CELCON® CE66 - POM

Restricted Grade. Please contact your Celanese representative for further information.

Description

General Purpose Acetal Copolymer
Celcon® acetal copolymer grade CE66 is a medium viscosity polymer providing good performance in general purpose injection molding and extrusion of thin walled tubing and thin gauge film. This grade provides overall excellent performance in many applications. Chemical abbreviation according to ISO 1043-1: POM UL94 Flammability HB

Physical properties	Value	Unit	Test Standard
Density	**1410**	kg/m³	ISO 1183
Melt volume rate, MVR	**8**	cm³/10min	ISO 1133
MVR temperature	**190**	°C	ISO 1133
MVR load	**2,16**	kg	ISO 1133
Molding shrinkage, parallel	**2,0**	%	ISO 294-4, 2577
Molding shrinkage, normal	**1,9**	%	ISO 294-4, 2577
Water absorption, 23°C-sat	**0,75**	%	ISO 62
Humidity absorption, 23°C/50%RH	**0,2**	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	**2700**	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	**62**	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	**11**	%	ISO 527-2/1A
Charpy notched impact strength, 23°C	**6**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	**166**	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	**100**	°C	ISO 75-1, -2
DTUL at 0.45 MPa	**155**	°C	ISO 75-1, -2
Vicat softening temperature, 50°C/h 50N	**160**	°C	ISO 306
Coeff. of linear therm expansion, parallel	**1,2**	E-4/°C	ISO 11359-2
Coeff. of linear therm expansion, normal	**1,2**	E-4/°C	ISO 11359-2

Electrical properties	Value	Unit	Test Standard
Volume resistivity	**1E12**	Ohm*m	IEC 60093
Surface resistivity	**1E15**	Ohm	IEC 60093

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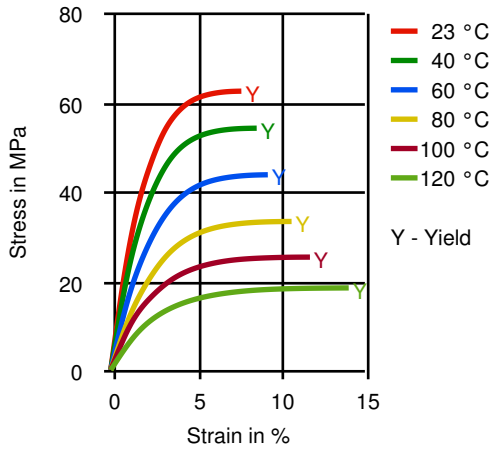
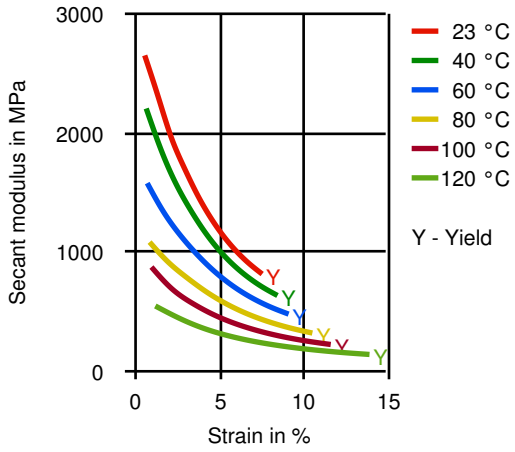
Diagrams

Stress-strain



Secant modulus-strain



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HOURS: 24

Typical injection moulding processing conditions

Pre Drying	**Value**	**Unit**	**Test Standard**
Drying time	**3 - 4**	h	-
Drying temperature	**100 - 120**	°C	-
Temperature	**Value**	**Unit**	**Test Standard**
Zone1 temperature	**170 - 180**	°C	-
Zone2 temperature	**180 - 190**	°C	-
Zone3 temperature	**180 - 190**	°C	-
Zone4 temperature	**190 - 200**	°C	-
Nozzle temperature	**190 - 200**	°C	-
Melt temperature	**180 - 200**	°C	-
Mold temperature	**80 - 120**	°C	-
Hot runner temperature	**180 - 200**	°C	-
Pressure	**Value**	**Unit**	**Test Standard**
Back pressure max.	**40**	bar	-
Speed	**Value**	**Unit**	**Test Standard**
Injection speed	**slow-medium**	-	-
Other	**Value**	**Unit**	**Test Standard**
Flow temperature	**174**	°C	Internal

Other text information

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.

Characteristics

Product Categories	**Delivery Form**
Unfilled	Pellets

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Processing

Calandering, Film extrusion, Injection molding, Other extrusion, Profile extrusion, Sheet extrusion

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General Disclaimer

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