CELCON® GC25T

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Celcon® GC25T is a 25% glass fiber coupled acetal copolymer grade. It offers higher strength than Celcon® GC25A. Celcon® GC25T is also exceptionally resistant to fuel. It offers excellent resistance to transportation fuels especially oxygenated fuels. Chemical abbreviation according to ISO 1043-1: POM

Product information

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

Rheological properties

Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	1.5	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	1.26E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	18100	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.7	%	ISO 527-1/-2
Flexural modulus	1.23E6	psi	ISO 178
Flexural strength	27600	psi	ISO 178
Compressive strength	26300	psi	ISO 604
Compressive stress at 1% strain	9720	psi	ISO 604
Charpy impact strength, 23°C	23.8	ftlb/in^2	ISO 179/1eU
Charpy impact strength, -30°C	26.2	ftlb/in^2	ISO 179/1eU
Charpy notched impact strength, 23°C	4.14	ftlb/in^2	ISO 179/1eA
Charpy notched impact strength, -30°C	3.43	ftlb/in^2	ISO 179/1eA
Izod notched impact strength, 23°C	3.81	ftlb/in^2	ISO 180/1A
Poisson's ratio	0.41		

Thermal properties

Melting temperature, 10°C/min	329	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	322	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.15	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.694	E-4/°F	ISO 11359-1/-2

Flammability

FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	2.36	in/min	ISO 3795 (FMVSS 302)

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Water absorption, 2mm	0.8	%	Sim. to ISO 62
Density	0.057	lb/in^3	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	374	°F
Min. melt temperature	356	°F
Max. melt temperature	392	°F
Max. screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	221	°F
Min. mold temperature	194	°F
Max. mold temperature	248	°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
Back pressure	290	psi

Characteristics

Processing	Injection Molding, Extrusion, Other Extrusion

Additional information

Injection molding

Preprocessing

Drying is generally not required because Celcon materials are not hydroscopic nor are they degraded by moisture during processing. Excessive moisture can lead to splay (silver streaking) in molded parts. For better uniformity in molding especially when using regrind or material that has been stored in containers open to the atmosphere, recommended drying conditions are 80 C (180 F) for three hours. Desiccant hopper dryers are not required. Max. water content = 0.35%.

Processing

Standard reciprocating screw injection molding machines with a high compression screw (minimum 3:1 and preferably 4:1) and low back pressure (0.35 Mpa/50 PSI) are favored. Using a low compression screw (i.e.- general purpose 2:1 compression ratio) can result in unmelted particles and poor melt homogeneity. Using a high back pressure to make up for a low compression ratio may lead to excessive shear heating and deterioration of the Celcon material.

Melt temperature: preferred range 182-199 C (360-390 F) Melt temperature should never exceed 230 C (450 F).Mold surface temperature: preferred range 93-121 C (200-250 F) especially with wall thickness less than 1.5 mm (0.060 in.). May require mold temperature as high as 120 C (250 F) to reproduce mold surface or to assure minimal molded in stress. Wall thickness greater than 3 mm (1/8 in.) may use a cooler (65 C/150 F) mold surface temperature and wall thickness over 6 mm (1/4 in.) may use a cold mold surface down to 25 C (80 F). In general, mold surface temperatures lower than 82 C (180 F) may produce a hazy surface or a surface with flow lines, pits and other included defects.

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Other extrusion

Postprocessing

Postprocessing conditioning and moisturizing not required. It may be necessary to fixture large or complicated parts with varying wall thickness to prevent warpage while cooling to ambient temperature.

Preprocessing

Drying is generally not required because Celcon materials are not hydroscopic nor are they degraded by moisture during processing. Excessive moisture can cause surface defects. For better uniformity especially when using regrind or material that has been stored in containers open to the atmosphere, recommended drying is 3 hours at 80 C (180 F). Desiccant hopper dryers are not required. Max. moisture content = 0.35%

Processing

Standard extruders with a length to diameter ratio of at least 20:1 are recommended. The screw should be a high compression ratio of at least 3:1 and preferably 4:1 to assure good melting and uniform melt homogeneity. The design should be approximately 35% each for the feed and metering sections with the remaining 30% as transition zone.

