

CELCON® F25-03 LOF

CELCON®

- A Standard unfilled (medium-low viscosity) grade for general injection molding
- A low-emission grade featuring improved heat stability

Product information

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

Rheological properties

Melt mass-flow rate	13 g/10min	ISO 1133
Melt mass-flow rate, Temperature	190 °C	
Melt mass-flow rate, Load	2.16 kg	
Moulding shrinkage, parallel	2.0 %	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	2750 MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	65 MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	9 %	ISO 527-1/-2
Nominal strain at break	33 %	ISO 527-1/-2
Flexural modulus	2650 MPa	ISO 178
Charpy notched impact strength, 23 °C	6 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30 °C	5.5 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.366	

Thermal properties

Melting temperature, 10 °C/min	165 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	100 °C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	120 E-6/K	ISO 11359-1/-2

Electrical properties

Surface resistivity	>1E15 Ohm	IEC 62631-3-2
Electric strength	19 kV/mm	IEC 60243-1

Physical/Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Density	1410 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	185 °C
Min. melt temperature	180 °C
Max. melt temperature	190 °C
Screw tangential speed	≤0.3 m/s
Mold Temperature Optimum	70 °C

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Min. mould temperature	60 °C
Max. mould temperature	80 °C
Hold pressure range	60 - 120 MPa

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Special characteristics	Low emissions