CELCON® FG1025 N012

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CELCON® FG1025 N012 is a 25% glass fiber-reinforced grade (a high-viscosity grade) for general injection molding (grey-colored). Suitable for parts requiring extremely high strength, high stiffness, high deflection temperature and excellent creep resistance.

Product information

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

Rheological properties

Melt mass-flow rate	4.2	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 break, 5mm/min	23500	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.2	%	ISO 527-1/-2
Flexural modulus	1.28E6	psi	ISO 178
Flexural strength	34800	psi	ISO 178
Charpy notched impact strength, 23°C	4.76	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	324	°F	ISO 75-1/-2

Flammability

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

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Density	0.0574	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
Mold Temperature Optimum	158	°F
Min. mold temperature	140	°F
Max. mold temperature	176	°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

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Stellantis	B62 0300 / 61/208M+/211E+/H708+(Grease)	01994_17_00012

Characteristics

Processing	Injection Molding

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