

DURACON® M90FC

Acetal (POM) Copolymer

Polyplastics Co., Ltd.

Message:

DURACON® M90FC is a polyoxymethylene (POM) copolymer product. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. The main characteristics are: flame retardant/rated flame.

General Information			
UL File Number	E45034		
Forms	Particle		
Processing Method	Injection molding		
Part Marking Code (ISO 11469)	>POM		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	9.0	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	8.00	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2700	MPa	ISO 527-2
Tensile Stress	62.0	MPa	ISO 527-2
Nominal Tensile Strain at Break	35	%	ISO 527-2
Flexural Modulus	2500	MPa	ISO 178
Flexural Stress	87.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	6.0	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	95.0	°C	ISO 75-2/A
Linear thermal expansion coefficient			Internal method
Flow: 23 to 55°C	1.2E-4	cm/cm/°C	Internal method
Lateral: 23 to 55°C	1.2E-4	cm/cm/°C	Internal method
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	19	kV/mm	IEC 60243-1
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Additional Information	Nominal Value		
Color Number	CF2001		
Injection	Nominal Value	Unit	

Drying Temperature	80.0 - 90.0	°C
Drying Time	3.0 - 4.0	hr
Processing (Melt) Temp	190 - 210	°C
Mold Temperature	60.0 - 80.0	°C
Injection Pressure	49.0 - 98.0	MPa
Screw Speed	100 - 150	rpm

Injection instructions

Injection Speed: 5-50mm/s (0.3-3m/min)Molding Cycle:

Injection Holding Pressure: Gate sealing time + alpha

Cooling: Plasticizing time or ejection capable time

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