

Celcon® MR270B

Acetal (POM) Copolymer

Celanese Corporation

Message:

Celcon® MR270B is a high flow specialty media resistant grade developed for improved bleach resistance.

General Information			
Features	High liquidity		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	24.0	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2750	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	66.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	7.0	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2800	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	5.0	kJ/m ²	ISO 179/1eA
23°C	5.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	95	kJ/m ²	ISO 179/1eU
23°C	100	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	5.5	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	100	°C	ISO 75-2/A
Melting Temperature ¹	166	°C	ISO 11357-3
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	180 - 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: 180 to 200°C		
NOTE		
1.	10°C/min	

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