

# CELCON® F10-52D

## CELCON®

- A UV-stabilized high-viscosity grade for general injection molding.

### 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	2.2 %	ISO 294-4, 2577

### Typical mechanical properties

Tensile strain at yield, 50mm/min	9 %	ISO 527-1/-2
Tensile stress at break, 50mm/min	55 MPa	ISO 527-1/-2
Nominal strain at break	42 %	ISO 527-1/-2
Flexural modulus	2250 MPa	ISO 178
Flexural strength	75 MPa	ISO 178
Charpy notched impact strength, 23 °C	8 kJ/m <sup>2</sup>	ISO 179/1eA
Poisson's ratio	0.391	

### 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	130 E-6/K	ISO 11359-1/-2

### Electrical properties

Volume resistivity	1E16 Ohm.m	IEC 62631-3-1
Surface resistivity	1E16 Ohm	IEC 62631-3-2
Electric strength	19 kV/mm	IEC 60243-1

### Physical/Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Density	1370 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, Extrusion
Delivery form	Pellets
Special characteristics	U.V. stabilised or stable to weather