

Celcon® GC90UV

Acetal (POM) Copolymer

Celanese Corporation

Message:

Celcon® acetal copolymer grade GC90UV is a specialty grade combining glass coupling for improved strength and stiffness and UV stabilization for improved performance in exposure to artificial lighting and sunlight.

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Additive	UV stabilizer		
Features	Rigid, good		
	Chemical coupling		
	Good UV resistance		
	Good strength		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.47	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4170	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	59.0	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	9.0	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	3790	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.7	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)	4.5	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	141	°C	ISO 75-2/A
Melting Temperature ¹	167	°C	ISO 11357-3
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	90.0 - 120	°C	
Injection Pressure	90.0 - 140	MPa	
Injection Rate	Slow		

Holding Pressure	90.0 - 140	MPa
Back Pressure	0.00 - 0.500	MPa
Injection instructions		
Manifold Temperature: 190 to 210°CZone 4 Temperature: 190 to 200°C		
NOTE		
1.	10°C/min	

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