

CELCON® GC15

15% glass fibers, coupled for improved stiffness

Celcon® GC15 is an acetal copolymer grade utilizing a nominal 15 wt. % glass fiber to increase stiffness and strength.

Chemical abbreviation according to ISO 1043-1: POM

Rheological properties

Moulding shrinkage, parallel	0.5 %	ISO 294-4, 2577
Moulding shrinkage, normal	0.9 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	5950 MPa	ISO 527-1/-2
Stress at break, 5mm/min	91 MPa	ISO 527-1/-2
Strain at break, 5mm/min	2.5 %	ISO 527-1/-2
Flexural Modulus	5850 MPa	ISO 178
Charpy notched impact strength, 23°C	4.9 kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	5.3 kJ/m ²	ISO 180/1A

Thermal properties

Melting temperature, 10°C/min	166 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	159 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	161 °C	ISO 306
Coeff. of linear therm. expansion, parallel	46 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	100 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	1500 kg/m ³	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

Additional information

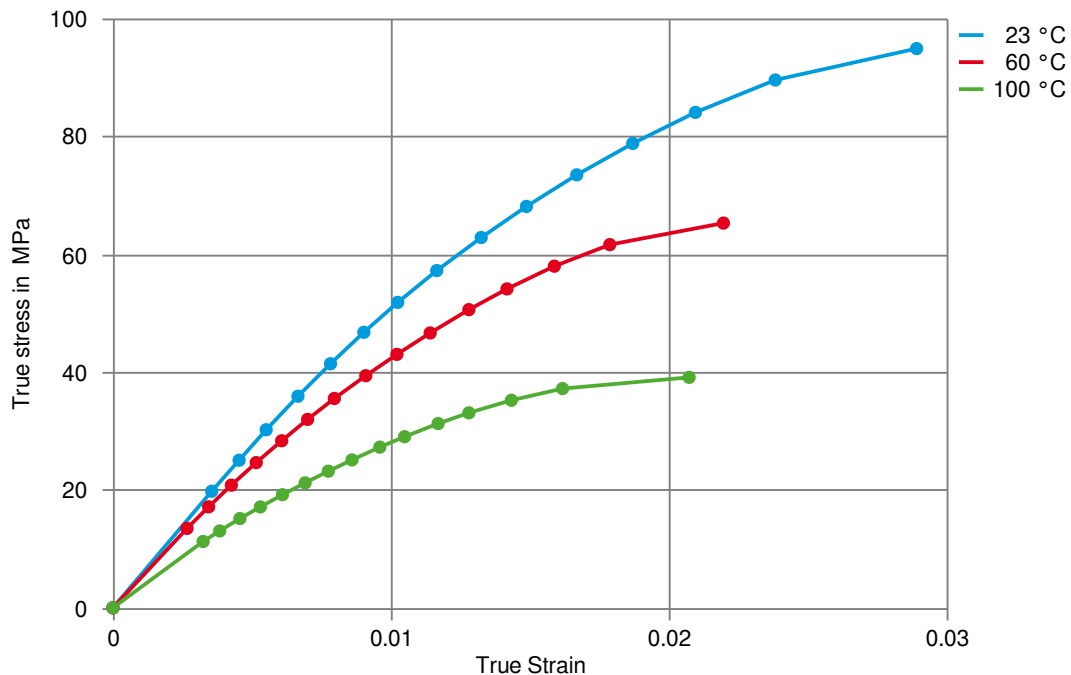
Injection molding	Standard reciprocating screw injection molding machines with a high compression screw (minimum 3:1 and preferably 4:1) and low back pressure (0.35 Mpa/50 PSI) are favored. Using a low compression screw (i.e.- general purpose 2:1 compression ratio) can result in unmelted particles and 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.
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Melt temperature: preferred range 182-199 C (360-390 F) Melt temperature

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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.

True stress-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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Injection molding Preprocessing

Drying is generally not required because Celcon materials are not hygroscopic 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%.

Injection molding 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.