

CELCON[®] F30-03 LOF

CELCON®

- A low-viscosity grade for general injection molding.
- A low-emission grade featuring thermal stability.
- Suitable for multi-cavity molds and thin-walled part.

Product information Resin Identification	POM		ISO 1043
Part Marking Code	>POM<		ISO 11469
Rheological properties			
Melt mass-flow rate		g/10min	ISO 1133
Melt mass-flow rate, Temperature Melt mass-flow rate, Load	190 2.16		
Moulding shrinkage, parallel	2.0	•	ISO 294-4, 2577
Typical mechanical properties			
Tensile modulus	2850	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min		MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min		%	ISO 527-1/-2
Nominal strain at break	25		ISO 527-1/-2
Flexural modulus Charpy notched impact strength, 23°C	2700	MPa kJ/m ²	ISO 178 ISO 179/1eA
Charpy notched impact strength, -30°C		kJ/m ²	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	101		ISO 75-1/-2
Coefficient of linear thermal expansion	120	E-6/K	ISO 11359-1/-2
(CLTE), parallel Electrical properties			
	>1E15	Ohm	
Surface resistivity Electric strength		kV/mm	IEC 62631-3-2 IEC 60243-1
-			
Physical/Other properties		2 /	
Humidity absorption, 2mm Density	0.2	% kg/m³	Sim. to ISO 62 ISO 1183
	1410	Ng/III	100 1103
Injection			
Drying Recommended	no		
Drying Temperature	100 3 - 4		
Drying Time, Dehumidified Dryer Processing Moisture Content	3-4 ≤0.2		
Melt Temperature Optimum	185		
Min. melt temperature	180	°C	
Max. melt temperature	190	°C	

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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

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Special characteristics	High Flow, Low emissions

Automotive

OEM General Motors STANDARD GMW22P-POM-C4 ADDITIONAL INFORMATION Natural

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