

Hostaform® C 2521 G

Acetal (POM) Copolymer

Celanese Corporation

Message:

Chemical abbreviation according to ISO 1043-1: POM

Molding compound ISO 9988- POM-K, M-GNS, 01-001

POM copolymer

Stiff-flowing type for injection molding and extrusion, modified with (R) GUR (PE-UHMW); good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation; with GUR (PE-UHMW) modified extrusion type, therefore very good lubricating properties.

Burning rate ISO 3795 and FMVSS 302 < 100 mm/min for a thickness more than 1 mm.

Ranges of applications: For injection molding parts and semi-finished products with higher requirements on lubricating properties.

FMVSS = Federal Motor Vehicle Safety Standard (USA)

General Information			
Features	Solvent resistance		
	Good chemical resistance		
	alkali resistance		
	Fuel resistance		
	Hydrolysis resistance		
RoHS Compliance	Contact manufacturer		
Processing Method	Extrusion		
	Injection molding		
Resin ID (ISO 1043)	POM		
Physical	Nominal Value	Unit	Test Method
Density	1.34	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	1.50	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 23°C)	0.80	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2100	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	44.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	12	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	15	%	ISO 527-2/1A/50
Tensile Creep Modulus			ISO 899-1
1 hr	1800	MPa	ISO 899-1
1000 hr	1000	MPa	ISO 899-1
Flexural Modulus (23°C)	2000	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	4.5	kJ/m ²	ISO 179/1eA
23°C	5.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	50	kJ/m ²	ISO 179/1eU
23°C	50	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	84.0	°C	ISO 75-2/A
Melting Temperature ¹	165	°C	ISO 11357-3
CLTE - Flow	1.0E-4	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093
Dielectric Strength	35	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	3.80		IEC 60250
1 MHz	3.80		IEC 60250
Dissipation Factor			IEC 60250
100 Hz	2.0E-3		IEC 60250
1 MHz	7.0E-3		IEC 60250
Comparative Tracking Index	600	V	IEC 60112
Injection	Nominal Value	Unit	
Drying Temperature	100 - 120	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.15	%	
Hopper Temperature	20.0 - 30.0	°C	
Rear Temperature	170 - 180	°C	
Middle Temperature	180 - 190	°C	
Front Temperature	190 - 200	°C	
Nozzle Temperature	190 - 210	°C	
Processing (Melt) Temp	190 - 210	°C	
Mold Temperature	80.0 - 120	°C	
Injection Pressure	60.0 - 120	MPa	
Injection Rate	Slow		
Holding Pressure	60.0 - 120	MPa	
Back Pressure	0.00 - 2.00	MPa	
Injection instructions			
Manifold Temperature: 190 to 210°CZone 4 Temperature: 190 to 210°CFeed Temperature: 60 to 80°C			
NOTE			
1.	10°C/min		

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