CELCON® FT2020

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CELCON® FT2020 is a 20% whisker filled grade for general injection molding. Suitable for parts parts requiring much higher stiffness, dimensional accuracy, and low warpage.

Product information

Resin Identification	POM-MH20	ISO 1043
Part Marking Code	>POM-MH20<	ISO 11469

Rheological properties

Melt mass-flow rate	15	g/10min	ISO 1133
Melt mass-flow rate, Temperature	374	°F	
Melt mass-flow rate, Load	4.76	lb	
Molding shrinkage, parallel	0.9	%	ISO 294-4, 2577

Typical mechanical properties

Tensile stress at break, 5mm/min	12500	psi	ISO 527-1/-2
Nominal strain at break	2.7	%	ISO 527-1/-2
Flexural modulus	696000	psi	ISO 178
Flexural strength	21200	psi	ISO 178
Charpy notched impact strength, 23°C	1.71	ftlb/in^2	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	329	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	306	°F	ISO 75-1/-2

Physical/Other properties

Humidity absorption, 2mm	0.23	%	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

Revised: 2026-04-22 Source: Celanese Materials Database

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Characteristics

Processing	Injection Molding
Special characteristics	Low Warpage

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