

Celcon® M90-45H

Acetal (POM) Copolymer

Celanese Corporation

Message:

Celcon® M90-45H is an acetal copolymer which has been stabilized to give protection against property and color degradation in interior applications where UV exposure is anticipated.

Celcon ® M90-45H is formulated in custom colors for Toyota interior UV stabilized applications

General Information			
Additive	UV stabilizer		
Features	Good UV resistance		
Uses	Application in Automobile Field		
	Car interior parts		
RoHS Compliance	Contact manufacturer		
Appearance	Available colors		
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	1.7	%	ISO 294-4
Flow direction	1.9	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2750	MPa	ISO 527-2/1A/1
Tensile Stress			
Yield	63.0	MPa	ISO 527-2/1A/50
Fracture, 23°C	60.7	MPa	ASTM D638
Tensile Strain (Yield)	10	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2490	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	4.0	kJ/m ²	ISO 179/1eA
23°C	6.0	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)	6.0	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	91.0	°C	ISO 75-2/A

Melting Temperature			
-- 1	166	°C	ISO 11357-3
--	165	°C	ASTM D3418
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	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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