CELCON® CE66FC GV1/25

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Celcon® CE66FC GV1/25 is a 25% glass fiber coupled acetal copolymer grade. It offers higher strength than the standard Celcon® CE66FC.

Product information

Resin Identification	POM-GF25	ISO 1043
Part Marking Code	>POM-GF25<	ISO 11469

Rheological properties

Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	1.32E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	18900	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5	%	ISO 527-1/-2
Flexural modulus	1.21E6	psi	ISO 178
Flexural strength	28300	psi	ISO 178
Charpy impact strength, 23°C	21.4	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23°C	4.28	ftlb/in²	ISO 179/1eA
Charpy notched impact strength, -30°C	3.33	ftlb/in²	ISO 179/1eA
Izod notched impact strength, 23°C	4.57	ftlb/in²	ISO 180/1A

Thermal properties

Melting temperature, 10°C/min	331	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	320	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.15	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.694	E-4/°F	ISO 11359-1/-2

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Water absorption, 2mm	0.8	%	Sim. to ISO 62
Density	0.057	lb/in³	ISO 1183

Injection

Drying Recommended	no	
Drying Temperature	212	°F
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	374	°F
Min. melt temperature	356	°F
Max. melt temperature	392	°F
Max. screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	221	°F
Min. mold temperature	194	°F
Max. mold temperature	248	°F
Hold pressure range	8700 - 17400	psi

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Hold Pressure Time (h is the max. wall thickness of the part in mm)	$2h^2$-3	s
Back pressure	290	psi

