

Celcon® CE66FC GV1/25

Acetal (POM) Copolymer
Celanese Corporation

Message:

Celcon® CE66FC GV1/25 is a 25% glass fiber coupled acetal copolymer grade. It offers higher strength than the standard Celcon CE66FC.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 25% filler by weight		
Features	High strength		
	Copolymer		
	Chemical coupling		
RoHS Compliance	Contact manufacturer		
Processing Method	Extrusion		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.58	g/cm³	ASTM D792
--	1.57	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)	6.5	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	8.50	cm³/10min	ISO 1133
Molding Shrinkage			
Flow	0.40	%	ASTM D955
Transverse flow	1.0	%	ASTM D955
Transverse flow	0.80	%	ISO 294-4
Flow	0.40	%	ISO 294-4
Water Absorption (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8450	MPa	ISO 527-2/1A/1
Tensile Strength			
Fracture, 23°C	138	MPa	ASTM D638
Fracture	120	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.5	%	ISO 527-2/1A/5

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	kJ/m²	ISO 179/1eA

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, not annealed	163	°C	ASTM D648

1.8 MPa, not annealed	160	°C	ISO 75-2/A
Melting Temperature ¹	166	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	2.7E-5	cm/cm/°C	ISO 11359-2
Lateral	1.3E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	80 - 100	°C	
Drying Time	3.0	hr	
Rear Temperature	170 - 180	°C	
Middle Temperature	180 - 190	°C	
Front Temperature	180 - 190	°C	
Nozzle Temperature	190 - 200	°C	
Processing (Melt) Temp	180 - 200	°C	
Mold Temperature	90 - 120	°C	
Injection Pressure	90.0 - 140	MPa	
Injection Rate	Slow		
Holding Pressure	90.0 - 140	MPa	
Back Pressure	0.00 - 2.00	MPa	
Injection instructions			
Manifold Temperature: 190 to 210°C Zone 4 Temperature: 190 to 200°C			
NOTE			
1.	10°C/min		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

