



**Product Data Sheet &  
General Processing Conditions**

**ZOVGOV® M23GB4  
Acetal (POM)  
Glass Bead**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Primary Additive	20 %	20 %	
Specific Gravity	1.54	1.54	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0150 - 0.0260 in/in	1.50 - 2.60 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.8 ft-lbs/in	43 J/m	D 256
unnotched 1/8 in (3.2 mm) section	8.5 ft-lbs/in	454 J/m	D 4812
Tensile Strength	6700 psi	46 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.47 x 10 <sup>6</sup> psi	3241 MPa	D 638
Flexural Strength	11000 psi	76 MPa	D 790
Flexural Modulus	0.43 x 10 <sup>6</sup> psi	2965 MPa	D 790

**THERMAL**

Ignition Resistance* Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635
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**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.

\* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

\*\* Values per MOLAN Company testing.

**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	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.