Hostaform® C 13021 LS 10/1570

Acetal (POM) Copolymer

Celanese Corporation

Message:

POM copolymer
Easy flowing Injection molding type for precision molded parts and thin-walled molded parts with high rigidity, hardness and toughness; good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation. With UV Additives and a high amount of carbon black
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Ranges of applications: automotive engineering, especially out door applications

General Information			
Additive	Carbon black UV stabilizer		
Features	Rigidity, high Solvent resistance Good liquidity Good chemical resistance alkali resistance Fuel resistance Hydrolysis resistance Good toughness High hardness		
Uses	Thin wall parts Application in Automobile Field Automotive exterior parts		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.41	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	12.0	cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Transverse flow	1.8	%	ISO 294-4
Flow	2.0	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.65	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2900	MPa	ISO 527-2/1A/1

Tensile Stress (Yield)	65.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	9.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	25	%	ISO 527-2/1A/50
Tensile Creep Modulus			ISO 899-1
1 hr	2500	MPa	ISO 899-1
1000 hr	1300	MPa	ISO 899-1
Flexural Modulus (23°C)	2800	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	6.0	kJ/m^2	ISO 179/1eA
23°C	6.5	kJ/m^2	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	140	kJ/m^2	ISO 179/1eU
23°C	150	kJ/m^2	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (1.8 MPa, Unannealed)	106	°C	ISO 75-2/A
Melting Temperature [1]	166	°C	ISO 11357-3
CLTE - Flow	1.1E-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	4.00		IEC 60250
1 MHz	4.00		IEC 60250
Dissipation Factor			IEC 60250
100 Hz	2.0E-3		IEC 60250
1 MHz	5.0E-3		IEC 60250
Comparative Tracking Index	600	V	IEC 60112
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Density of Melt	1.200	g/cm^3	Internal method
Specific Heat Capacity of Melt	2210	J/kg/°C	Internal method
Thermal Conductivity of Melt	0.16	W/m/K	Internal method
Ejection Temperature	140	°C	Internal method
Injection	**Nominal Value**	**Unit**	**Test Method**
Drying Temperature	120 - 140	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.15	%	
Hopper Temperature	20 - 30	°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 - 120	°C
Injection Pressure	60.0 - 120	MPa
Injection Rate	Slow-Moderate	
Holding Pressure	60.0 - 120	MPa
Back Pressure	0.00 - 4.00	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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