Hostaform® C13031 XF

Acetal (POM) Copolymer

Celanese Corporation

Message:

Hostaform® acetal copolymer grade C13031 XF is an acetal copolymer modified to resist deterioration from aggressive fuel blends. This material is specially targeted for transportation industry fuel systems. In natural form, Hostaform® C13031 XF has a distinctive yellow color (Color code 50/5339) to denote use for fuel systems. Additionally the product is available in black 10/9022 for laser welding applications.

General Information	
Features	Fuel resistance
RoHS Compliance	Contact manufacturer
Appearance	Black
	Yellow

Physical	Nominal Value	Unit	Test Method
Density	1.42	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
Vertical flow direction	1.9	%	ISO 294-4
Flow direction	2.2	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2850	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	62.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	11	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	30	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2900	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	6.0	kJ/m²	ISO 179/1eA
23°C	7.5	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	140	kJ/m²	ISO 179/1eU
23°C	150	kJ/m²	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	159	°C	ISO 75-2/B
1.8 MPa, not annealed	102	°C	ISO 75-2/A
Melting Temperature [1]	170	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	9.0E-5	cm/cm/°C	ISO 11359-2

Lateral	9.0E-5	cm/cm/°C	ISO 11359-2

Injection	Nominal Value	Unit
Drying Temperature	80.0 - 100	°C
Drying Time	3.0	hr
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-Moderate	
Holding Pressure	60.0 - 120	MPa
Back Pressure	0.00 - 0.500	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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Recommended distributors for this material

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