

Celcon® M270UV

Acetal (POM) Copolymer

Celanese Corporation

Message:

Celcon® M270UV is an acetal copolymer developed as a natural UV light stabilized lower molecular weight, high-flow grade designed for superior moldability in multi-cavity or hard to fill injection mold.

General Information			
UL YellowCard	E38860-239310		
Additive	UV stabilizer		
Features	Low molecular weight		
	Good UV resistance		
	Good formability		
	High liquidity		
RoHS Compliance	Contact manufacturer		
Appearance	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	23.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.6	%	ISO 294-4
Flow direction	1.7	%	ISO 294-4
Water Absorption			ISO 62
Saturated, 23°C	0.75	%	ISO 62
Equilibrium, 23°C, 50% RH	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2800	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	66.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	8.0	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2750	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.5	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)	4.9	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	102	°C	ISO 75-2/A
Melting Temperature ¹	167	°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	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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