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**Product Data Sheet &  
General Processing Conditions**

**EMI 861  
Acetal (POM)  
EMI/RFI Shielding  
Stainless Steel Fiber**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

| <b>PERMANENCE</b>                            | <b>English</b> | <b>SI Metric</b> | <b>ASTM<br/>TEST</b> |
|----------------------------------------------|----------------|------------------|----------------------|
| Specific Gravity                             | 1.48           | 1.48             | D 792                |
| Molding Shrinkage<br>1/8 in (3.2 mm) section | 0.0240 in/in   | 2.40 %           | D 955                |

**MECHANICAL**

|                                   |                            |          |        |
|-----------------------------------|----------------------------|----------|--------|
| Impact Strength, Izod             |                            |          |        |
| notched 1/8 in (3.2 mm) section   | 1.5 ft-lbs/in              | 80 J/m   | D 256  |
| unnotched 1/8 in (3.2 mm) section | 9.5 ft-lbs/in              | 507 J/m  | D 4812 |
| Tensile Strength                  | 8000 psi                   | 55 MPa   | D 638  |
| Tensile Elongation                | > 10.0 %                   | > 10.0 % | D 638  |
| Tensile Modulus                   | 0.40 x 10 <sup>6</sup> psi | 2758 MPa | D 638  |
| Flexural Strength                 | 12000 psi                  | 83 MPa   | D 790  |
| Flexural Modulus                  | 0.40 x 10 <sup>6</sup> psi | 2758 MPa | D 790  |

**ELECTRICAL**

|                     |               |               |              |
|---------------------|---------------|---------------|--------------|
| Volume Resistivity  | < 1E-1 ohm.cm | < 1E-1 ohm.cm | D 257        |
| Surface Resistivity | < 1E2 ohm/sq  | < 1E2 ohm/sq  | D 257        |
|                     |               |               | ESD STM11.11 |

**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**

|                    | <b>English</b>    | <b>SI Metric</b> |
|--------------------|-------------------|------------------|
| Injection Pressure | 10000 - 15000 psi | 69 - 103 MPa     |
| Melt Temperature   | 360 - 425 °F      | 182 - 218 °C     |
| Mold Temperature   | 180 - 225 °F      | 82 - 107 °C      |
| Drying             | 2 hrs @ 250 °F    | 2 hrs @ 121 °C   |
| Moisture Content   | 0.15 %            | 0.15 %           |
| Dew Point          | -20 °F            | -29 °C           |