Melt temperature 180-220 C (355-430F)

Postprocessing

Postprocessing conditioning or moisturizing are not required. For thick walled sections (>3mm or 1/8 in.), annealing is recommended to reduce internal stresses.

Annealing temperature: 130-140 C (265-285 F)

Annealing time: 10 min/mm thickness

Processing Notes

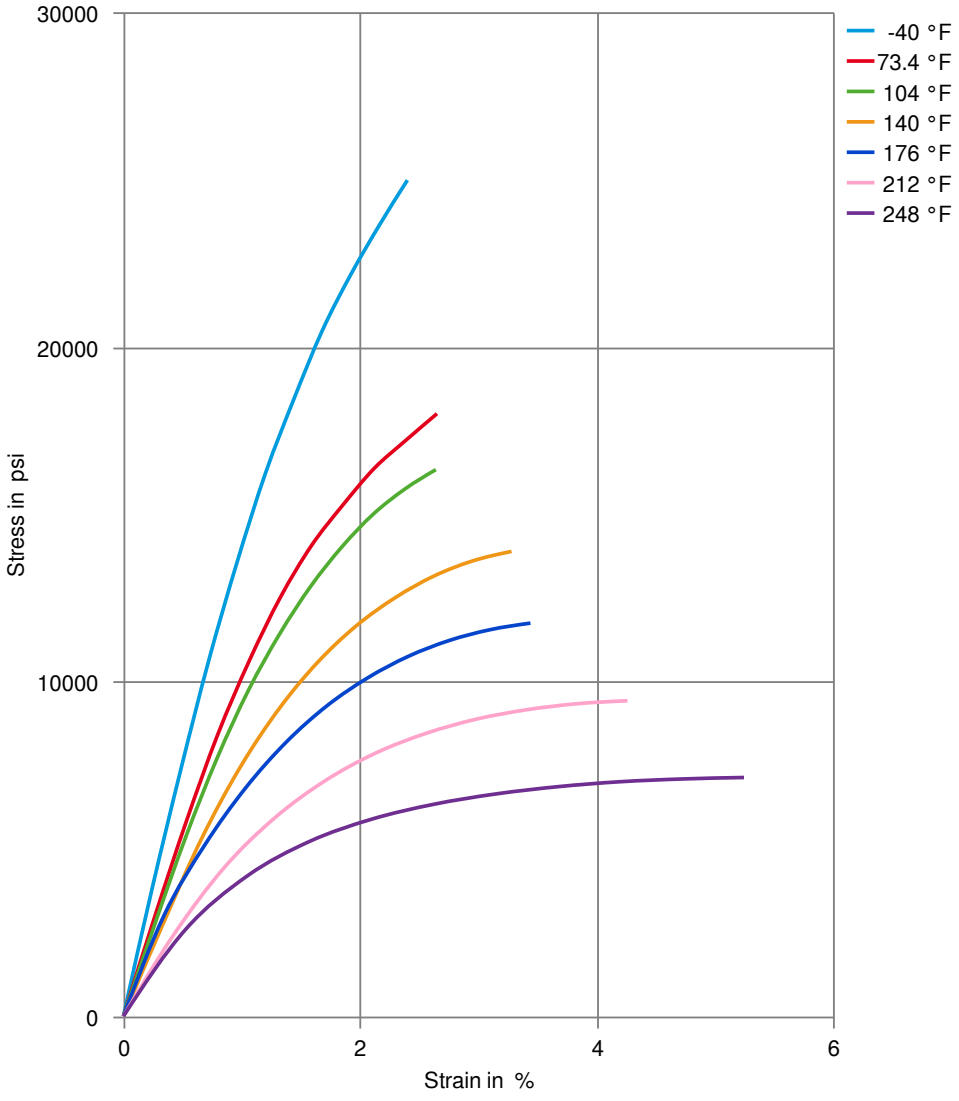
Pre-Drying

Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying may be necessary to prevent splay and odor problems.

