



CELCON® M90UV

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Celcon® M90UV is an acetal copolymer developed as a natural UV light stabilized medium 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.

Product informa	ition

i roduct imormation			
Resin Identification Part Marking Code	POM >POM<		ISO 1043 ISO 11469
Rheological properties			
Melt volume-flow rate Temperature Load	8 190 2.16	-	ISO 1133
Typical mechanical properties			
Tensile modulus Tensile stress at yield, 50mm/min Tensile strain at yield, 50mm/min Flexural modulus Flexural stress at 3.5% Charpy notched impact strength, 23°C Izod notched impact strength, 23°C Poisson's ratio [C]: Calculated	10 2550 70 6.1	MPa %	ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 178 ISO 179/1eA ISO 180/1A
Thermal properties			
Melting temperature, 10 ° C/min Temperature of deflection under load, 1.8 MPa Coefficient of linear thermal expansion (CLTE), parallel Coefficient of linear thermal expansion (CLTE), normal			ISO 11357-1/-3 ISO 75-1/-2 ISO 11359-1/-2
Physical/Other properties			
Humidity absorption, 2mm Water absorption, 2mm Water absorption, Immersion 24h Density	0.2 0.75 0.2 1410	%	Sim. to ISO 62 Sim. to ISO 62 Sim. to ISO 62 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	no 100 3 - 4 ≤0.2 190 180 200 ≤0.3 100	h % °C °C °C m/s	

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Min. mould temperature
Max. mould temperature
Hold pressure range
Back pressure

80 °C 120 °C 60 - 120 MPa 4 MPa

Characteristics

Processing Injection Moulding

Delivery form Pellets

Additives Release agent

Special characteristics U.V. stabilised or stable to weather

Additional information

Injection molding

Preprocessing

Drying is generally not required because Celcon® and Hostaform® acetal copolymers are not hydroscopic nor are they degraded by moisture during processing. Excessive moisture can lead to splay (silver streaking) in molded parts. For better uniformity in molding especially when using regrind or material that has been stored in containers open to the atmosphere, recommended drying conditions are 80 C (180 F) for 3hours. Desiccant hopper dryers are not required. Maximum water content = 0.35%

Processing

Standard reciprocating screw injection molding machines with a high compression screw (minimum 3:1 and preferably 4:1) and low back pressure (0.35 Mpa/50 PSI) are favored. Using a low compression screw (I.E. general purpose 2:1 compression ratio) can result in unmelted particles and poor melt homogeneity. Using a high back pressure to make up for a low compression ratio may lead to excessive shear heating and deterioration of the material.

Melt Temperature: Preferred range 182-199 C (360-390 F). Melt temperature should never exceed 230 C (450 F).

Mold Surface Temperature: Preferred range 82-93 C (180-200 F) especially with wall thickness less than 1.5 mm (0.060 in.). May require mold temperature as high as 120 C (250 F) to reproduce mold surface or to assure minimal molded in stress. Wall thickness greater than 3mm (1/8 in.) may use a cooler (65 C/150 F) mold surface temperature and wall thickness over 6mm (1/4 in.) may use a cold mold surface down to 25 C (80 F). In general, mold surface temperatures lower than 82 C (180 F) may hinder weld line formation and produce a hazy surface or a surface with flow lines, pits and other included defects that can hinder part performance.

Postprocessing

Postprocessing conditioning and moisturizing are not required. It may be

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necessary to fixture large or complicated parts with varying wall thickness to prevent warpage while cooling to ambient temperature.

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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