

HM90-11

Polyoxymethylene-POM

Date: 2025-02-08, V1.1

Key Features

- ◆ Medium viscosity
- ◆ Injection molding grade

Recommended Applications

- ◆ Sanitary ware
- ◆ Automotive
- ◆ Electronics & Electrical

Basic Properties	Standard	Condition	Unit	Typical Value
Specific Gravity	ISO1183-1	23°C	g/cm ³	1.40
Melt Flow Rate	ISO1133	230°C, 2.16 kg	g/10min	9
Shrinkage	ISO 294-4	Flow direction, 3.20mm	%	1.8~2.3

Mechanical Properties

Tensile Strength	ISO 527-2	50mm/min	MPa	60
Elongation at Break	ISO 527-2	50mm/min	%	30
Flexural Strength	ISO 178	2mm/min	MPa	82
Flexural Modulus	ISO 178	2mm/min	MPa	2250
Charpy Notched Impact Strength	ISO 179-1	Notched, 23°C	kJ/m ²	6

Thermal Properties

Melting Point	ISO 11357-3		°C	165
Heat Deflection Temperature (HDT)	ISO 75-2	1.8MPa, non-annealed	°C	88

Other Properties

Flammability Rating	UL94	3.2mm	class	HB
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Processing Guidelines

Pre-drying	80~90°C, 3~4hr
Barrel Temperature-Rear Zone	190~200°C
Barrel Temperature-Middle Zone	195~205°C
Barrel Temperature-Front Zone	200~210°C
Mold Temperature	60~80 °C
Back Pressure	10~30 bar

Notes:

- 【1】 The typical values listed are for reference only and do not constitute product specifications.
- 【2】 The addition of colorants may alter some or all properties. Products of different colors may exhibit varying physical characteristics.
- 【3】 Processing parameters are provided as guidelines. Adjustments may be required based on equipment, molds, and product requirements.

Important Notice: The customer is responsible for ensuring that the product and its information comply with local laws and regulations. For safety and handling instructions, request the Material Safety Data Sheet (MSDS) from the local Huasu office. The recommendations herein assume proper end-use conditions (including efficacy and safety aligned with product design). Users assume full responsibility for their choices.