

CELCON[®] F10-02

CELCON®

- A high-viscosity grade for extrusion of round bars, sheets and tubes

- Suitable for extrusion molding of thick-walled, void-free, and sink mark-reduced parts

Product information						
Resin Identification Part Marking Code	POM >POM<		ISO 1043 ISO 11469			
Rheological properties						
Melt mass-flow rate Melt mass-flow rate, Temperature Melt mass-flow rate, Load	190 2.16	kg	ISO 1133			
Moulding shrinkage, parallel	2.0	%	ISO 294-4, 2577			
Typical mechanical properties						
Tensile modulus Tensile stress at yield, 50mm/min Tensile strain at yield, 50mm/min Nominal strain at break Flexural modulus Flexural strength Charpy notched impact strength, 23°C Charpy notched impact strength, -30°C Poisson's ratio [C]: Calculated	10 32 2400 84 8	MPa % %	ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 178 ISO 178 ISO 179/1eA ISO 179/1eA			
Thermal properties						
Melting temperature, 10 °C/min Temperature of deflection under load, 1.8 MPa Coefficient of linear thermal expansion (CLTE), parallel Coefficient of linear thermal expansion (CLTE),	120	°C °C E-6/K E-6/K	ISO 11357-1/-3 ISO 75-1/-2 ISO 11359-1/-2 ISO 11359-1/-2			
normal Flammability						
Burning Behav. at thickness h Thickness tested		class mm	IEC 60695-11-10 IEC 60695-11-10			
Electrical properties						
Volume resistivity Surface resistivity Electric strength	1E16	Ohm.m Ohm kV/mm	IEC 62631-3-1 IEC 62631-3-2 IEC 60243-1			
Physical/Other properties						
Water absorption, 2mm Density	0.2 1410	% kg/m³	Sim. to ISO 62 ISO 1183			

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Injection

Drying Recommended	no	
Drying Temperature	100 °	С
Drying Time, Dehumidified Dryer	3-4 h	
Processing Moisture Content	≤0.2 %	ว
Melt Temperature Optimum	195 °	С
Min. melt temperature	180 °	С
Max. melt temperature	210 °	С
Screw tangential speed	≤0.3 m	n/s
Mold Temperature Optimum	70 °	С
Min. mould temperature	60 °	С
Max. mould temperature	80 °	С
Hold pressure range	60 - 120 N	IPa

Characteristics

Processing	Injection Moulding, Extrusion, Sheet Extrusion, Other Extrusion		
Delivery form	Pellets		
Automotive			
OEM	STANDARD	ADDITIONAL INFORMATION	
Hyundai	MS237-05 Type B	Pyeongtaek,Korea	

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