



Phone: (517) 295-4196 Fax: (517) 295-4918

Technical Data Sheet

LCA® POM-ZF0402 Black

Acetal Copolymer, Unfilled, Impact Modified

Typical Compound Properties

Physical Properties	Value / Measure	Test Methods
Melt Flow Rate	3.8 g/10 min	ASTM D-1238
Density	1.33 g/cm ³	ASTM D-792
Mechanical Properties		
Izod Impact	2.35 ft-lb/in	ASTM D-256
Tensile (Yield)	6,400 psi	ASTM D-638
Tensile Elongation (Break)	80 %	ASTM D-638
Flexural Modulus	320,000 psi	ASTM D-790
Flexural Strength	9000 psi	ASTM D-790

All tests are performed on dry as molded ASTM (ISO) test bars.

General Product Type Information

The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplas, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

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Typical Processing Conditions

Temperatures	Zone	°F
Barrel	Rear	350-380
	Center	360-390
	Front	370-400
	Nozzle	370-400
	Mold	175-225

Drying

Type	Dehumidifier
Temperature	160°F (max)
Time	2 - 4 hours

Special Requirements

Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.

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