Celcon® MR90B

Celanese Corporation - Acetal (POM) Copolymer

Sunday, November 3, 2019

General Information

Product Description

Celcon® MR90B is a standard flow specialty media resistant grade developed for improved bleach resistance.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
RoHS Compliance	• Contact Manufacturer		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	8.00	cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	2.2	%	
Flow	2.2	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	406000	psi	ISO 527-2/1A
Tensile Stress (Yield)	9430	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	11	%	ISO 527-2/1A/50
Flexural Modulus (73°F)	406000	psi	ISO 178
Flexural Stress (3.5% Strain)	10900	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	2.4	ft·lb/in²	
73°F	2.4	ft·lb/in²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	51	ft·lb/in²	
73°F	51	ft·lb/in²	
Notched Izod Impact Strength (73°F)	2.9	ft·lb/in²	ISO 180/1A
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (264 psi, Unannealed)	212	°F	ISO 75-2/A
Melting Temperature [2]	331	°F	ISO 11357-3
CLTE - Flow	4.9E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	5.6E-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 374	°F
Middle Temperature	356 to 374	°F
Front Temperature	356 to 374	°F
Nozzle Temperature	356 to 392	°F

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Injection	Nominal Value	Unit
Processing (Melt) Temp	356 to 392	°F
Mold Temperature	176 to 248	°F
Injection Rate	Slow-Moderate	
Back Pressure	< 580	psi

Injection Notes

Zone4 temperature: 180 to 200°C
Hot runner temperature: 180 to 200°C

Notes

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

[2] 10°C/min