



Celcon® CE66FC GV1/25

Celanese Corporation - Acetal (POM) Copolymer

Saturday, November 2, 2019

General Information

Product Description

Celcon® CE66FC GV1/25 is a 25% glass fiber coupled acetal copolymer grade. It offers higher strength than the standard Celcon CE66FC.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight		
Features	• Chemically Coupled	• Good Strength	
RoHS Compliance	• Contact Manufacturer		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.57	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	0.80	%	
Flow	0.40	%	
Water Absorption (Saturation, 73°F)	0.80	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.23E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	17400	psi	ISO 527-2/1A/5
Tensile Strain (Break)	2.5	%	ISO 527-2/1A/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	3.8	ft·lb/in ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	320	°F	ISO 75-2/A
Melting Temperature ²	331	°F	ISO 11357-3
CLTE - Flow	1.5E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	6.9E-5	in/in/°F	ISO 11359-2

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
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	194 to 248	°F
Injection Rate	Slow	
Back Pressure	< 290	
	psi	

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Injection Notes

Zone4 temperature: 190 to 200°C
Hot runner temperature: 190 to 210°C

Notes

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

² 10°C/min