 ohm.cm | > 1E14 ohm.cm | D 257 |
|--------------------|---------------|---------------|-------|

THERMAL

| | | | |
|--|--------------|-------------|-------|
| Deflection Temperature @ 264 psi (1820 kPa) | 240 °F | 116 °C | D 648 |
| Ignition Resistance* Flammability** | HB @ 1/16 in | HB @ 1.5 mm | D 635 |

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

** Values per MOLAN Company testing.

GENERAL PROCESSING FOR INJECTION MOLDING

| | English | SI Metric |
|--------------------|-------------------|------------------|
| Injection Pressure | 10000 - 15000 psi | 69 - 103 MPa |
| Melt Temperature | 360 - 425 °F | 182 - 218 °C |
| Mold Temperature | 175 - 225 °F | 79 - 107 °C |
| Drying | 2 hrs @ 250 °F | 2 hrs @ 121 °C |
| Moisture Content | 0.15 % | 0.15 % |
| Dew Point | -25 °F | -32 °C |

PROCESSING NOTES

Desiccant Type Dryer Required.