

Celcon® MR90B

Acetal (POM) Copolymer

Celanese Corporation

Message:

Celcon® MR90B is a standard flow specialty media resistant grade developed for improved bleach resistance.

General Information			
RoHS Compliance		Contact manufacturer	
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	8.00	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	2.2	%	ISO 294-4
Flow direction	2.2	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2800	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	65.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	11	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2800	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	5.0	kJ/m ²	ISO 179/1eA
23°C	5.1	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	110	kJ/m ²	ISO 179/1eU
23°C	110	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	6.0	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	8.9E-5	cm/cm/°C	ISO 11359-2
Lateral	1.0E-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 - 190	°C	
Middle Temperature	180 - 190	°C	
Front Temperature	180 - 190	°C	

Nozzle Temperature	180 - 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: 180 to 200°C

NOTE

1. 10°C/min

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

