



### Celcon® M90 Technical Data

Property	Method	Value	Units
<b>Physical Properties</b>			
● Density	ISO 1183	1410	kg/m <sup>3</sup>
● Melt volume rate (MVR)	ISO 1133	8.5	cm <sup>3</sup> /10min
● Mold shrinkage - parallel	ISO 294-4	2.2	%
● Mold shrinkage - normal	ISO 294-4	2.0	%
● Water absorption (23°C-sat)	ISO 62	0.65	%
● Humidity absorption (23°C/50%RH)	ISO 62	0.2	%
<b>Mechanical Properties</b>			
● Tensile modulus (1mm/min)	ISO 527-2/1A	2780	MPa
● Tensile stress at yield (50mm/min)	ISO 527-2/1A	66	MPa
● Tensile creep modulus 1h	ISO 899-1	2450	MPa
● Tensile creep modulus 1000h	ISO 899-1	1350	MPa
● Flexural modulus (23°C)	ISO 178	2640	MPa
● Charpy notched impact strength @ 23°C	ISO 179/1eA	5.8	KJ/m <sup>2</sup>
● Notched impact strength (Izod) @ 23°C	ISO 180/1A	5.5	KJ/m <sup>2</sup>
<b>Thermal Properties</b>			
● Melting temperature (10 C/min)	ISO 11357-1,-2,-3	165	°C
● DTUL @ 1.8 MPa	ISO 75-1, -2	100	°C