

CELCON[®] F40-03

CELCON®

- A standard unfilled(extremely low-viscosity) grade for general injection molding

- Suitable for multi-cavity molds and thin-walled precision parts

Product information			
Resin Identification Part Marking Code	POM >POM<		ISO 1043 ISO 11469
Rheological properties			
Melt mass-flow rate Melt mass-flow rate, Temperature Melt mass-flow rate, Load	45 190 2.16		ISO 1133
Moulding shrinkage, parallel	2.0	•	ISO 294-4, 2577
Typical mechanical properties			
Tensile modulus Tensile stress at yield, 50mm/min Tensile strain at yield, 50mm/min Nominal strain at break Flexural modulus Flexural strength Charpy notched impact strength, 23°C Charpy notched impact strength, -30°C Poisson's ratio [C]: Calculated	7 20 2750 90 5	MPa % %	ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 178 ISO 178 ISO 179/1eA ISO 179/1eA
Thermal properties			
Melting temperature, 10°C/min Temperature of deflection under load, 1.8 MPa Coefficient of linear thermal expansion (CLTE), parallel Electrical properties	165 101 120		ISO 11357-1/-3 ISO 75-1/-2 ISO 11359-1/-2
Volume resistivity		Ohm.m	IEC 62631-3-1
Surface resistivity Electric strength	1E16 19	Ohm kV/mm	IEC 62631-3-2 IEC 60243-1
Physical/Other properties			
Humidity absorption, 2mm Density	0.2 1410	% kg/m³	Sim. to ISO 62 ISO 1183
Injection			
Drying Recommended Drying Temperature	no 100	°C	
Drying Time, Dehumidified Dryer	3 - 4	h	
Processing Moisture Content Melt Temperature Optimum Min. melt temperature	≤0.2 195 180	°C	

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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

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Special characteristics	High Flow

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