

Hostaform® C 36021

Acetal (POM) Copolymer

Celanese Corporation

Message:

Hostaform® C 36021 is an unfilled acetal copolymer grade formulated for high flow while retaining a good balance of mechanical properties.
Chemical abbreviation according to ISO 1043-1: POM

General Information			
Features	Fast molding cycle		
	High liquidity		
Uses	Thin wall parts		
RoHS Compliance	Contact manufacturer		
Resin ID (ISO 1043)	POM		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	32.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.8	%	ISO 294-4
Flow direction	1.9	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2800	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	68.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	8.0	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2800	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	103	°C	ISO 75-2/A
Melting Temperature ¹	166	°C	ISO 11357-3
CLTE - Flow	1.1E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	170 - 180	°C	
Middle Temperature	180 - 190	°C	
Front Temperature	180 - 190	°C	
Nozzle Temperature	180 - 200	°C	
Processing (Melt) Temp	180 - 200	°C	

Mold Temperature	80.0 - 120	°C
Injection Pressure	60.0 - 120	MPa
Holding Pressure	60.0 - 120	MPa
Back Pressure	0.00 - 0.500	MPa

Injection instructions

Zone 4 Temperature: 180 to 200°C

NOTE

1. 10°C/min

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