

Celcon® GB10

Acetal (POM) Copolymer

Celanese Corporation

Message:

Celcon® GB10 is a 10% glass bead filled grade for low shrinkage and warp resistance in large, flat, and thin walled parts.

Chemical abbreviation according to ISO 1043-1: POM

General Information			
Filler / Reinforcement	Glass beads, 10% filler by weight		
Features	Low warpage		
	Low shrinkage		
Uses	Thin wall parts		
RoHS Compliance	Contact manufacturer		
Resin ID (ISO 1043)	POM		
Physical	Nominal Value	Unit	Test Method
Density	1.47	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	17.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.6	%	ISO 294-4
Flow direction	1.9	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3100	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	55.0	MPa	ISO 527-2/1A/50
Tensile Strain			ISO 527-2/1A/50
Yield	7.0	%	ISO 527-2/1A/50
Fracture	10	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	3.5	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	94.0	°C	ISO 75-2/A
Melting Temperature ¹	166	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	3.0	hr	
Rear Temperature	170 - 180	°C	
Middle Temperature	170 - 180	°C	
Front Temperature	180 - 190	°C	
Nozzle Temperature	190 - 200	°C	

Processing (Melt) Temp	180 - 200	°C
Mold Temperature	90.0 - 120	°C
Injection Pressure	90.0 - 140	MPa
Injection Rate	Slow	
Holding Pressure	90.0 - 140	MPa
Back Pressure	0.00 - 0.500	MPa

Injection instructions

Manifold Temperature: 190 to 210°CZone 4 Temperature: 180 to 190°C

NOTE

1.
- 10°C/min

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