

Celcon® LW90FS-K

Acetal (POM) Copolymer

Celanese Corporation

Message:

Celcon® acetal copolymer grade LW90FS-K is wear resistant grade of M90 based on both silicone and a high level of PTFE to give excellent slip and wear resistance properties in demanding applications.

General Information			
Additive	PTFE lubricant		
	Silicone lubricant		
Features	Good wear resistance		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.51	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	1.1	%	ISO 294-4
Flow direction	0.90	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2100	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	44.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	17	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2050	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	61	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	4.4	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	87.0	°C	ISO 75-2/A
Melting Temperature ¹	166	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.1E-4	cm/cm/°C	ISO 11359-2
Lateral	1.2E-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 - 180	°C	
Middle Temperature	175 - 185	°C	

Front Temperature	180 - 190	°C
Nozzle Temperature	185 - 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		
Zone 4 Temperature: 185 to 195°C		
NOTE		
1.	10°C/min	

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