CELCON® F25-03H

CELCON®

- A stiffness-improved(medium-viscosity) grade for general injection molding.
- It has a high stiffness compared to general POM copolymer

Product information

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

Rheological properties

Melt mass-flow rate	13	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 modulus	413000	psi	ISO 527-1/-2
Tensile stress at yield, 50mm/min	9900	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	10	%	ISO 527-1/-2
Nominal strain at break	31	%	ISO 527-1/-2
Flexural modulus	406000	psi	ISO 178
Flexural strength	13600	psi	ISO 178
Charpy notched impact strength, 23°C	3.09	ftlb/in^2	ISO 179/1eA
Charpy notched impact strength, -30°C	2.85	ftlb/in^2	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	338	°F	ISO 11357-1/-3

Electrical properties

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

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Density	0.0509	lb/in^3	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
Mold Temperature Optimum	158	°F
Min. mold temperature	140	°F
Max. mold temperature	176	°F

Revised: 2026-08-18 Source: Celanese Materials Database

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Hold pressure range	8700 - 17400	psi
Hold Pressure Time (h is the max. wall thickness of the part in mm)	$2h^2$-3	s

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
General Motors	GMW22P-POM-C3	Natural
General Motors	GMW22P-POM-C3	Black
Stellantis	B62 0300 / 61/207E/206M+/H506E/H706	01994_13_00033

Characteristics

Processing	Injection Molding

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