Hostaform® S 27063

Acetal (POM) Copolymer

Celanese Corporation

Message:

Chemical abbreviation according to ISO 1043-1: POM-HI,
Molding compound ISO 9988- POM-K, M-GNPR, 05-001
POM copolymer, modified
Easy flowing elastomer-containing injection molding type based on HOSTAFORM C 27021; with higher impact strength and slightly lower hardness, rigidity and chemical resistance than the basic type; high resistance to thermal and oxidative degradation.
UL-registration in natural and a thickness more than 1.57 mm as UL 94 HB.
Burning rate ISO 3795 and FMVSS 302 < 100 mm/min for a thickness more than 1 mm thickness.
Ranges of applications: For thin-walled molded parts with higher energy-absorbing capacity
UL = Underwriters Laboratories (USA)
FMVSS = Federal Motor Vehicle Safety Standard (USA)

General Information			
UL YellowCard	E42337-234626		
Features	Impact resistance, high Good liquidity Good toughness		
Uses	Thin wall parts		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Multi-Point Data	Shear Stress vs. Shear Rate (ISO 11403-1)		
Resin ID (ISO 1043)	POM-HI		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.39	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	20.0	cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.8	%	ISO 294-4
Flow direction	1.9	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.65	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2200	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	54.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	9.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	30	%	ISO 527-2/1A/50
Tensile Creep Modulus			ISO 899-1

1 hr	1850	MPa	ISO 899-1
1000 hr	1050	MPa	ISO 899-1
Flexural Modulus (23°C)	2100	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	6.0	kJ/m²	ISO 179/1eA
23°C	9.0	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	90	kJ/m²	ISO 179/1eU
23°C	140	kJ/m²	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (1.8 MPa, Unannealed)	84.0	°C	ISO 75-2/A
Melting Temperature [1]	166	°C	ISO 11357-3
CLTE - Flow	1.2E-4	cm/cm/°C	ISO 11359-2
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+13	ohms·cm	IEC 60093
Dielectric Strength	28	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	4.20		IEC 60250
1 MHz	4.20		IEC 60250
Dissipation Factor			IEC 60250
100 Hz	5.0E-3		IEC 60250
1 MHz	0.015		IEC 60250
Comparative Tracking Index	600	V	IEC 60112
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
1.57 mm	HB		UL 94
3.17 mm	HB		UL 94
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 - 200	°C	
Processing (Melt) Temp	190 - 200	°C	
Mold Temperature	60.0 - 70.0	°C	
Injection Pressure	60.0 - 120	MPa	

Injection Rate	Slow-Moderate	
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 200°CFeed Temperature: 60 to 80°C

NOTE	
1.	10°C/min

Recommended distributors for this material

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