

Celcon® M140-L1

Acetal (POM) Copolymer

Celanese Corporation

Message:

Celcon® M140-L1 is a general purpose acetal copolymer material with a slightly lower viscosity for improved flow in molding that has been modified to reduce or eliminate noise (squeak) when wearing against itself.

General Information			
UL YellowCard	E38860-239308		
Features	Low viscosity		
	Good liquidity		
	General		
Uses	General		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)		
Physical	Nominal Value	Unit	Test Method
Density	1.40	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	12.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.7	%	ISO 294-4
Flow direction	1.9	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2600	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	63.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	9.5	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2500	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)	5.7	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	100	°C	ISO 75-2/A
Melting Temperature ¹	166	°C	ISO 11357-3
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
Fill Analysis	Nominal Value	Unit	Test Method
Density of Melt	1.170	g/cm ³	Internal method

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°C Zone 4 Temperature: 190 to 200°C

NOTE

1. 10°C/min

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