

CELCON® MR25B - POM

Description

Celcon® MR25B is a specialty media resistant grade developed for improved bleach resistance and improved toughness. Preliminary Data Sheet

Physical properties	Value	Unit	Test Standard
Density	1410	kg/m ³	ISO 1183
Melt volume rate, MVR	2.1	cm ³ /10min	ISO 1133
MVR temperature	190	°C	ISO 1133
MVR load	2.16	kg	ISO 1133

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	2600	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	63	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	10	%	ISO 527-2/1A
Charpy notched impact strength, 23°C	7.5	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	101	°C	ISO 75-1, -2

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Drying time	3 - 4	h	-
Drying temperature	100 - 120	°C	-
Temperature	Value	Unit	Test Standard
Zone1 temperature	170 - 180	°C	-
Zone2 temperature	180 - 190	°C	-
Zone3 temperature	180 - 190	°C	-
Zone4 temperature	180 - 200	°C	-
Nozzle temperature	180 - 200	°C	-
Melt temperature	180 - 200	°C	-
Mold temperature	80 - 120	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	40	bar	-
Speed	Value	Unit	Test Standard
Injection speed	slow	-	-

