



Celcon® M140-L1

Celanese Corporation - Acetal (POM) Copolymer

Saturday, November 2, 2019

General Information

Product Description

Celcon® M140-L1 is a general purpose acetal copolymer material with a slightly lower viscosity for improved flow in molding that has been modified to reduce or eliminate noise (squeak) when wearing against itself.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
Additive	• Antisqueak		
Features	• General Purpose		
Uses	• General Purpose		
RoHS Compliance	• Contact Manufacturer		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.40	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	12	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.7	%	
Flow	1.9	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	377000	psi	ISO 527-2/1A
Tensile Stress (Yield)	9140	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	9.5	%	ISO 527-2/1A/50
Flexural Modulus (73°F)	363000	psi	ISO 178
Flexural Stress (3.5% Strain)	10300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	2.9	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact Strength (73°F)	2.7	ft·lb/in ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	212	°F	ISO 75-2/A
Vicat Softening Temperature	322	°F	ISO 306/B50
Melting Temperature ²	331	°F	ISO 11357-3
Melting Temperature	329	°F	
CLTE - Flow	6.1E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	6.7E-5	in/in/°F	ISO 11359-2
Fill Analysis	Nominal Value	Unit	Test Method
Melt Density	1.17	g/cm ³	Internal Method

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

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Injection	Nominal Value	Unit
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	< 580	psi

Injection Notes

Zone4 temperature: 190 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