

Celcon® M90UV

Acetal (POM) Copolymer

Celanese Corporation

Message:

Celcon® M90UV is an acetal copolymer developed as a natural UV light stabilized standard flow grade for overall performance in most molding applications. It has been formulated as a natural acetal that does not discolor, yet maintains protection from UV light exposure.

General Information			
UL YellowCard	E38860-239310	E38860-239313	
Additive	UV stabilizer		
Features	Good UV resistance		
	General		
Uses	General		
RoHS Compliance	Contact manufacturer		
Appearance	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792, ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	8.00	cm ³ /10min	ISO 1133
Molding Shrinkage			ASTM D955
Flow	2.2	%	ASTM D955
Transverse flow	1.8	%	ASTM D955
Water Absorption			ISO 62
Saturated, 23°C	0.75	%	ISO 62
Equilibrium, 23°C, 50% RH	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2600	MPa	ISO 527-2/1A/1
Tensile Strength			
Yield, 23°C	60.7	MPa	ASTM D638
Yield	65.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	10	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2550	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.1	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)	5.8	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, not annealed	110	°C	ASTM D648
1.8 MPa, not annealed	101	°C	ISO 75-2/A

Melting Temperature ¹	165	°C	ISO 11357-3, ASTM D3418
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.1E-4	cm/cm/°C	ISO 11359-2
Lateral	1.2E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	3.0	hr	
Rear Temperature	170 - 180	°C	
Middle Temperature	180 - 190	°C	
Front Temperature	180 - 190	°C	
Nozzle Temperature	190 - 200	°C	
Processing (Melt) Temp	180 - 200	°C	
Mold Temperature	80.0 - 120	°C	
Injection Pressure	60.0 - 120	MPa	
Injection Rate	Slow-Moderate		
Holding Pressure	60.0 - 120	MPa	
Back Pressure	0.00 - 0.500	MPa	
Injection instructions			
Manifold Temperature: 180 to 200°CZone 4 Temperature: 190 to 200°C			
NOTE			
1.	10°C/min		

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