

Hostaform® CF802 10/9022

Acetal (POM) Copolymer

Celanese Corporation

Message:

Hostaform® acetal copolymer grade CF802 10/9022 is a conductive, fuel compatible general purpose acetal copolymer. Hostaform® CF802 10/9022 has been developed to dissipate static electricity from fuel handling systems. Hostaform® CF802 10/9022 has been specially formulated for laser welding applications.

Please note Hostaform® CF802 10/9022 has special processing considerations to ensure static dissipation properties. Use minimum back pressure and slowest screw speed possible in retracting screw during cooling portion of cycle. Large gate size (>2 mm) recommended. Pneumatic conveying of material long distances is not recommended.

General Information			
Features	Electrostatic discharge protection		
	Laser welding		
	Fuel resistance		
	General		
Uses	General		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.47	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3000	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	62.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	10	%	ISO 527-2/1A/50
Tensile Creep Modulus			ISO 899-1
1 hr	2130	MPa	ISO 899-1
1000 hr	1050	MPa	ISO 899-1
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.0	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	100	°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	1.2E-4	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	2.0E+3	ohms	IEC 60093
Volume Resistivity	3.0E+2	ohms · cm	IEC 60093
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	

Drying Time	3.0	hr
Rear Temperature	170 - 180	°C
Middle Temperature	175 - 185	°C
Front Temperature	180 - 190	°C
Nozzle Temperature	190 - 200	°C
Processing (Melt) Temp	180 - 200	°C
Mold Temperature	80.0 - 120	°C
Injection Pressure	60.0 - 120	MPa
Holding Pressure	60.0 - 120	MPa
Back Pressure	0.00 - 0.500	MPa

Injection instructions

Manifold Temperature: 190 to 200°C Zone 4 Temperature: 185 to 195°C

NOTE

1. 10°C/min

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