CELCON® FG2025K LOF

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CELCON® FG2025K LOF is a 10% glass fiber-reinforced grade for general injection molding.
Suitable for parts requiring extremely high strength, high stiffness, high deflection temperature, and excellent creep resistance.
Low emission grade featuring heat stability.

Product information

Resin Identification	POM-GF10	ISO 1043
Part Marking Code	>POM-GF10<	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	1.0	%	ISO 294-4, 2577

Typical mechanical properties

Tensile stress at break, 5mm/min	16000	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.1	%	ISO 527-1/-2
Flexural modulus	689000	psi	ISO 178
Flexural strength	23200	psi	ISO 178
Charpy notched impact strength, 23°C	3	ftlb/in²	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	329	°F	ISO 11357-1/-3
Coefficient of linear thermal expansion (CLTE), parallel	0.33	E-4/°F	ISO 11359-1/-2

Flammability

Burning Behav. at 1.5mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	0.0591	in	IEC 60695-11-10
UL recognition	yes		UL 94
Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.1181	in	IEC 60695-11-10
UL recognition	yes		UL 94

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	0.0531	lb/in³	ISO 1183

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Injection

Drying Recommended	no	
Drying Temperature	212	°F
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	365	°F
Min. melt temperature	356	°F
Max. melt temperature	374	°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
Hyundai	MS237-12 Type E	Pyeongtaek,Korea

Characteristics

Processing	Injection Molding
Special characteristics	Low emissions

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