

Celcon® LU02

Acetal (POM) Copolymer
Celanese Corporation

Message:

Celcon® acetal copolymer grade LU02 is UV stabilized material displaying a reduced gloss over standard UV acetal grades.

General Information			
Additive	UV stabilizer		
Features	Gloss, low		
	Good UV resistance		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.39	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	20.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.6	%	ISO 294-4
Flow direction	1.9	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2530	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	56.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	9.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	11	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2500	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	3.7	kJ/m ²	ISO 179/1eA
23°C	3.7	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	90.0	°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 - 175	°C	
Middle Temperature	170 - 180	°C	
Front Temperature	175 - 185	°C	
Nozzle Temperature	185 - 195	°C	
Processing (Melt) Temp	180 - 195	°C	

Mold Temperature	80.0 - 105	°C
Injection Pressure	60.0 - 120	MPa
Injection Rate	Slow	
Holding Pressure	60.0 - 120	MPa
Back Pressure	0.00 - 0.500	MPa

Injection instructions

Zone 4 Temperature: 180 to 190°C

NOTE

1. 10°C/min

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