



Phone: (517) 295-4196 Fax: (517) 295-4918

**Technical Data Sheet**  
**LCA® M-90 Type**  
**Acetal Copolymer, Unfilled**

Typical Compound Properties	Value / Measure		Test Methods
<b>Physical Properties</b>			
	English Units (ISO)	Metric Units	
Melt Flow Rate @ 190 / 2.16	9 g/10 min		ASTM D-1238
Density	1.4 g/cm3	1.4 g/cm3	ASTM D-792
Ash Content	%	0 %	ASTM D-5630
Linear Mold Shrinkage	0.022 in/in	mm/mm	ASTM D-955
<b>Mechanical Properties</b>			
Izod Impact - Notched	1.00 ft-lb/in (kJ/m2)	53 J/m	ASTM D-256
Tensile Strength @ Yield	8,000 psi (Mpa)	55 MPa	ASTM D-638
Tensile Strength @ Break	psi (Mpa)	0 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	30 %	30 %	ASTM D-638
Flexural Strength @ Yield	12,500 psi (Mpa)	86 MPa	ASTM D-790
Flexural Stress @ Break	psi (Mpa)	0 MPa	ASTM D-790
Flexural Stress @ 5% Strain	psi (Mpa)	0 MPa	ASTM D-790
Flexural Modulus	330,000 psi (Mpa)	2,277 MPa	ASTM D-790
<b>Thermal Properties</b>			
DTUL @ 66 psi (455 kPa)	Deg. F	Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	Deg. F	Deg. C	ASTM D-648
Vicat Softening Temperature	Deg. F	Deg. C	ASTM D-1525
Melt Point	331 Deg. F	166 Deg. C	ASTM D-789-92e1

All tests are performed on dry as molded ASTM (ISO) test bars.

**General Product Type Information**

The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplus, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

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<b>Typical Processing Conditions</b>			
Process Variable	Description	Values	
<b>Temperatures</b>		<b>F</b>	<b>C</b>
Barrel	Rear	340-360	
	Center	360-375	
	Front	360-380	
	Nozzle	375-400	
	Mold	170-200	
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<b>Drying</b>			
Type		Dehumidifier	
Temperature		180°F	
Time		2 - 4 hours	
Max. % Moisture			
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<b>Special Requirements</b>			
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Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.

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