

CELCON® F10-01 T2

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CELCON® F10-01 T2 is a high-viscosity grade for extrusion of round bars, sheets and tubes Suitable for uses requiring high productivity without micro porosity for large diameter rods and plates.

Product information

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

Rheological properties

Melt mass-flow rate	3 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 stress at yield, 50mm/min	61 MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	10 %	ISO 527-1/-2
Nominal strain at break	30 %	ISO 527-1/-2
Flexural modulus	2200 MPa	ISO 178
Flexural strength	80 MPa	ISO 178
Charpy notched impact strength, 23 °C	8 kJ/m ²	ISO 179/1eA

Thermal properties

Melting temperature, 10 °C/min	165 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	90 °C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	120 E-6/K	ISO 11359-1/-2

Flammability

Burning Behav. at thickness h	HB class	IEC 60695-11-10
Thickness tested	3 mm	IEC 60695-11-10

Electrical properties

Electric strength	19 kV/mm	IEC 60243-1
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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	195 °C
Min. melt temperature	180 °C
Max. melt temperature	210 °C
Screw tangential speed	≤0.3 m/s

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Mold Temperature Optimum	70 °C
Min. mould temperature	60 °C
Max. mould temperature	80 °C
Hold pressure range	60 - 120 MPa

Characteristics

Processing	Injection Moulding, Extrusion, Other Extrusion
Delivery form	Pellets