



CELCON® F15-33

CELCON®

CELCON® F15-33 is a toughness-improved (medium-high viscosity) grade for general injection molding. Features improved molding cycle time.

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

Rheological properties

Melt mass-flow rate	6	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 modulus	2600	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	64	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	10	%	ISO 527-1/-2
Nominal strain at break	34	%	ISO 527-1/-2
Flexural modulus	2450	MPa	ISO 178
Flexural strength	85	MPa	ISO 178
Charpy notched impact strength, 23°C	7	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	_	kJ/m²	ISO 179/1eA
Poisson's ratio	0.38 ^[C]		

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	165	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	96	°C	ISO 75-1/-2
Coefficient of linear thermal expansion	120	E-6/K	ISO 11359-1/-2
(CLTE), parallel			

Electrical properties

Electric strength 19	9 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 Optimum70 °CMin. mould temperature60 °CMax. mould temperature80 °CHold pressure range60 - 120 MPa

Characteristics

Processing Injection Moulding

Delivery form Pellets

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