CELCON® F10-01 T2

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CELCON® F10-01 T2 is a high-viscosity grade for extrusion of round bars, sheets and tubes Suitable for uses requiring high productivity without micro porosity for large diameter rods and plates.

Product information

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

Rheological properties

Melt mass-flow rate	3	g/10min	ISO 1133
Melt mass-flow rate, Temperature	374	°F	
Melt mass-flow rate, Load	4.76	lb	
Molding shrinkage, parallel	2.0	%	ISO 294-4, 2577

Typical mechanical properties

Tensile stress at yield, 50mm/min	8800	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	10	%	ISO 527-1/-2
Nominal strain at break	30	%	ISO 527-1/-2
Flexural modulus	319000	psi	ISO 178
Flexural strength	11600	psi	ISO 178
Charpy notched impact strength, 23°C	3.81	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
Coefficient of linear thermal expansion (CLTE), parallel	0.67	E-4/°F	ISO 11359-1/-2

Flammability

Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.1181	in	IEC 60695-11-10

Electrical properties

Electric strength	483	kV/in	IEC 60243-1

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Density	0.0509	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	383	°F
Min. melt temperature	356	°F
Max. melt temperature	410	°F
Max. screw tangential speed	≤0.3	m/s

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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)	$2h^2$-3	s

Characteristics

Processing	Injection Molding, Extrusion, Other Extrusion
Special characteristics	High viscosity

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