

Injection molding grade with high flow

Chemical abbreviation according to ISO 1043-1: POM Molding compound ISO 29988- POM-K, M-GNR, 05-002 POM copolymer Very easy flowing Injection molding type with high rigidity and hardness; good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation. Monomers and additives are listed in EU-Regulation (EU) 10/2011 FDA compliant according to 21 CFR 177.2470 UL-registration for all colours and a thickness more than 1.5 mm as UL 94 HB, temperature index UL 746 B electrical 110 °C, mechanical 90 °C. Burning rate ISO 3795 and FMVSS 302 < 75 mm/min for a thickness more than 1 mm. Ranges of applications: thin-walled molded parts with unfavourite flow-path-wall thickness relation; multicavity moulds; complicated precision molded parts; short cycle time. FDA = Food and Drug Administration (USA) FMVSS = Federal Motor Vehicle Safety Standard (USA) UL = Underwriters Laboratories (USA)

ECO-B: Hostaform ECO-B is a POM-Copolymer with the same properties and performance as standard grades but produced with sustainability in mind. Using a mass-balance approach, biogenic feedstocks are used to offset the use of fossil-based raw materials and decrease greenhouse gas emissions. The process is audited and certified according to the ISCC Plus mass balance approach.

Product information

Part Marking Code	POM		ISO 11469
Rheological properties			
Melt volume-flow rate	24	cm ³ /10min	ISO 1133
Temperature	190	°C	
Load	2.16	kg	
Moulding shrinkage, parallel	1.9	•	ISO 294-4, 2577
Moulding shrinkage, normal	1.8	%	ISO 294-4, 2577
Typical mechanical properties			
Tensile Modulus	2900	MPa	ISO 527-1/-2
Yield stress, 50mm/min	65	MPa	ISO 527-1/-2
Yield strain, 50mm/min	7.5	%	ISO 527-1/-2
Nominal strain at break	17	%	ISO 527-1/-2
Flexural Modulus	2800	MPa	ISO 178
Shear Modulus	1010	MPa	ISO 6721
Tensile creep modulus, 1h	2500	MPa	ISO 899-1
Tensile creep modulus, 1000h	1300	MPa	ISO 899-1
Charpy impact strength, 23°C	170	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	170	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	5.5	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	5.5	kJ/m²	ISO 179/1eA
Ball indentation hardness, H 358/30	147	MPa	ISO 2039-1
Poisson's ratio	0.406		

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ISO 11357-1/-3

Sim. to ISO 62

Sim. to ISO 62

ISO 1183

Internal

ISO 75-1/-2

HOSTAFORM® C 27021 ECO-B

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Melting temperature, 10°C/min

Temp. of deflection under load, 1.8 MPa

Vicat softening temperature, 50°C/h, 50N	151	°C	ISO 306
Coeff. of linear therm. expansion, parallel	110	E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.155	W/(m K)	Internal
Spec. heat capacity of melt		J/(kg K)	Internal
Flammability			
Burning Behav. at 1.5mm nom. thickn.	НВ	class	UL 94
Thickness tested	1.5	mm	UL 94
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	3.00	mm	UL 94
UL recognition	yes		UL 94
Electrical properties			
Relative permittivity, 100Hz	4		IEC 62631-2-1
Relative permittivity, 1MHz	4		IEC 62631-2-1
Dissipation factor, 100Hz	25	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	50	E-4	IEC 62631-2-1
Volume resistivity	1E12	Ohm.m	IEC 62631-3-1
Surface resistivity	1E14	Ohm	IEC 62631-3-2
Electric strength	35	kV/mm	IEC 60243-1
Comparative tracking index	PLC 0	PLC	UL 746A
Other properties			

166 °C

106 °C

0.2 %

1410 kg/m³

1200 kg/m³

0.65 %

Density Density of melt

Humidity absorption, 2mm

Water absorption, 2mm

Injection			
Drying Temperature	100 - 120	°C	
Drying Time, Dehumidified Dryer	3 - 4	h	
Processing Moisture Content	0.15	%	
Melt Temperature Optimum	200	°C	Internal
Screw tangential speed	0.2 - 0.21	m/s	
Max. mould temperature	80 - 120	°C	
Back pressure	4	MPa	
Injection speed	slow-medium		
Eiection temperature	140	°C	Internal

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Characteristics

Additives Release agent, Biobased

Additional information

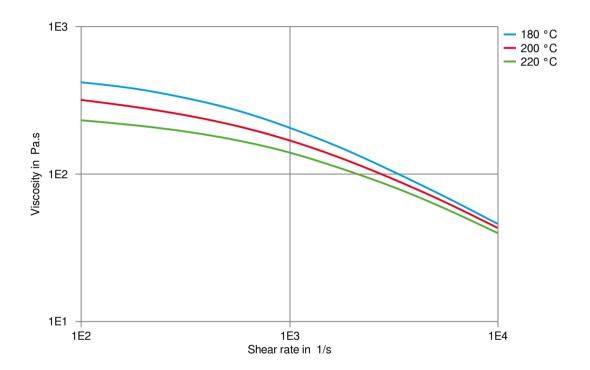
Injection molding Standard injection moulding machines with three phase (15 to 25 D)

plasticating screws will fit.

