

# CELCON® CE66FC GV1/25

25% glass fibers, coupled for improved stiffness and high strength

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

## Rheological properties

Moulding shrinkage, parallel	0.4 %	ISO 294-4, 2577
Moulding shrinkage, normal	0.8 %	ISO 294-4, 2577

## Typical mechanical properties

Tensile Modulus	8450 MPa	ISO 527-1/-2
Stress at break, 5mm/min	120 MPa	ISO 527-1/-2
Strain at break, 5mm/min	2.5 %	ISO 527-1/-2
Flexural Modulus	8340 MPa	ISO 178
Flexural Strength	195 MPa	ISO 178
Charpy impact strength, 23°C	45 kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	8 kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30 °C	7 kJ/m <sup>2</sup>	ISO 179/1eA

## Thermal properties

Melting temperature, 10°C/min	166 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	160 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	27 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	125 E-6/K	ISO 11359-1/-2

## Other properties

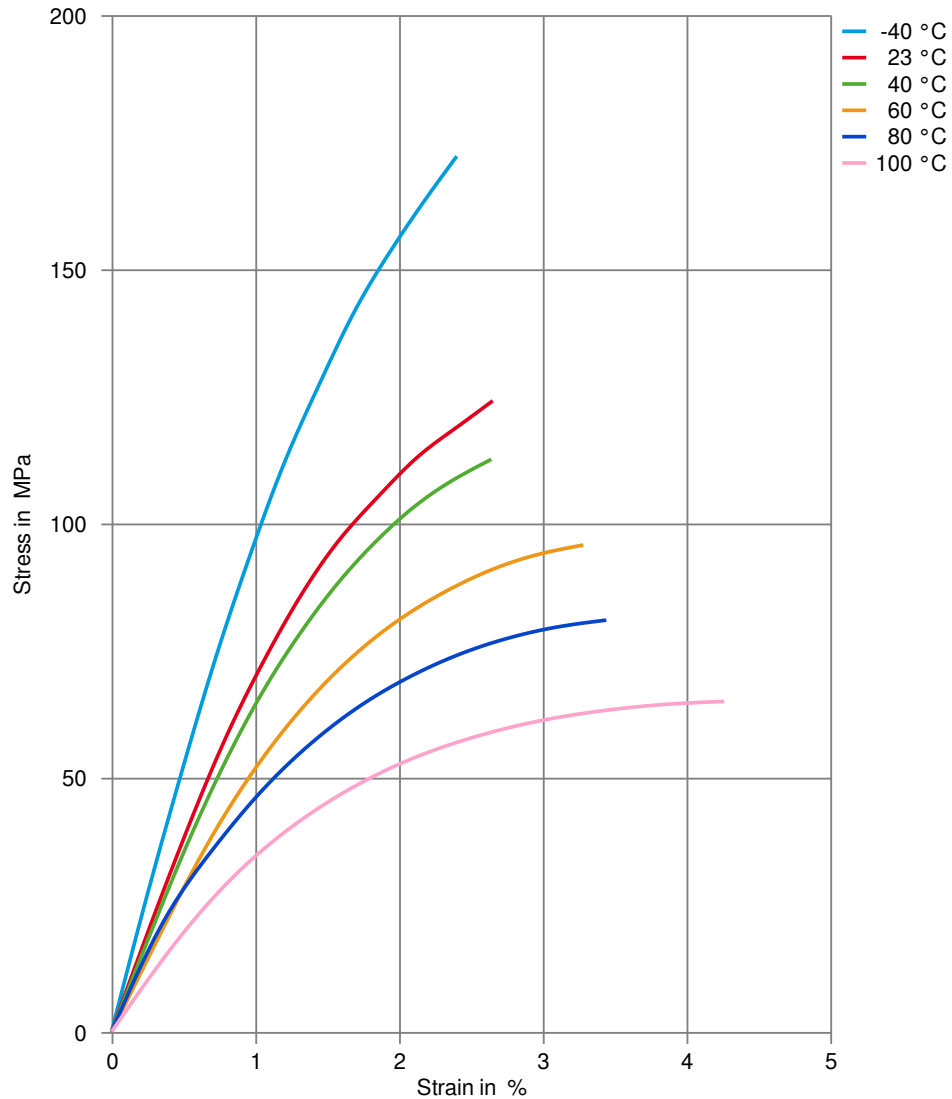
Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.8 %	Sim. to ISO 62
Density	1570 kg/m <sup>3</sup>	ISO 1183

