

Hostaform® C 27021 GV3/30

Acetal (POM) Copolymer

Celanese Corporation

Message:

Chemical abbreviation according to ISO 1043-1: POM

Molding compound ISO 9988- POM-K, M-GNR, 05-002, GB30

POM copolymer

With 30 % glass spheres reinforced, very easy flowing injection molding type; low-warpage; 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: low-warpage and dimensionally stable molded parts with higher rigidity and hardness.

FMVSS = Federal Motor Vehicle Safety Standard (USA)

General Information			
Filler / Reinforcement	Glass beads, 30% filler by weight		
Features	Good dimensional stability		
	Low warpage		
	Rigidity, high		
	High liquidity		
	High hardness		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Multi-Point Data	Shear Stress vs. Shear Rate (ISO 11403-1)		
Resin ID (ISO 1043)	POM		
Physical	Nominal Value	Unit	Test Method
Density	1.59	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	16.0	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 23°C)	0.90	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3800	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	38.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	6.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	12	%	ISO 527-2/1A/50
Tensile Creep Modulus			ISO 899-1
1 hr	3300	MPa	ISO 899-1
1000 hr	2100	MPa	ISO 899-1
Flexural Modulus (23°C)	3500	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA

-30°C	3.0	kJ/m ²	ISO 179/1eA
23°C	2.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	30	kJ/m ²	ISO 179/1eU
23°C	30	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	112	°C	ISO 75-2/A
Melting Temperature ¹	166	°C	ISO 11357-3
CLTE - Flow	8.0E-5	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	40	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	5.00		IEC 60250
1 MHz	4.50		IEC 60250
Dissipation Factor			IEC 60250
100 Hz	0.030		IEC 60250
1 MHz	8.0E-3		IEC 60250
Comparative Tracking Index	600	V	IEC 60112
Injection	Nominal Value	Unit	
Drying Temperature	100 - 120	°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		
Holding Pressure	60.0 - 120	MPa	
Back Pressure	0.00 - 2.00	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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