CELCON® F40-52 SM

CELCON®

- A low-viscosity metallic grade for general injection molding
- Designed for applications eliminating the secondary processing such as painting and plating
- Suitable for applications requiring UV stability such asdoor handle, clip and cosmetic container cap

Product information

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

Rheological properties

Melt mass-flow rate	45	g/10min	ISO 1133
Melt mass-flow rate, Temperature	374	°F	
Melt mass-flow rate, Load	4.76	lb	

Typical mechanical properties

Tensile stress at yield, 50mm/min	8000	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	6	%	ISO 527-1/-2
Nominal strain at break	8	%	ISO 527-1/-2
Flexural modulus	406000	psi	ISO 178
Flexural strength	11600	psi	ISO 178
Charpy notched impact strength, 23°C	1.43	ftlb/in^2	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	329	°F	ISO 11357-1/-3

Flammability

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

Electrical properties

Volume resistivity	1E14	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

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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
Special characteristics	U.V. stabilized or stable to weather, Specialty appearance, High Flow

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