Celanese
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CELCON® F40-03 Colored

CELCON®

CELCON® F40-03 Colored is a standard unfilled(extremely low-viscosity) grade for general injection molding (colored). Suitable for multi-cavity molds and thin-walled precision parts

Product information

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

Rheological properties

Melt mass-flow rate	50	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 stress at yield, 50mm/min	65	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	7	%	ISO 527-1/-2
Nominal strain at break	20	%	ISO 527-1/-2
Flexural modulus	2750	MPa	ISO 178
Flexural strength	93	MPa	ISO 178
Charpy notched impact strength, 23°C	3.5	kJ/m²	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	165	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	101	°C	ISO 75-1/-2

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/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
Max. mould temperature	80	°C
Hold pressure range	60 - 120	MPa

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Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Special characteristics	High Flow

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