Characteristics

Processing	Injection Molding, Extrusion, Other Extrusion

Additional information

Processing Notes

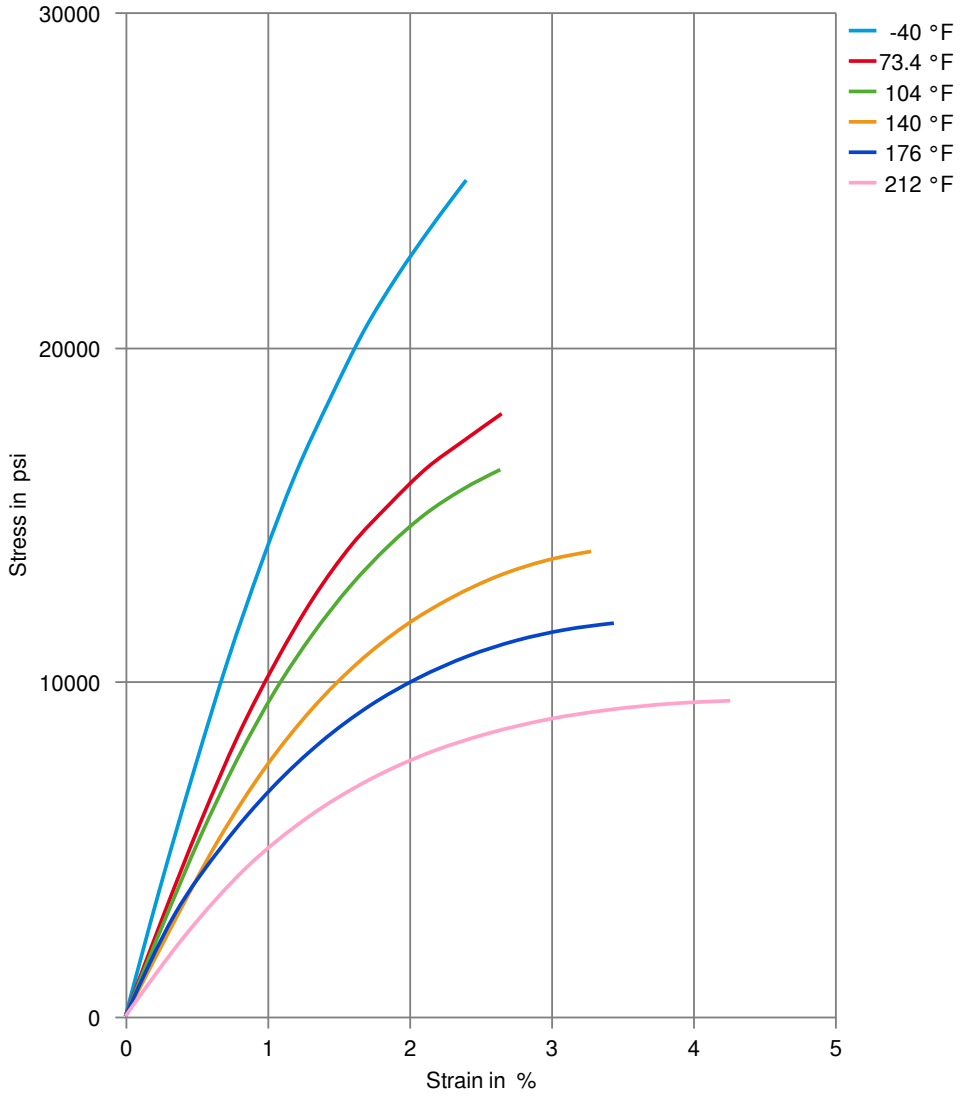
Pre-Drying

Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying may be necessary to prevent splay and odor problems.

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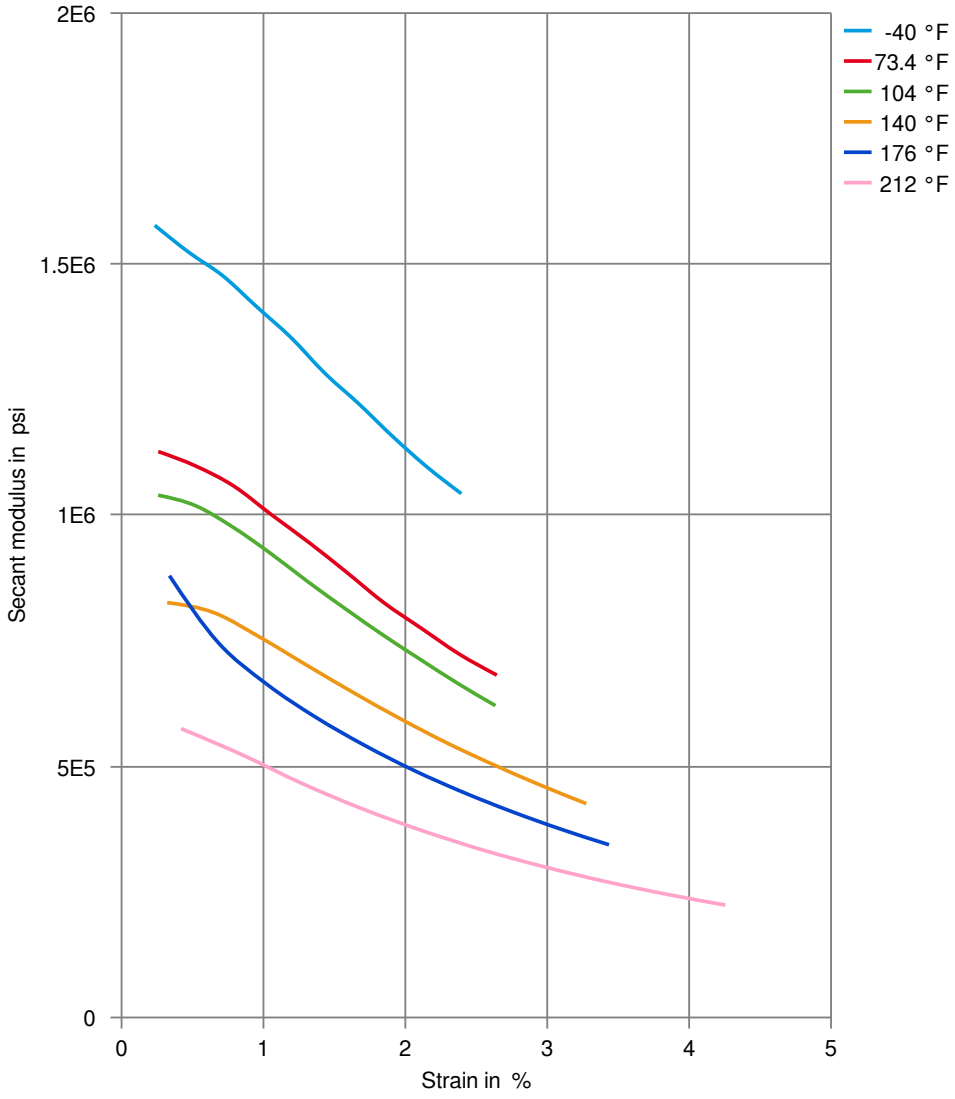
Stress-strain



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Secant modulus-strain



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