



Hostaform® S 27072 WS 10/1570

Celanese Corporation - Acetal (POM) Copolymer

Sunday, November 3, 2019

General Information

Product Description

Chemical abbreviation according to ISO 1043-1: POM-HI Molding compound ISO 9988- POM-K, M-GCLP, 05-001 Modified POM copolymer Easy flowing, elastomer-containing injection molding type in color modifying black 10/1570; especially weathering resistant; lower chemical resistance than the basic type HOSTAFORM C 27021; high resistance to thermal and oxidative degradation. Burning rate ISO 3795 and FMVSS 302 < 100 mm/min for a thickness more than 1 mm. Ranges of applications: for molded parts with matt surface. FMVSS = Federal Motor Vehicle Safety Standard (USA)

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Chemical Resistant	• Good Flow	• Good Weather Resistance
RoHS Compliance	• Contact Manufacturer		
Appearance	• Black	• Matte Finish	
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• POM-HI		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.39	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	21	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.9	%	
Flow	1.8	%	
Water Absorption (Saturation, 73°F)	0.70	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	290000	psi	ISO 527-2/1A
Tensile Stress (Yield)	6670	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	8.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	35	%	ISO 527-2/1A/50
Tensile Creep Modulus (1 hr)	261000	psi	ISO 899-1
Tensile Creep Modulus (1000 hr)	145000	psi	ISO 899-1
Flexural Modulus (73°F)	305000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	3.8	ft·lb/in ²	
73°F	5.2	ft·lb/in ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	52	ft·lb/in ²	
73°F, Partial Break	71	ft·lb/in ²	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness ²	16700	psi	ISO 2039-1
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	183	°F	ISO 75-2/A
Vicat Softening Temperature	275	°F	ISO 306/B50

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Thermal	Nominal Value	Unit	Test Method
Melting Temperature ³	331	°F	ISO 11357-3
CLTE - Flow	6.7E-5	in/in/°F	ISO 11359-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr
Hopper Temperature	68 to 86	°F
Rear Temperature	338 to 356	°F
Middle Temperature	356 to 374	°F
Front Temperature	374 to 392	°F
Nozzle Temperature	374 to 392	°F
Processing (Melt) Temp	374 to 392	°F
Mold Temperature	140 to 158	°F
Injection Rate	Slow	
Back Pressure	< 290	psi

Injection Notes

Feeding zone temperature: 60 to 80°C
 Zone4 temperature: 190 to 200°C
 Hot runner temperature: 190 to 200°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 30s

³ 10°C/min