

Celcon® LW90-F2

Acetal (POM) Copolymer

Celanese Corporation

Message:

Celcon® LW90-F2 is an acetal copolymer formulated with a nominal 9 melt flow rate base polymer and a standard level of polytetrafluoroethylene filler (PTFE). It is designed for use in wear applications against plastic, metal, glass, or ceramic mating surfaces where silicone lubricants can not be tolerated.

General Information			
Additive	PTFE lubricant		
Features	Low friction coefficient		
	Good wear resistance		
	Lubrication		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.40	g/cm ³	ASTM D792
--	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			
Flow	2.2	%	ASTM D955
Transverse flow	1.8	%	ASTM D955
Vertical flow direction	1.9	%	ISO 294-4
Flow direction	2.3	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2650	MPa	ISO 527-2/1A/1
Tensile Strength			
Yield, 23°C	57.2	MPa	ASTM D638
Yield	63.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	9.0	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2600	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	120	kJ/m ²	ISO 179/1eU
23°C	120	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	5.1	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	98.0	°C	ISO 75-2/A

Melting Temperature ¹	166	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.0E-4	cm/cm/°C	ISO 11359-2
Lateral	9.0E-5	cm/cm/°C	ISO 11359-2
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	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: 190 to 200°C			
NOTE			
1.	10°C/min		

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