

Celcon® LW90-S2

Acetal (POM) Copolymer

Celanese Corporation

Message:

Celcon® LW90-S2 is a preblended low wear formulation of M90 base polymer containing 2% silicone. This standard low friction, low wear product performs well in many applications including those involving intermittent motion.

General Information			
UL YellowCard	E38860-100951553		
Additive	Silicone lubricant (2%)		
Features	Low friction coefficient		
	Good wear resistance		
	Lubrication		
RoHS Compliance	Contact manufacturer		
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.40	g/cm ³	ASTM D792
--	1.38	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	8.40	cm ³ /10min	ISO 1133
Molding Shrinkage			
Flow	2.2	%	ASTM D955
Transverse flow	1.8	%	ASTM D955
Vertical flow direction	1.6	%	ISO 294-4
Flow direction	1.9	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-2/1A/1
Tensile Strength			
Yield, 23°C	51.0	MPa	ASTM D638
Yield	56.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	10	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2400	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	4.5	kJ/m ²	ISO 179/1eA
23°C	7.0	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)	5.3	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	94.0	°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
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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