CELCON® FG1025

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CELCON® FG1025 is a 25% glass fiber filled high viscosity grade. KEPITAL®FG1025 is suited for parts requiring very high stiffness, creep resistance, and HDT.

Product information

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

Typical mechanical properties

Tensile stress at break, 5mm/min	22500	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5	%	ISO 527-1/-2
Flexural modulus	1.2E6	psi	ISO 178
Flexural strength	31900	psi	ISO 178
Charpy notched impact strength, 23°C	4.76	ftlb/in^2	ISO 179/1eA

Thermal properties

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

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Density	0.0574	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
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
Ford	WSS-M98P14-A3	ASN 9900

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Characteristics

Processing	Injection Molding

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