



CELCON® F20-02

CELCON®

- A medium-viscosity grade for general injection molding

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

Rheological properties

Melt mass-flow rate	9 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	2750	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	65	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	10	%	ISO 527-1/-2
Nominal strain at break	32	%	ISO 527-1/-2
Flexural modulus	2550	MPa	ISO 178
Flexural strength	87	MPa	ISO 178
Charpy notched impact strength, 23°C	6.5	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C		kJ/m²	ISO 179/1eA
Poisson's ratio	0.37 ^[C]		

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	165 °C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	100 °C	ISO 75-1/-2
Coefficient of linear thermal expansion	120 E-6/K	ISO 11359-1/-2
(CLTE), parallel		

Electrical properties

Volume resistivity	1E12 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	1410 kg/m³	ISO 1183

Injection

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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

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Revised: 2025-01-23 Source: Celanese Materials Database





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Screw tangential speed \leq 0.3 m/sMold Temperature Optimum70 °CMin. mould temperature60 °CMax. mould temperature80 °CHold pressure range60 - 120 MPa

Characteristics

Processing Injection Moulding

Delivery form Pellets

Automotive

OEM STANDARD ADDITIONAL INFORMATION

Geely Q/JLY J7110235B-2018(2)

Hyundai MS237-09 Type A Ulsan, Korea

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