



CELCON® F25-03

CELCON®

CELCON® F25-03 is a medium-low 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	13 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	9	%	ISO 527-1/-2
Nominal strain at break	31	%	ISO 527-1/-2
Flexural modulus	2650	MPa	ISO 178
Charpy notched impact strength, 23°C	6	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	5.5	kJ/m²	ISO 179/1eA
Poisson's ratio	0.379		

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		

Flammability

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

Electrical properties

	Electric strength	19 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

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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

Hyundai MS237-14 Type A Ulsan, Korea

Renault EP03-3-S1, Ulsan, Korea, Bumper Technical

Parts, No Spec, Special Part Approval, See

Your CE Account Manager.

Renault IP13f-S5, Ulsan, Korea, Seat Handles, No

Spec, Special Part Approval, See Your CE

Account Manager.

Renault IP13g-S3, Ulsan, Korea, Seat Component, No

Spec, Special Part Approval, See Your CE

Account Manager.

Renault UB03f-S1, Ulsan, Korea, Fuel Supply System,

No Spec, Special Part Approval, See Your CE

Account Manager.

Stellantis B62 0300 / 61/207E/207M/H507E 01994_19_00367

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