

Celcon® M25UV

Acetal (POM) Copolymer

Celanese Corporation

Message:

Celcon® M25UV is an acetal copolymer developed as a natural UV light stabilized low flow, high molecular weight grade. It has been formulated as a natural acetal that does not discolor, yet maintains protection from UV light exposure.

General Information			
UL YellowCard	E38860-239310		
Additive	UV stabilizer		
Features	High molecular weight		
	Good UV resistance		
	Low liquidity		
	Good toughness		
RoHS Compliance	Contact manufacturer		
Appearance	Natural color		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	2.20	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.8	%	ISO 294-4
Flow direction	2.2	%	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	2500	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	62.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	12	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2400	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.5	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)	7.6	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	93.0	°C	ISO 75-2/A
Melting Temperature ¹	166	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.2E-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		
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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