

# CELCON® F20-03 Colored

## CELCON®

CELCON® F20-03 Colored is a medium-viscosity grade for general injection molding (colored). A general grade for injection molding applications.

### Product information

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

### Rheological properties

Melt mass-flow rate	10 g/10min	ISO 1133
Melt mass-flow rate, Temperature	190 °C	
Melt mass-flow rate, Load	2.16 kg	

### Typical mechanical properties

Tensile stress at yield, 50mm/min	63 MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	8.5 %	ISO 527-1/-2
Nominal strain at break	32 %	ISO 527-1/-2
Flexural modulus	2600 MPa	ISO 178
Flexural strength	87 MPa	ISO 178
Charpy notched impact strength, 23 °C	6.5 kJ/m <sup>2</sup>	ISO 179/1eA

### Thermal properties

Melting temperature, 10 °C/min	165 °C	ISO 11357-1/-3
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### Flammability

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

### Physical/Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Density	1410 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
Max. mould temperature	80 °C
Hold pressure range	60 - 120 MPa

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### Characteristics

Processing	Injection Moulding
Delivery form	Pellets

### Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Hyundai	MS237-09 Type A	Ulsan, Korea