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CELCON® CE66FC GV1/25

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

Product information

Resin Identification	POM-GF25	ISO 1043
Part Marking Code	>POM-GF25<	ISO 11469

Rheological properties

Moulding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.8	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	9100	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	130	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5	%	ISO 527-1/-2
Flexural modulus	8350	MPa	ISO 178
Flexural strength	200	MPa	ISO 178
Charpy impact strength, 23°C	45	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	9	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	7	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	9.6	kJ/m²	ISO 180/1A
Poisson's ratio	0.34[C]		

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	160	°C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	27	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	125	E-6/K	ISO 11359-1/-2

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Water absorption, 2mm	0.8	%	Sim. to ISO 62
Density	1580	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	190	°C
Min. melt temperature	180	°C
Max. melt temperature	200	°C
Screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	105	°C
Min. mould temperature	90	°C

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Max. mould temperature	120	°C
Hold pressure range	60 - 120	MPa
Back pressure	2	MPa

Characteristics

Processing	Injection Moulding, Extrusion, Other Extrusion
Delivery form	Pellets

Additional information

Processing Notes

Pre-Drying

Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying may be necessary to prevent splay and odor problems.

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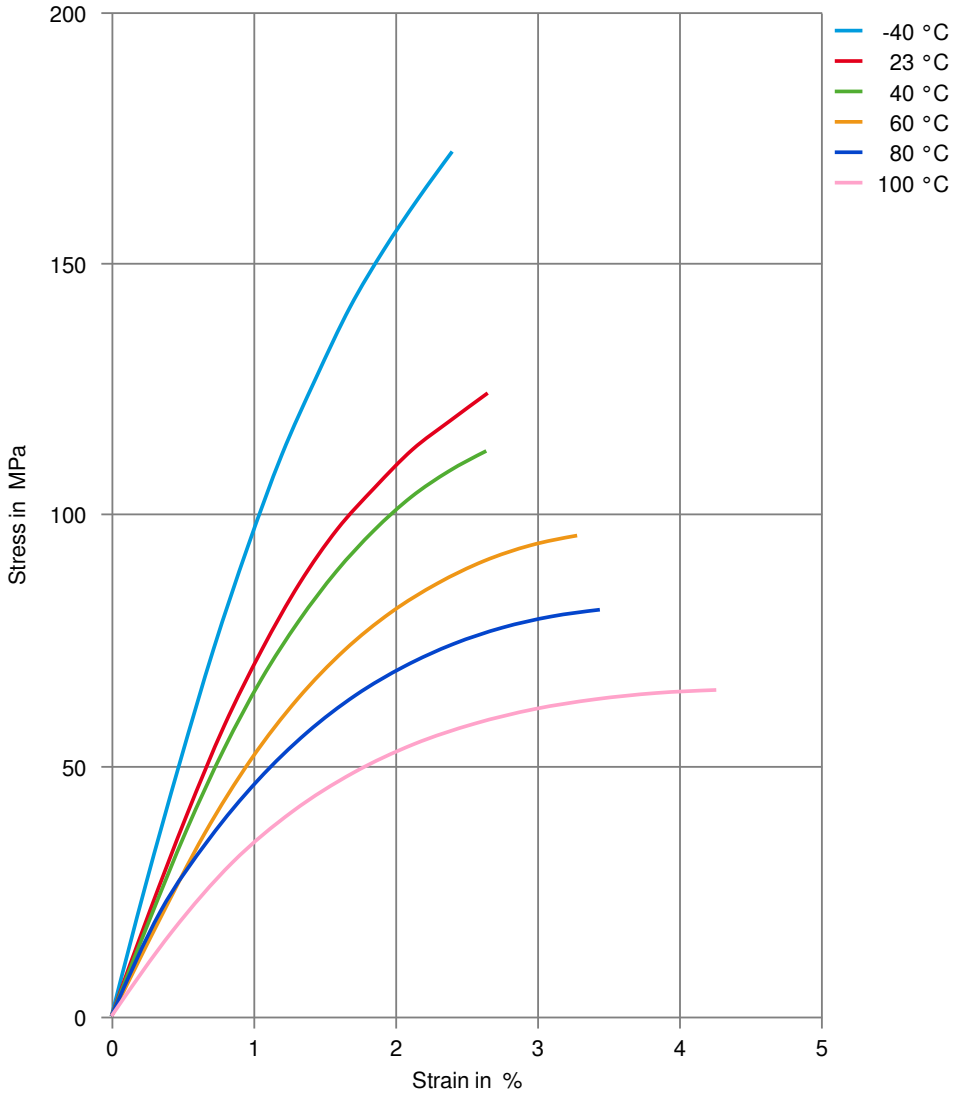
Stress-strain



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Secant modulus-strain