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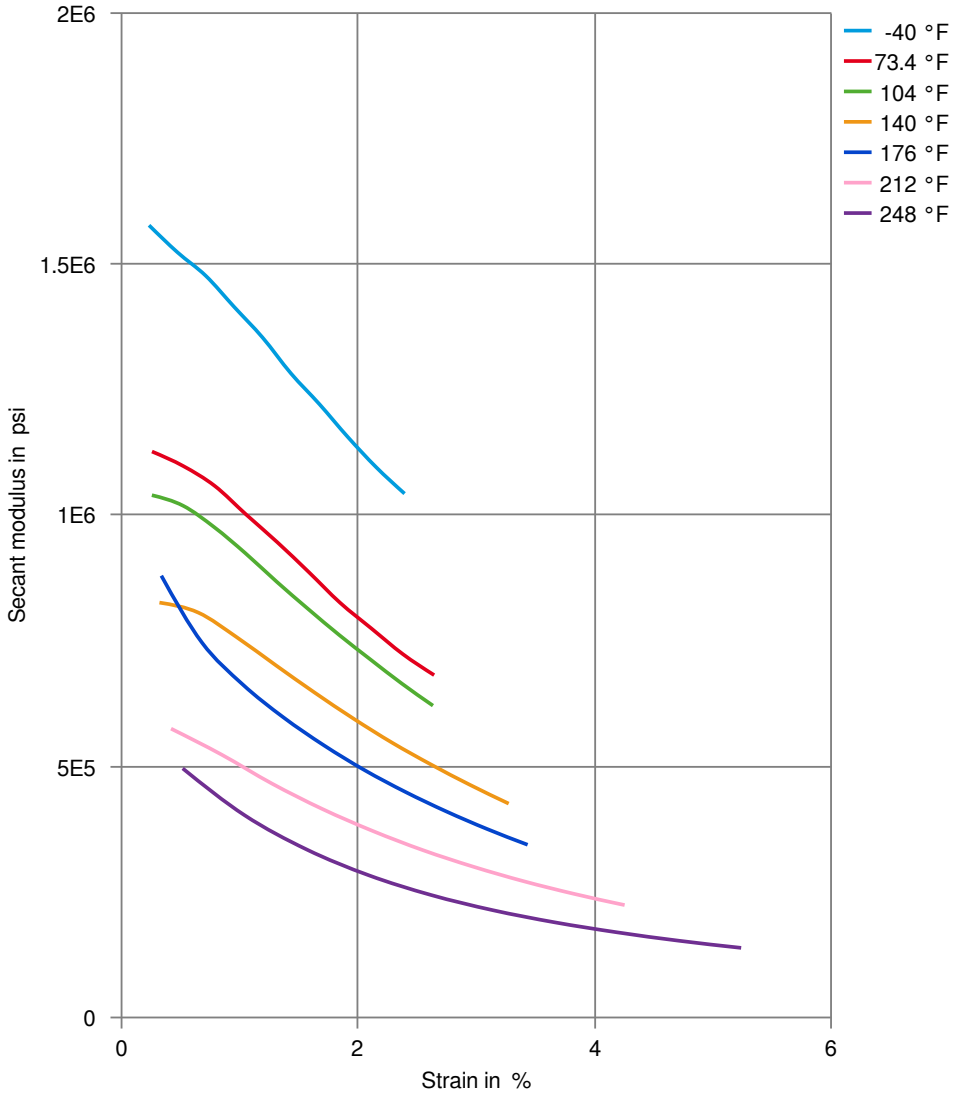
Stress-strain



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Secant modulus-strain



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Chemical Media Resistance

Standard Fuels

- ✔ ISO 1817 Liquid 1 - E5, 60°C
- ✔ ISO 1817 Liquid 2 - M15E4, 60°C
- ✔ ISO 1817 Liquid 3 - M3E7, 60°C
- ✔ ISO 1817 Liquid 4 - M15, 60°C
- ✔ Standard fuel without alcohol (pref. ISO 1817 Liquid C), 23°C
- ✔ Standard fuel with alcohol (pref. ISO 1817 Liquid 4), 23°C

Symbols used:

✔ possibly resistant
Defined as: Supplier has sufficient indication that contact with chemical can be potentially accepted under the intended use conditions and expected service life. Criteria for assessment have to be indicated (e.g. surface aspect, volume change, property change).

✘ not recommended - see explanation
Defined as: Not recommended for general use. However, short-term exposure under certain restricted conditions could be acceptable (e.g. fast cleaning with thorough rinsing, spills, wiping, vapor exposure).

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