HK:+852-69575415 China GuangDong:+13538586433 ShangHai:+18816996168

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CELCON® M90LF

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Celcon® acetal copolymer grade M90LF is a medium viscosity polymer formulated without lubricants, providing optimum performance in injection molding and extrusion of thin walled tubing and thin gauge film.

Product information

Resin Identification	POM		ISO 1043
Part Marking Code	>POM<		ISO 11469

Rheological properties

Melt volume-flow rate	8	cm^3/10min	ISO 1133
Temperature	190	°C	
Load	2.16	kg	
Moulding shrinkage, parallel	2.0	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.9	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	2800	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	66	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	9	%	ISO 527-1/-2
Charpy notched impact strength, 23°C	6	kJ/m^2	ISO 179/1eA
Poisson's ratio	0.37[C]		

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	167	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	101	°C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	120	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	120	E-6/K	ISO 11359-1/-2

Physical/Other properties

Density	1410	kg/m^3	ISO 1183

Injection

Drying Recommended	no	
Drying Temperature	100	°C
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	190	°C
Min. melt temperature	180	°C
Max. melt temperature	200	°C
Screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	100	°C
Min. mould temperature	80	°C
Max. mould temperature	120	°C
Hold pressure range	60 - 120	MPa
Back pressure	0.5	MPa

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Characteristics

Processing	Injection Moulding
Delivery form	Pellets

Additional information

Processing Notes

Pre-Drying

Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying may be necessary to prevent splay and odor problems.