Celanese
The chemistry inside innovation™

CELCON® F25-03H

CELCON®

- A stiffness-improved(medium-viscosity) grade for general injection molding.
- It has a high stiffness compared to general POM copolymer

Product information

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	

Typical mechanical properties

Tensile modulus	2850	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	68	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	10	%	ISO 527-1/-2
Nominal strain at break	31	%	ISO 527-1/-2
Flexural modulus	2800	MPa	ISO 178
Flexural strength	94	MPa	ISO 178
Charpy notched impact strength, 23°C	6.5	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	6	kJ/m²	ISO 179/1eA
Poisson's ratio	0.37[C]		

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	170	°C	ISO 11357-1/-3

Electrical properties

Volume resistivity	1E12	Ohm.m	IEC 62631-3-1
Surface resistivity	1E16	Ohm	IEC 62631-3-2

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Density	1410	kg/m³	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	80 °C
Hold pressure range	60 - 120 MPa

Characteristics

Processing	Injection Moulding
Delivery form	Pellets

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
General Motors	GMW22P-POM-C3	Natural
General Motors	GMW22P-POM-C3	Black
Stellantis	B62 0300 / 61/207E/206M+/H506E/H706	01994_13_00033

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