

Hostaform® CP15X

Acetal (POM) Copolymer

Celanese Corporation

Message:

Preliminary Data Sheet

Hostaform® acetal copolymer grade CP15X is a creep resistant, high viscosity polymer providing excellent performance in general purpose injection molding. This grade provides overall excellent performance in applications requiring high stiffness over time.

General Information			
Features	Rigidity, high		
	Good creep resistance		
	General		
	Viscosity, High		
Uses	General		
RoHS Compliance	Contact manufacturer		
Processing Method	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)	1.70	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	2.0	%	ISO 294-4
Flow direction	2.1	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.75	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2700	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	66.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	12	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	40	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	2450	MPa	ISO 178
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	92.0	°C	ISO 75-2/A
Melting Temperature ¹	167	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.0E-4	cm/cm/°C	ISO 11359-2
Lateral	1.0E-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

Injection	Nominal Value	Unit
Drying Temperature	80.0 - 100	°C
Drying Time	3.0	hr
Rear Temperature	180 - 200	°C
Middle Temperature	190 - 210	°C
Front Temperature	190 - 210	°C
Nozzle Temperature	195 - 215	°C
Processing (Melt) Temp	200 - 215	°C
Mold Temperature	90.0 - 120	°C
Injection Pressure	90.0 - 140	MPa
Holding Pressure	90.0 - 140	MPa
Back Pressure	0.00 - 0.500	MPa
Injection instructions		
Manifold Temperature: 195 to 215°CZone 4 Temperature: 195 to 215°C		
NOTE		
1.	10°C/min	

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