



**OmniTech™**  
**POM 27**

Easy Flow, Injection Grade, Polyoxymethylene

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Specific Gravity		D792	1.41	1.41
Filler/Reinforcement	%	D2584	n/a	n/a
Mold Shrinkage, Isotropic	in/in	D955	.015 - .021	
<b>IMPACT</b>				
Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	1	53
<b>MECHANICAL</b>				
Tensile Strength At Yield, 73°F	psi (MPa)	D638	8,800	61
Tensile Elongation	%	D638	8	8
Flexural Modulus	psi (MPa)	D790	390,000	2,689
Flexural Strength	psi (MPa)	D790	12,500	86
<b>THERMAL</b>				
Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	-	-
1/8" bar, 264 psi	°F (°C)	D648	230	110
<b>FLAMMABILITY</b>				
Flame Resistance *Omni Internal Testing	.125"	UL94	HB*	HB*
<b>RECOMMENDED PROCESSING CONDITIONS</b>				
Drying Temperature			250° F	
Drying Time			3 hrs. max.	
Maximum Moisture			0.15%	
Rear Zone(s)			375 to 410° F	
Middle Zone(s)			375 to 410° F	
Front Zone(s)			375 to 410° F	
Nozzle			375 to 410° F	
Mold Temperature			200 to 250° F	
Melt Temperature			420 to 500° F	
Back Pressure			50 to 100 psi	

Values are based on natural or black materials unless otherwise noted. Properties and values herein are based on laboratory test specimens and should not be used to establish minimum specification limits or fabricate tooling.

Omni does not guarantee the accuracy of this information or the suitability of this product in any given application or usage situation.