

Celcon® M90-34

Acetal (POM) Copolymer

Celanese Corporation

Message:

Celcon® M90-34 is a specially formulated injection moldable grade of acetal copolymer for the appliance market targeted at resisting staining while providing a balance of properties.

Chemical abbreviation according to ISO 1043-1: POM

General Information			
UL YellowCard	E38860-239312		
Uses	Electrical appliances		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Resin ID (ISO 1043)	POM		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792, 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	1.8	%	ISO 294-4
Flow direction	2.2	%	ISO 294-4
Water Absorption			
Saturated, 23°C	0.75	%	ISO 62
Equilibrium, 23°C, 50% RH	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2550	MPa	ISO 527-2/1A/1
Tensile Strength			
Yield, 23°C	60.7	MPa	ASTM D638
Yield	63.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	11	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2450	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.4	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)	6.2	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, not annealed	110	°C	ASTM D648
1.8 MPa, not annealed	100	°C	ISO 75-2/A
Melting Temperature ¹	165	°C	ISO 11357-3, ASTM D3418

Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
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°C Zone 4 Temperature: 190 to 200°C			
NOTE			
1.	10°C/min		

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