



Celcon® M90LF

Celanese Corporation - Acetal (POM) Copolymer

Saturday, November 2, 2019

General Information

Product Description

Hostaform® acetal copolymer grade M90LF is a medium viscosity polymer providing optimum performance in general purpose injection molding and extrusion of thin walled tubing and thin gauge film. Preliminary Data Sheet

General

Material Status	• Experimental: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• General Purpose	• Medium Viscosity	
Uses	• Film	• General Purpose	• Tubing
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	8.00	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.9	%	
Flow	2.0	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	406000	psi	ISO 527-2/1A
Tensile Stress (Yield)	9570	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	9.0	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	2.9	ft-lb/in ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	214	°F	ISO 75-2/A
Melting Temperature ²	333	°F	ISO 11357-3
CLTE - Flow	6.7E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	6.7E-5	in/in/°F	ISO 11359-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	338 to 356	°F
Middle Temperature	356 to 374	°F
Front Temperature	356 to 374	°F
Nozzle Temperature	374 to 392	°F
Processing (Melt) Temp	356 to 392	°F
Mold Temperature	176 to 248	°F
Injection Rate	Slow-Moderate	
Back Pressure	< 72.5	psi

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Injection Notes

Zone4 temperature: 190 to 200°C

Flow temperature: 174°C

No flow temperature: 160°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 10°C/min