Hostaform® C 13021 XAP

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.
Emission according to VDA 275 < 10 mg/kg
Monomers and additives are listed in EU-Regulation (EU) 10/2011
FDA compliant according to 21 CFR 177.2470
Burning rate ISO 3795 and FMVSS 302 < 75 mm/min for a thickness more than 1 mm.
Ranges of applications: automotive engineering, precision engineering, electric and electronical industry, domestic appliances.
FDA = Food and Drug Administration (USA)
FMVSS = Federal Motor Vehicle Safety Standard (USA)

General Information			
Features	Rigidity, high Copolymer Hydrolysis resistance Good toughness High hardness		
Uses	Thin wall parts Electrical/Electronic Applications Electrical appliances Application in Automobile Field		
Agency Ratings	FDA 21 CFR 177.2470 Europe 10/1/2011 12:00:00 AM		
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
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
1.5 mm	HB		UL 94
3.0 mm	HB		UL 94
Fill Analysis	**Nominal Value**	**Unit**	
Melt Density	1.20	g/cm^3	
Melt Specific Heat	2210	J/kg/°C	
Melt Thermal Conductivity	0.16	W/m/K	
Ejection Temperature	140	°C	
Injection	**Nominal Value**	**Unit**	
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

Recommended distributors for this material

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