

# **CELCON®**

Celcon® UV270Z is a nominal 27 melt flow rate acetal copolymer which has been specially stabilized to prevent discoloration and deterioration of mechanical properties from ultraviolet light exposure. Celcon® UV270Z is designed to fill small and difficult to process parts such as speaker grills and other interior automotive parts. The material is available in precolored black or colors.

### **Product information**

Resin Identification	POM		ISO 1043
Part Marking Code	>POM<		ISO 11469
Rheological properties			
Melt volume-flow rate	23	cm <sup>3</sup> /10min	ISO 1133
Temperature	190	°C	
Load	2.16	•	
Moulding shrinkage, parallel	1.7		ISO 294-4, 2577
Moulding shrinkage, normal	1.6	%	ISO 294-4, 2577
Typical mechanical properties			
Tensile modulus	2700	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	64	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min		%	ISO 527-1/-2
Flexural modulus	2760		ISO 178
Flexural stress at 3.5%		MPa	ISO 178
Compressive stress at 1% strain		MPa	ISO 604
Charpy notched impact strength, 23°C Izod notched impact strength, 23°C		kJ/m² kJ/m²	ISO 179/1eA ISO 180/1A
Poisson's ratio	0.38 <sup>[C]</sup>	NO/III	130 180/1A
[C]: Calculated	0.00		
[o]. Calculate			
Thermal properties			
Melting temperature, 10°C/min	167		ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa		°C	ISO 75-1/-2
Coefficient of linear thermal expansion	110	E-6/K	ISO 11359-1/-2
(CLTE), parallel Coefficient of linear thermal expansion (CLTE),	120	E-6/K	ISO 11359-1/-2
normal	120	L-0/1X	130 11339-1/-2
Electrical properties			
	1.0510	Ohan	IEC 00001 0 0
Surface resistivity Arc Resistance	1.3E16 240		IEC 62631-3-2 UL 746B
AIC nesistance	240	5	OL 740B
Physical/Other properties			
Humidity absorption, 2mm	0.2		Sim. to ISO 62
Water absorption, 2mm	0.75		Sim. to ISO 62
Density	1410	kg/m³	ISO 1183

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## Injection

Drying Recommended	no	
Drying Temperature	100	°C
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	190	°C
Min. melt temperature	180	°C
Max. melt temperature	200	°C
Screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	100	°C
Min. mould temperature	80	°C
Max. mould temperature	120	°C
Hold pressure range	60 - 120	MPa
Back pressure	4	MPa

#### Additional information

Injection molding

# Preprocessing

Drying is generally not required because Celcon® and Hostaform® acetal copolymers are not hydroscopic nor are they degraded by moisture during processing. Excessive moisture can lead to splay (silver streaking) in molded parts. For better uniformity in molding especially when using regrind or material that has been stored in containers open to the atmosphere, recommended drying conditions are 80 C (180 F) for 3hours. Desiccant hopper dryers are not required. Maximum water content = 0.35%

### **Processing**

Standard reciprocating screw injection molding machines with a high compression screw (minimum 3:1 and preferably 4:1) and low back pressure (0.35 Mpa/50 PSI) are favored. Using a low compression screw (I.E. general purpose 2:1 compression ratio) can result in unmelted particles and poor melt homogeneity. Using a high back pressure to make up for a low compression ratio may lead to excessive shear heating and deterioration of the material.

Melt Temperature: Preferred range 182-199 C (360-390 F). Melt temperature should never exceed 230 C (450 F).

Mold Surface Temperature: Preferred range 82-93 C (180-200 F) especially with wall thickness less than 1.5 mm (0.060 in.). May require mold temperature as high as 120 C (250 F) to reproduce mold surface or to assure minimal molded in stress. Wall thickness greater than 3mm (1/8 in.) may use a cooler (65 C/150 F) mold surface temperature and wall thickness over 6mm (1/4 in.) may use a cold mold surface down to 25 C (80 F). In general, mold surface temperatures lower than 82 C (180 F) may hinder weld line formation and produce a hazy surface or a surface with flow lines, pits and other included defects that can hinder part performance.