## Injection

Drying Temperature	100 - 120 °C
Drying Time, Dehumidified Dryer	3 - 4 h
Max. mould temperature	90 - 120 °C
Back pressure	2 MPa
Injection speed	slow

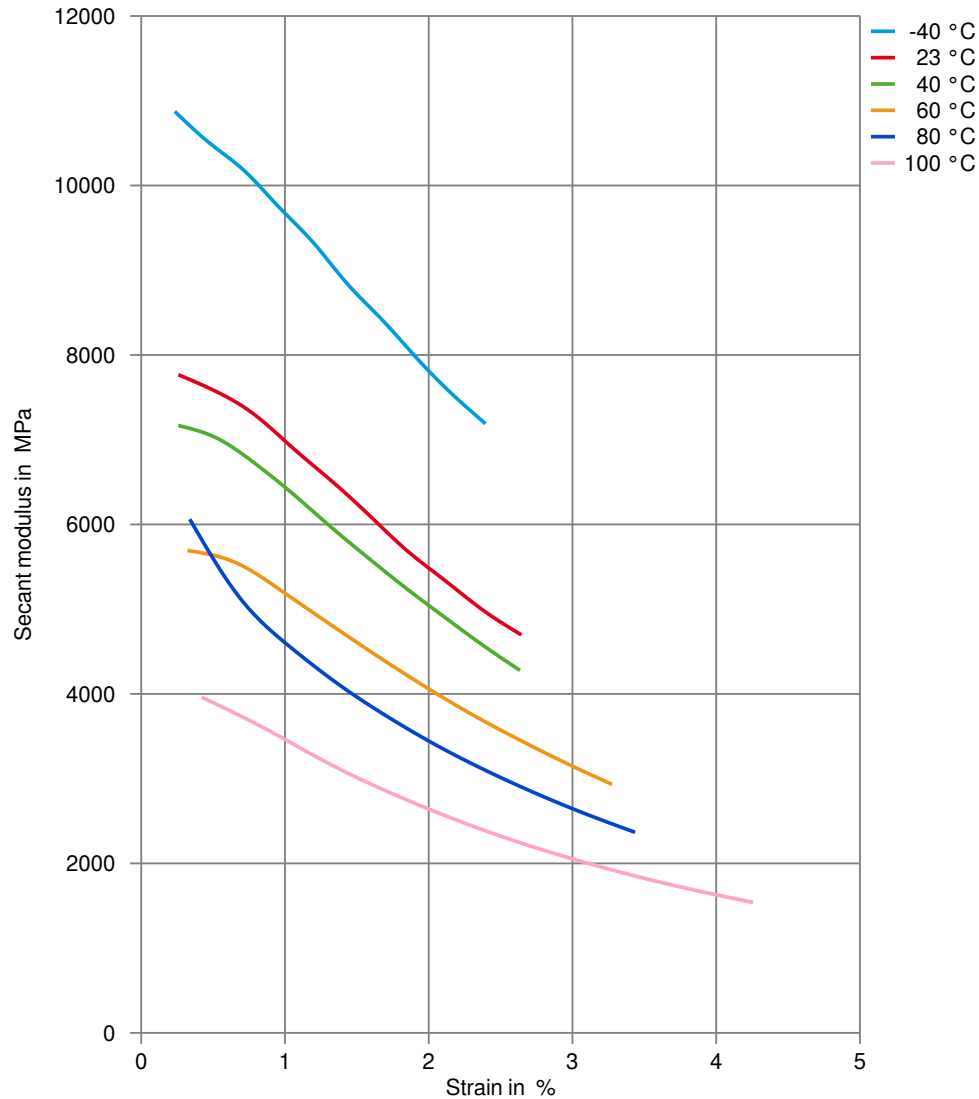
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## Stress-strain



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## Secant modulus-strain



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## Processing Texts

### 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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