



CELCON® ET-20R3 BK

CELCON®

- A CNT filled high-viscosity grade for general extrusion molding (rods, plates, sheets, etc.)
- Suitable for applications requiring surface resistivity 10³ Ohm
- Cautions: Surface resistivity will change with extrusion conditions: die design, pressure, seeed, etc.

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Resin Identification	POM-CD4		ISO 1043
Part Marking Code	>POM-CD4<		ISO 11469
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Rheological properties			
Melt mass-flow rate	0.3	g/10min	ISO 1133
Melt mass-flow rate, Temperature	190	°C	
Melt mass-flow rate, Load	2.16	kg	
Typical mechanical properties			
Tensile stress at yield, 50mm/min	55	MPa	ISO 527-1/-2
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Tensile strain at yield, 50mm/min Flexural modulus	2500		ISO 527-17-2 ISO 178
		MPa	
Flexural strength			ISO 178
Charpy notched impact strength, 23°C	3.5	kJ/m²	ISO 179/1eA
Thermal properties			
Melting temperature, 10°C/min	165	°C	ISO 11357-1/-3
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Flammability			
Burning Behav. at thickness h	НВ	class	IEC 60695-11-10
Thickness tested	0.8	mm	IEC 60695-11-10
Electrical properties			
Surface resistivity	1000	Ohm	IEC 62631-3-2
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Physical/Other properties			
Density	1370	kg/m³	ISO 1183
Density	1370	Kg/III	130 1163
Injection			

Injection

Drying Recommended	no
Drying Temperature	100 °C
Drying Time, Dehumidified Dryer	3-4 h
Processing Moisture Content	≤0.2 %
Melt Temperature Optimum	195 °C
Min. melt temperature	180 °C
Max. melt temperature	210 °C
Screw tangential speed	≤0.3 m/s
Mold Temperature Optimum	70 °C
Min. mould temperature	60 °C
Max. mould temperature	80 °C
Hold pressure range	60 - 120 MPa

Printed: 2025-05-30 Page: 1 of 2

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Characteristics

Processing Injection Moulding, Extrusion

Delivery form Pellets

Special characteristics Increased electrical conductivity

Printed: 2025-05-30 Page: 2 of 2

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