

Hostaform® WR140LG

Acetal (POM) Copolymer

Celanese Corporation

Message:

Hostaform® acetal copolymer grade WR140LG Black is a specialty weatherable grade of acetal copolymer formulated to provide good flow with a low gloss finish and a UV stability necessary for exterior automotive applications.

General Information			
Additive	UV stabilizer		
Features	Gloss, low		
	Good UV resistance		
	Good liquidity		
	Good weather resistance		
RoHS Compliance	Contact manufacturer		
Appearance	Black		
Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	13.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.5	%	ISO 294-4
Flow direction	1.6	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1800	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	41.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	10	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	1850	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	3.6	kJ/m ²	ISO 179/1eA
23°C	3.6	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	80.0	°C	ISO 75-2/A
Melting Temperature ¹	165	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.3E-4	cm/cm/°C	ISO 11359-2
Lateral	1.3E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	105 - 110	°C	

Drying Time	3.0	hr
Rear Temperature	170 - 175	°C
Middle Temperature	170 - 180	°C
Front Temperature	175 - 185	°C
Nozzle Temperature	185 - 195	°C
Processing (Melt) Temp	180 - 195	°C
Mold Temperature	80.0 - 105	°C
Injection Pressure	60.0 - 120	MPa
Injection Rate	Slow	
Holding Pressure	60.0 - 120	MPa
Back Pressure	0.00 - 0.500	MPa

Injection instructions

Manifold Temperature: 180 to 200°C Zone 4 Temperature: 180 to 190°C

NOTE

- 10°C/min

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