CELCON® AR-15

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A medium-viscosity grade for general injection molding
Designed for applications requiring acid resistance

Product information

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

Rheological properties

Melt mass-flow rate	6.5	g/10min	ISO 1133

Typical mechanical properties

Tensile stress at yield, 50mm/min	8700	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	10	%	ISO 527-1/-2
Nominal strain at break	35	%	ISO 527-1/-2
Flexural modulus	341000	psi	ISO 178
Flexural strength	10900	psi	ISO 178
Charpy notched impact strength, 23 °C	3.33	ftlb/in²	ISO 179/1eA

Thermal properties

Melting temperature, 10 °C/min	329	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	194	°F	ISO 75-1/-2

Flammability

Burning Behav. at thickness h	HB	class	IEC 60695-11-10

Electrical properties

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

Injection

Drying Recommended	no	
Drying Temperature	212	°F
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	383	°F
Min. melt temperature	356	°F
Max. melt temperature	410	°F
Max. screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	158	°F
Min. mold temperature	140	°F
Max. mold temperature	176	°F
Hold pressure range	8700 - 17400	psi
Hold Pressure Time (h is the max. wall thickness of the part in mm)	2h²-3	s

Revised: 2026-05-20 Source: Celanese Materials Database

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Characteristics

Processing	Injection Molding

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