



**Product Data Sheet &
General Processing Conditions**

**ESD 805
Acetal (POM)
Glass Fiber
ESD Protection
Electrically Conductive**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	30 %	30 %	
Specific Gravity	1.58	1.58	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0010 - 0.0030 in/in	0.10 - 0.30 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.3 ft-lbs/in	69 J/m	D 256
unnotched 1/8 in (3.2 mm) section	5.0 ft-lbs/in	267 J/m	D 4812
Tensile Strength	12000 psi	83 MPa	D 638
Tensile Elongation	1.0 - 3.0 %	1.0 - 3.0 %	D 638
Tensile Modulus	1.25 x 10 ⁶ psi	8619 MPa	D 638
Flexural Strength	20000 psi	138 MPa	D 790
Flexural Modulus	1.10 x 10 ⁶ psi	7584 MPa	D 790

ELECTRICAL

Volume Resistivity	< 1E4 ohm.cm	< 1E4 ohm.cm	D 257
Surface Resistivity	< 1E7 ohm/sq	< 1E7 ohm/sq	D 257
Surface Resistance	< 1E6 ohm	< 1E6 ohm	ESD STM11.11
Static Decay MIL-PRF-81705D, 5kV to 50 V, 12% RH	< 2.00 s	< 2.00 s	FTMS101C 4046.1

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.

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.