

# CELCON® MC270

Mineral coupled for reduced warpage, high flow

Celcon® MC270 is a mineral coupled acetal copolymer designed for applications requiring improved stiffness, lower mold shrinkage and reduced warpage while maintaining the mechanical performance characteristics of an unfilled Celcon® M270 grade.

## Rheological properties

|                                    |            |                 |
|------------------------------------|------------|-----------------|
| Melt mass-flow rate                | 26 g/10min | ISO 1133        |
| Melt mass-flow rate, Temperature   | 190 °C     |                 |
| Melt mass-flow rate, Load          | 2.16 kg    |                 |
| Moulding shrinkage range, parallel | 1.9 %      | ISO 294-4, 2577 |
| Moulding shrinkage range, normal   | 1.6 %      | ISO 294-4, 2577 |

## Typical mechanical properties

|                                       |           |              |
|---------------------------------------|-----------|--------------|
| Tensile Modulus                       | 3150 MPa  | ISO 527-1/-2 |
| Yield stress, 50mm/min                | 57 MPa    | ISO 527-1/-2 |
| Yield strain, 50mm/min                | 7 %       | ISO 527-1/-2 |
| Flexural Modulus                      | 3100 MPa  | ISO 178      |
| Flexural Strength                     | 77 MPa    | ISO 178      |
| Charpy notched impact strength, 23°C  | 5.4 kJ/m² | ISO 179/1eA  |
| Charpy notched impact strength, -30°C | 4.5 kJ/m² | ISO 179/1eA  |
| Izod notched impact strength, 23°C    | 5.5 kJ/m² | ISO 180/1A   |
| Poisson's ratio                       | 0.437     |              |

## Thermal properties

|   |           |                |
|---|-----------|----------------|
| Melting temperature, 10°C/min               | 165 °C    | ISO 11357-1/-3 |
| Temp. of deflection under load, 1.8 MPa     | 101 °C    | ISO 75-1/-2    |
| Vicat softening temperature, 50°C/h, 50N    | 161 °C    | ISO 306        |
| Coeff. of linear therm. expansion, parallel | 100 E-6/K | ISO 11359-1/-2 |
| Coeff. of linear therm. expansion, normal   | 120 E-6/K | ISO 11359-1/-2 |

## Other properties

|                          |            |                |
|--------------------------|------------|----------------|
| Humidity absorption, 2mm | 0.2 %      | Sim. to ISO 62 |
| Water absorption, 2mm    | 0.75 %     | Sim. to ISO 62 |
| Density                  | 1480 kg/m³ | ISO 1183       |

## Injection

|                                 |              |
|---------------------------------|--------------|
| Drying Temperature              | 100 - 120 °C |
| Drying Time, Dehumidified Dryer | 3 - 4 h      |
| Max. mould temperature          | 80 - 120 °C  |
| Back pressure                   | 4 MPa        |
| Injection speed                 | slow         |



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## Characteristics

Additives

Mineral Filler

## Additional information

Injection molding

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.

