

# CELCON® F25-03H

## CELCON®

- A stiffness-improved (medium-viscosity) grade for general injection molding.
- It has a high stiffness compared to general POM copolymer

### 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	

### Typical mechanical properties

Tensile modulus	2850 MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	68 MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	10 %	ISO 527-1/-2
Nominal strain at break	31 %	ISO 527-1/-2
Flexural modulus	2800 MPa	ISO 178
Flexural strength	94 MPa	ISO 178
Charpy notched impact strength, 23 °C	6.5 kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30 °C	6 kJ/m <sup>2</sup>	ISO 179/1eA
Poisson's ratio	0.37 <sup>[C]</sup>	

[C]: Calculated

### Thermal properties

Melting temperature, 10 °C/min	170 °C	ISO 11357-1/-3
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### Electrical properties

Volume resistivity	1E12 Ohm.m	IEC 62631-3-1
Surface resistivity	1E16 Ohm	IEC 62631-3-2

### Physical/Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Density	1410 kg/m <sup>3</sup>	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

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Max. mould temperature  
Hold pressure range

80 °C  
60 - 120 MPa

### Characteristics

Processing Injection Moulding  
Delivery form Pellets

### Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
General Motors	GMW22P-POM-C3	Natural
General Motors	GMW22P-POM-C3	Black
Stellantis	B62 0300 / 61/207E/206M+/H506E/H706	01994_13_00033