



YUNCON®M90

Acetal (POM) Copolymer

General			
Material Status	Standard-flow grade, with minimized mold deposit		
Features	<ul style="list-style-type: none"> • Acid Resistant • Bacteria Resistant • Base Resistant • Copolymer • Fatigue Resistant 	<ul style="list-style-type: none"> • Good Abrasion Resistance • Good Chemical Resistance • Good Dimensional Stability • Good Electrical Properties • Good Flow 	<ul style="list-style-type: none"> • High Hardness • High Stiffness • Low Friction • Low Warpage • Solvent Resistant
Uses	<ul style="list-style-type: none"> • Automotive Electronics • Automotive Exterior Parts • Automotive Under the Hood 	<ul style="list-style-type: none"> • Fittings • Gears • pining 	<ul style="list-style-type: none"> • Thin-walled Parts • Valves/Valve Parts • Wheels
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical properties	Value	Unit	Test Standard
Density	1.41	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16Kg)	9	g/10min	ISO 1133
Water Absorption (24 hr, 23°C)	0.6	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile Stress at yield	60	MPa	ISO 527-2
Tensile modulus	2600	MPa	ISO 527-2
Strain at break	35	%	ISO 527-2
Flexural strength	88	MPa	ISO 178
Flexural modulus	2500	MPa	ISO 178
Charpy notched impact strength	6	KJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Heat Deflection Temperature 1.8Mpa, Unannealed	95	°C	ISO 75

Flammability properties	Value	Unit	Test Standard
Flame Rating-UL	HB	class	UL94

Notes to users : Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data value.



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Recommended Injection Molding Conditions

- Material Drying : 80 – 90°C, 3-4 hours
- Cylinder Temperature:
 - Nozzle : 180 - 210 (°C)
 - Front Section : 190 – 210 (°C)
 - Center Section : 170 – 200 (°C)
 - Rear Section : 160 – 180 (°C)
- Melt Temperature : 180 – 210 (°C)
- Mold Temperature : 60 – 90 (°C)
(Precision parts are often molede at a mold at a mold temperature as high as 120°C)
- Pressure :
 - Injection Pressure 50 – 100 Mpa
 - Holding Pressure 30 – 80 Mpa
 - Back Pressure 0 – 0.5 MPa
- Screw Rotational Speed : 50 – 120 rpm

Recommended Extruded Conditions

- Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.
Melt temperature : 180 - 190°C

Acquried Certifications of Yuntianhua POM

- RoHS test
- PFOS test
- Certification FDA
- Certification UL
- Certification W18 test
- EN71-3 test