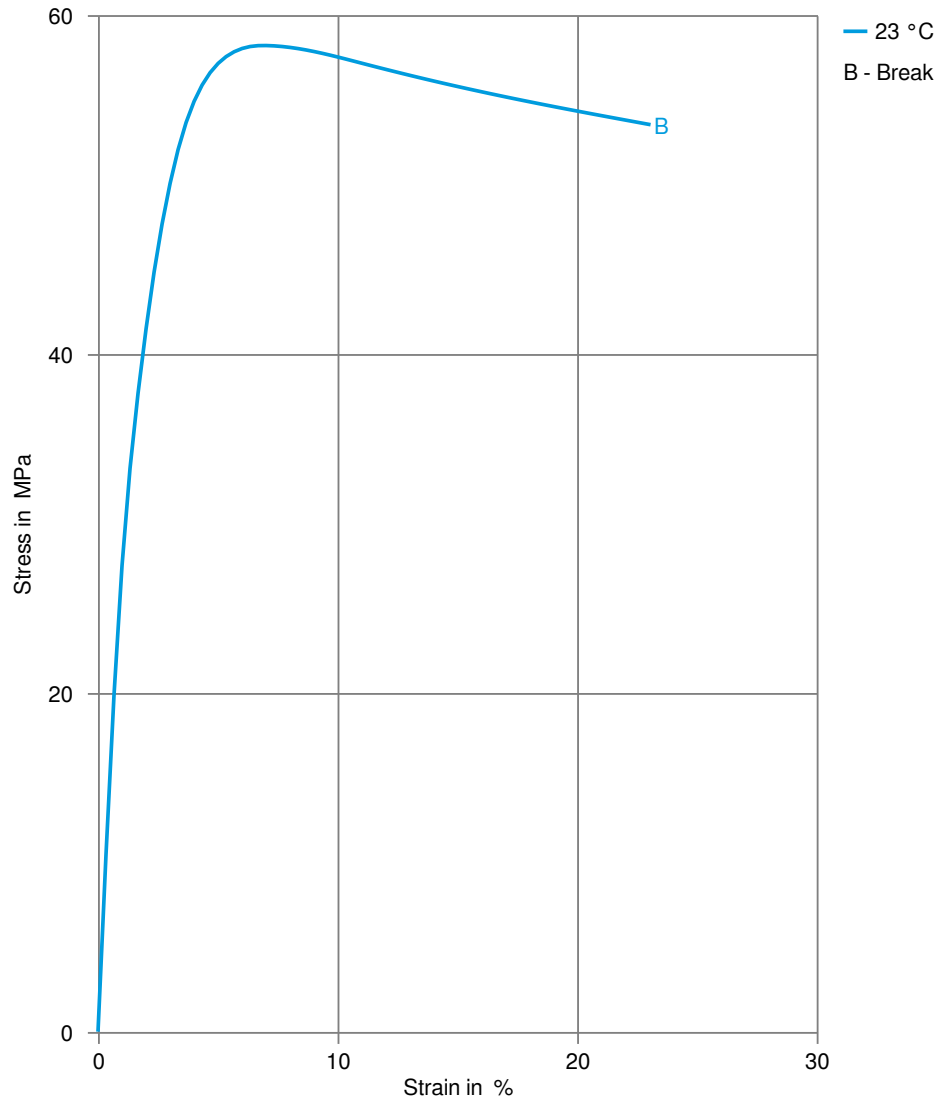
Melt Temperature: Preferred range 182-199 C (360-390 F). Melt temperature should never exceed 230 C (450 F).

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.



