



## CELCON® F30-34

#### **CELCON®**

CELCON® F30-34 is a low viscosity, high flow grade for injection molding with thin walled parts.

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Resin Identification Part Marking Code	POM >POM<	ISO 1043 ISO 11469
Rheological properties		
Melt mass-flow rate	36 g/10min	ISO 1133
Melt mass-flow rate, Temperature	190 °C	
NA district of the state of the	0.40 1	

Melt mass-flow rate, Temperature 2.16 kg Melt mass-flow rate, Load

ISO 294-4, 2577 Moulding shrinkage, parallel 2.0 %

#### Typical mechanical properties

Tensile stress at yield, 50mm/min	65	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	8	%	ISO 527-1/-2
Nominal strain at break	20	%	ISO 527-1/-2
Flexural modulus	2700	MPa	ISO 178
Flexural strength	90	MPa	ISO 178
Charpy notched impact strength, 23°C	5.5	kJ/m²	ISO 179/1eA

#### Thermal properties

Melting temperature, 10°C/min	165 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	101 °C	ISO 75-1/-2
Coefficient of linear thermal expansion	120 E-6/K	ISO 11359-1/-2
(CLTE), parallel		

#### **Electrical properties**

Electric strength 19 kV/mm IEC 60243-1

#### Physical/Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Density	1410 kg/m³	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
Max. mould temperature	80 °C
Hold pressure range	60 - 120 MPa

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#### Characteristics

Processing Injection Moulding

Delivery form Pellets

Special characteristics High Flow

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