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HOSTAFORM® CP15X

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

Product information

Resin Identification	POM		ISO 1043
Part Marking Code	>POM<		ISO 11469

Rheological properties

Melt volume-flow rate	1.7	cm^3/10min	ISO 1133
Temperature	190	°C	
Load	2.16	kg	
Moulding shrinkage, parallel	2.1	%	ISO 294-4, 2577
Moulding shrinkage, normal	2.0	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	2700	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	66	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	12	%	ISO 527-1/-2
Nominal strain at break	40	%	ISO 527-1/-2
Flexural modulus	2450	MPa	ISO 178
Flexural strength	87	MPa	ISO 178
Flexural stress at 3.5%	71	MPa	ISO 178
Hardness, Rockwell, M-scale	84		ISO 2039-2
Poisson's ratio	0.38[C]		

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	165	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	92	°C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	100	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	100	E-6/K	ISO 11359-1/-2

Electrical properties

Volume resistivity	1E12	Ohm.m	IEC 62631-3-1
Surface resistivity	1E14	Ohm	IEC 62631-3-2

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Water absorption, 2mm	0.75	%	Sim. to ISO 62
Density	1410	kg/m^3	ISO 1183

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Injection

Drying Recommended	no	
Drying Temperature	100	°C
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	205	°C
Min. melt temperature	200	°C
Max. melt temperature	215	°C
Screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	105	°C
Min. mould temperature	90	°C
Max. mould temperature	120	°C
Hold pressure range	60 - 120	MPa
Back pressure	4	MPa
Ejection temperature	132	°C

Characteristics

Processing	Injection Moulding, Extrusion
Delivery form	Pellets
Additives	Release agent
Special characteristics	Improved creep

Additional information

Processing Notes

Pre-Drying

Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying may be necessary to prevent splay and odor problems.

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