

CELCON® M90LF

Standard melt flow, lubrication free

Celcon® acetal copolymer grade M90LF is a medium viscosity polymer providing optimum performance in general purpose injection molding and extrusion of thin walled tubing and thin gauge film. Preliminary Data Sheet

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
Yield stress, 50mm/min	66 MPa	ISO 527-1/-2
Yield strain, 50mm/min	9 %	ISO 527-1/-2
Charpy notched impact strength, 23°C	6 kJ/m ²	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	167 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	101 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	120 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	120 E-6/K	ISO 11359-1/-2

Other properties

Density	1410 kg/m ³	ISO 1183
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Injection

Drying Temperature	100 - 120 °C	
Drying Time, Dehumidified Dryer	3 - 4 h	
Melt Temperature Optimum	174 °C	Internal
Max. mould temperature	80 - 120 °C	
Back pressure	1 MPa	
Injection speed	slow-medium	

Processing Texts

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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