



Celcon® MR25B

Celanese Corporation - Acetal (POM) Copolymer

Sunday, November 3, 2019

General Information

Product Description

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

General

Material Status	• Experimental: Active		
Availability	• Africa & Middle East	• Europe	• North America
Features	• Good Toughness		
RoHS Compliance	• Contact Manufacturer		

ASTM & ISO Properties¹

	Nominal Value	Unit	Test Method
Physical			
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	2.10	cm ³ /10min	ISO 1133
Mechanical			
Tensile Modulus	377000	psi	ISO 527-2/1A
Tensile Stress (Yield)	9140	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	10	%	ISO 527-2/1A/50
Impact			
Charpy Notched Impact Strength (73°F)	3.6	ft·lb/in ²	ISO 179/1eA
Thermal			
Heat Deflection Temperature (264 psi, Unannealed)	214	°F	ISO 75-2/A
Melting Temperature ²	331	°F	ISO 11357-3

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	338 to 356	°F
Middle Temperature	356 to 374	°F
Front Temperature	356 to 374	°F
Nozzle Temperature	356 to 392	°F
Processing (Melt) Temp	356 to 392	°F
Mold Temperature	176 to 248	°F
Injection Rate	Slow	
Back Pressure	< 580	psi

Injection Notes

Zone4 temperature: 180 to 200°C

Notes

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

² 10°C/min

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