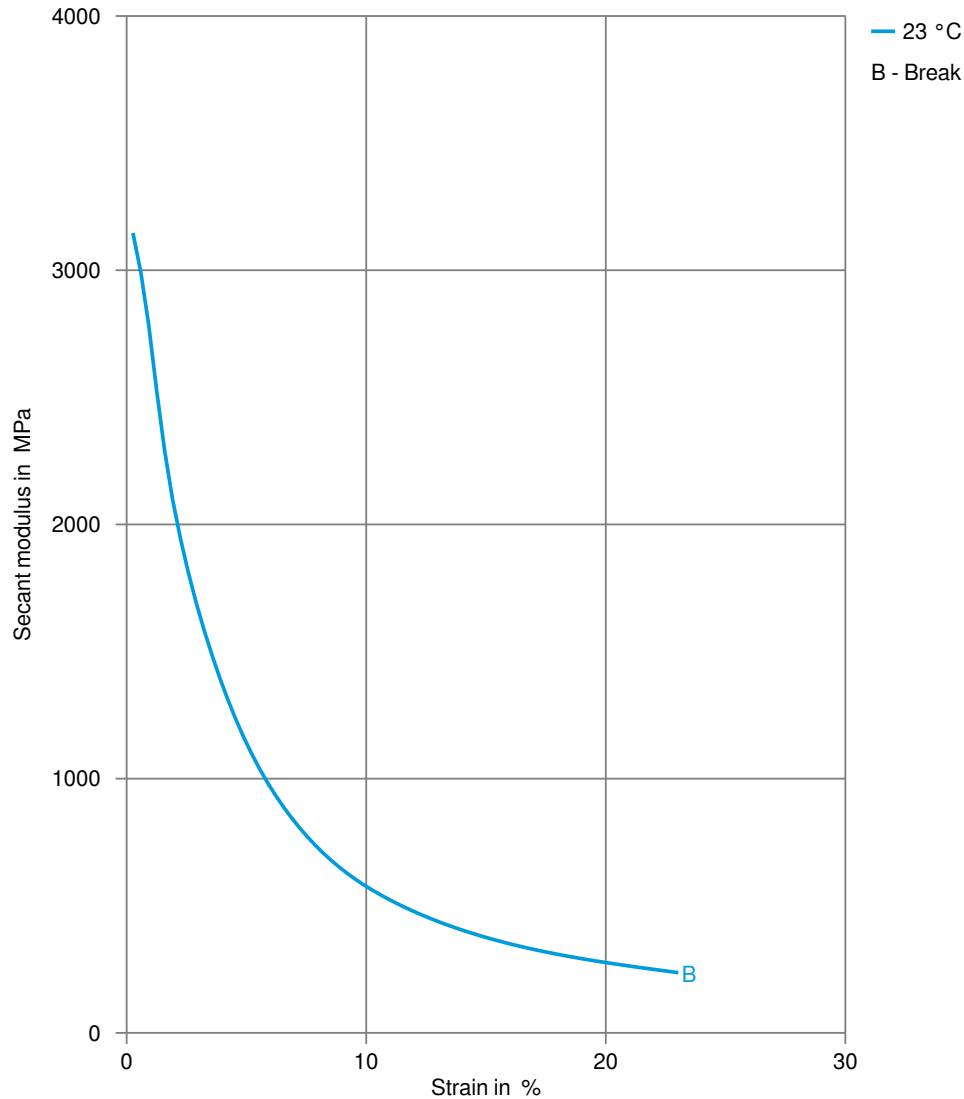
# CELCON® MC270

## Stress-strain



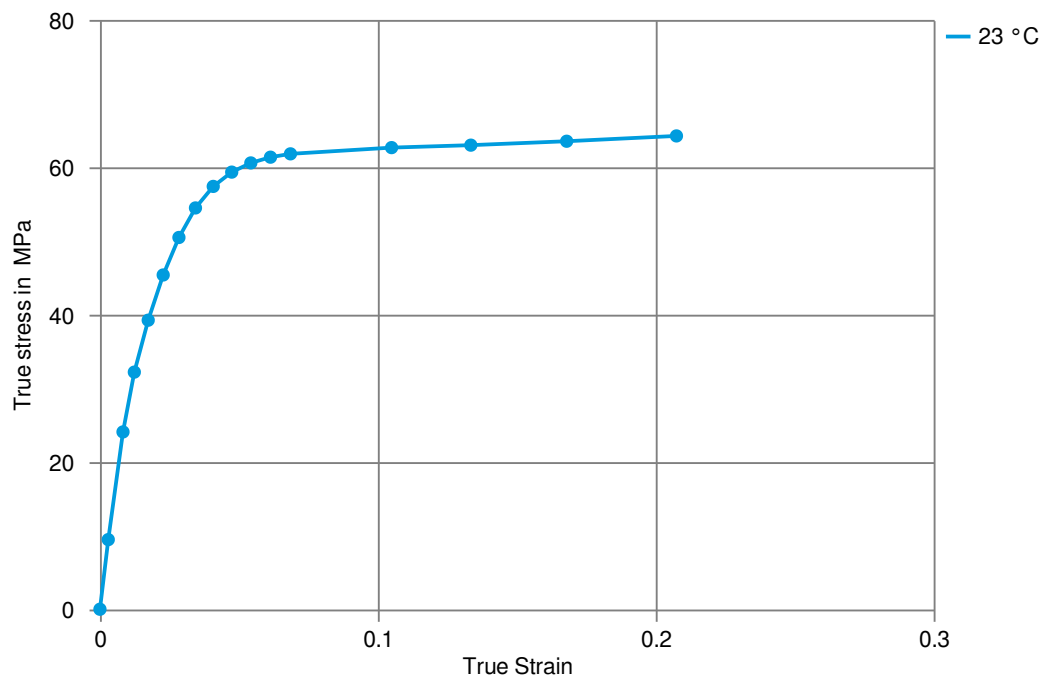
# CELCON® MC270

## Secant modulus-strain



# CELCON<sup>®</sup> MC270

## True stress-strain



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## Processing Texts

### Injection molding

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### Injection molding Preprocessing

Drying is generally not required because Celcon® and Hostaform® acetal copolymers are not hygroscopic 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 3 hours. Desiccant hopper dryers are not required. Maximum water content = 0.35%

### Injection molding Postprocessing

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.

