

CELCON[®] M90LF

CELCON®

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 Part Marking Code	POM >POM<		ISO 1043 ISO 11469
Rheological properties			
Melt volume-flow rate Temperature Load Moulding shrinkage, parallel	190 2.16 2.0	kg %	ISO 1133 ISO 294-4, 2577
Moulding shrinkage, normal	1.9	%	ISO 294-4, 2577
Typical mechanical properties			
Tensile modulus Tensile stress at yield, 50mm/min Tensile strain at yield, 50mm/min Charpy notched impact strength, 23°C Poisson's ratio [C]: Calculated	9	MPa MPa % kJ/m ²	ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 179/1eA
Thermal properties			
Melting temperature, 10°C/min Temperature of deflection under load, 1.8 MPa Coefficient of linear thermal expansion (CLTE), parallel	167 101 120		ISO 11357-1/-3 ISO 75-1/-2 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/m³	ISO 1183
Injection			
Drying Recommended Drying Temperature Drying Time, Dehumidified Dryer Processing Moisture Content Melt Temperature Optimum Min. melt temperature Max. melt temperature Screw tangential speed Mold Temperature Optimum Min. mould temperature Max. mould temperature Hold pressure range	no 100 3 - 4 ≤0.2 190 180 200 ≤0.3 100 80 120 60 - 120	h % °C °C °C m/s °C °C °C	
Back pressure	0.5	MPa	

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Characteristics

Processing Delivery form

Injection Moulding 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.

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