

CELCON® ET-20R7 BK

CELCON®

- A CNT (Carbon Nano Tube) filled anti-static grade for general extrusion molding (rods, plates, sheets, etc.)
- Suitable for electric and automotive parts requiring anti-static property
- Cautions: Surface resistivity will change with extrusion conditions: die design, pressure, speed, etc.

Product information

Resin Identification	POM-CD	ISO 1043
Part Marking Code	>POM-CD<	ISO 11469

Rheological properties

Melt mass-flow rate	4 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	52 MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	10 %	ISO 527-1/-2
Nominal strain at break	20 %	ISO 527-1/-2
Flexural modulus	2200 MPa	ISO 178
Flexural strength	72 MPa	ISO 178
Charpy notched impact strength, 23 °C	6 kJ/m ²	ISO 179/1eA

Thermal properties

Melting temperature, 10 °C/min	165 °C	ISO 11357-1/-3
Coefficient of linear thermal expansion (CLTE), parallel	90 E-6/K	ISO 11359-1/-2

Flammability

Burning Behav. at thickness h	HB class	IEC 60695-11-10
Thickness tested	0.8 mm	IEC 60695-11-10

Electrical properties

Surface resistivity	1E7 Ohm	IEC 62631-3-2
---------------------	---------	---------------

Physical/Other properties

Density	1370 kg/m ³	ISO 1183
---------	------------------------	----------

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

CELCON® ET-20R7 BK

CELCON®

Max. mould temperature
Hold pressure range

80 °C
60 - 120 MPa

Characteristics

Processing	Injection Moulding, Extrusion
Delivery form	Pellets