### Postprocessing

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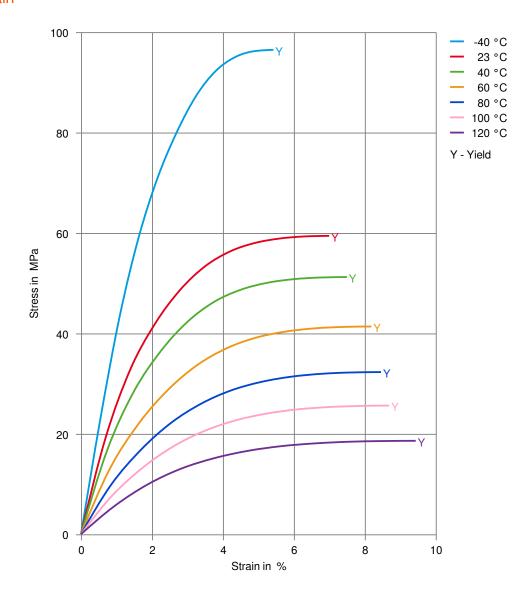
Postprocessing conditioning and moisturizing are not required. It may be necessary to fixture large or complicated parts with varying wall thickness to prevent warpage while cooling to ambient temperature.

**Processing Notes** 

# **Pre-Drying**

Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying may be necessary to prevent splay and odor problems.

### Stress-strain

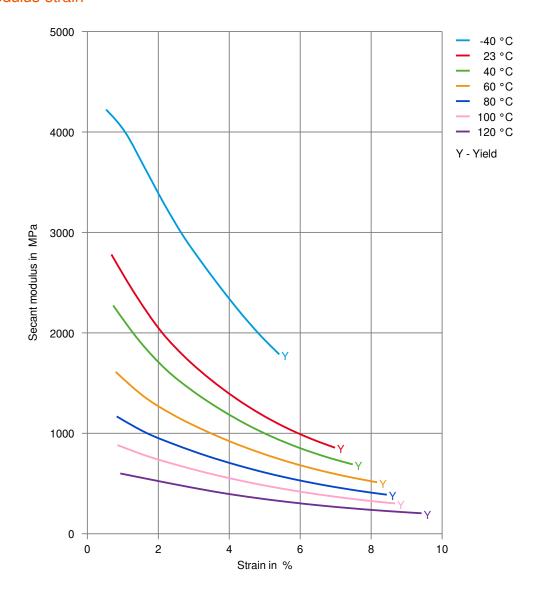


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## Secant modulus-strain

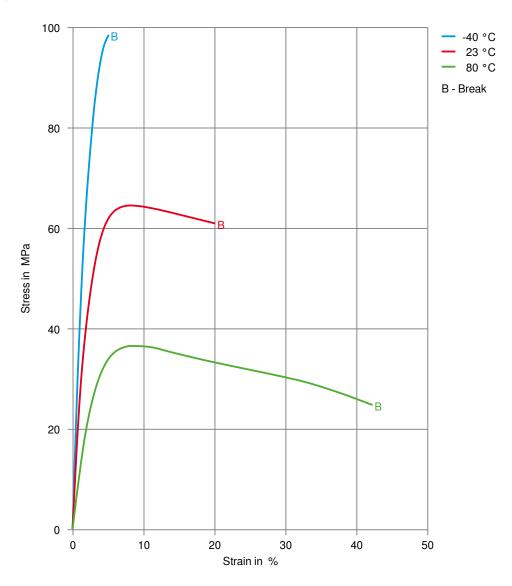


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## Stress-strain, 50mm/min

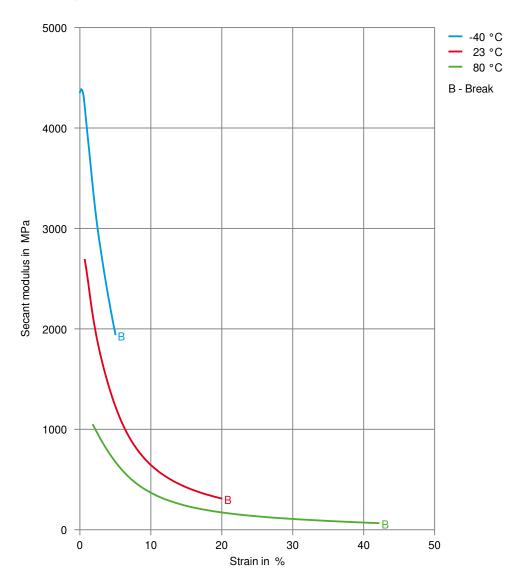


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#### Secant modulus-strain, 50mm/min



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