

Hostaform® C 2521 LS

Acetal (POM) Copolymer

Celanese Corporation

Message:

POM copolymer
Stiff-flowing type for injection molding and extrusion with high impact toughness and good tracking resistance over a high range of temperature; good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation.
This grade has been specially stabilized to prevent discoloration and deterioration of mechanical properties from ultraviolet light exposure.
The material is available in natural, black and colored.
Burning rate ISO 3795 and FMVSS 302 < 75 mm/min for a thickness more than 1 mm.
Ranges of applications: injection molding thick-walled, void-free molded parts; extrusion e.g. for boards and pipes.
FMVSS = Federal Motor Vehicle Safety Standard (USA)

General Information			
Additive	UV stabilizer		
Features	Solvent resistance		
	Impact resistance, high		
	Good chemical resistance		
	alkali resistance		
	Fuel resistance		
Uses	Piping system		
	Thick wall fittings (parts)		
RoHS Compliance	Contact manufacturer		
Appearance	Black		
	Available colors		
	Natural color		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	2.50	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.8	%	ISO 294-4
Flow direction	2.1	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.65	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method

Tensile Modulus	2600	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	62.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	9.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	32	%	ISO 527-2/1A/50
Tensile Creep Modulus			ISO 899-1
1 hr	2300	MPa	ISO 899-1
1000 hr	1100	MPa	ISO 899-1
Flexural Modulus (23°C)	2500	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	7.0	kJ/m ²	ISO 179/1eA
23°C	8.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	200	kJ/m ²	ISO 179/1eU
23°C, local fracture	220	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	101	°C	ISO 75-2/A
Melting Temperature ¹	165	°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	1.5E-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
1.50 mm	HB		UL 94
3.00 mm	HB		UL 94
Fill Analysis	Nominal Value	Unit	Test Method
Density of Melt	1.200	g/cm ³	Internal method
Ejection Temperature	165	°C	Internal method
Specific Heat Capacity of Melt	2210	J/kg/°C	Internal method
Thermal Conductivity of Melt	0.16	W/m/K	Internal method
Injection	Nominal Value	Unit	
Drying Temperature	120 - 140	°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-Moderate	
Holding Pressure	60.0 - 120	MPa
Back Pressure	0.00 - 4.00	MPa

Injection instructions

Manifold Temperature: 190 to 210°C Zone 4 Temperature: 190 to 210°C Feed Temperature: 60 to 80°C

NOTE

1. 10°C/min

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