

ISOFORM® - POM

Structure	Semicrystalline
Density	1.41 g/cm ³ (unfilled)
General properties	Hard, stiff, high thermal stability, antifriction and abrasion resistant. High gloss.
Barrel temperature	
Feed zone:	30 – 50 °C
Zone 1:	160 – 190 °C
Zone 2:	180 – 200 °C
Zone 3:	180 – 210 °C
Zone 4:	180 – 210 °C
Zone 5:	180 – 210 °C
Nozzle:	180 – 210 °C
Melt temperature	180 – 210 °C
Mould temperature	70 – 100 °C
Injection temperature	800 – 1200 bar
Post-pressure	Between 30 and 60% of injection pressure, high post-pressure time
Counterpressure	50 – 100 bar
Injection speed	Medium
Screw speed	Equal to peripheric speed of 1.0 m/s
Metering	0.5 – 4 diameters
Cushion	2 – 8 mm, depends on metering and screw diameter
Drying	3 - 4 hours at 80°C
Recycle	Maximum 20% of regrinded material. This percentage decreases for technical and aesthetic parts.
Shrinkage	1.7 – 2.2% (for unfilled product)
Barrel equipment	Standard screw, non-return valve, free-flow nozzle
Quenching	Purge with PP or PEHD. Do not leave POM inside the barrel when the moulding machine is turned off.