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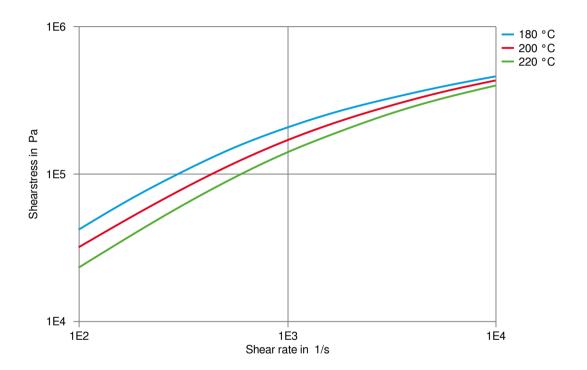
Viscosity-shear rate



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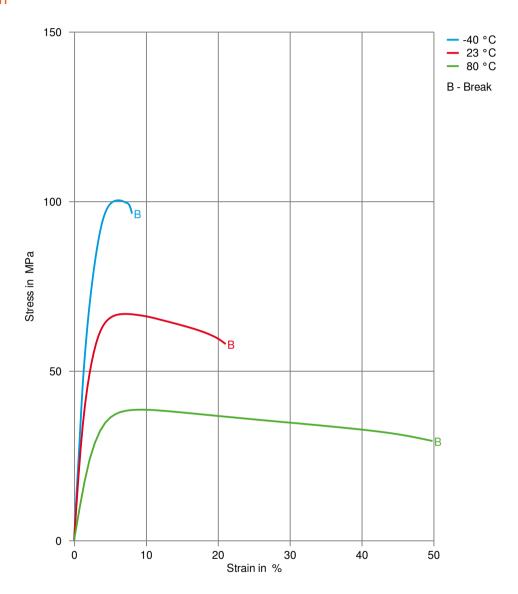
Shearstress-shear rate



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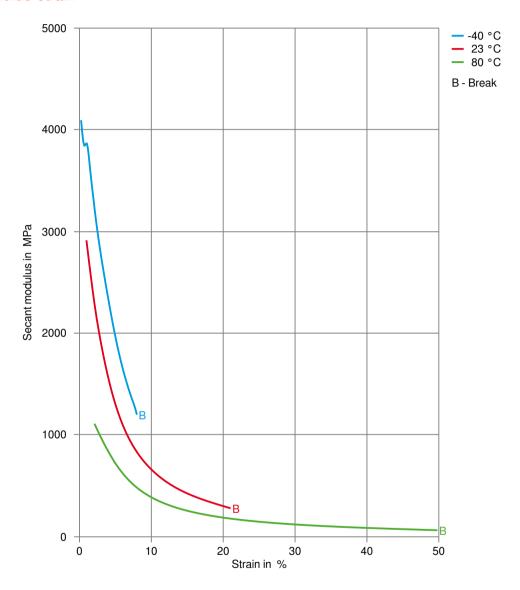
Stress-strain



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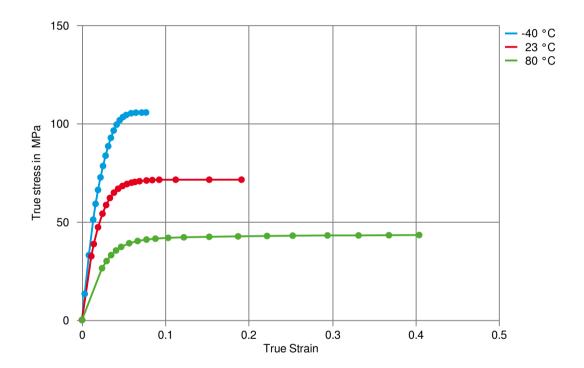
Secant modulus-strain



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True stress-strain



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Processing Texts

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.

Longer pre-drying times/storage The product can then be stored in standard conditions until processed.

Injection molding Standard injection moulding machines with three phase (15 to 25 D)

plasticating screws will fit.

Injection molding Preprocessing General drying is not necessary due to low moisture absorption of

the resin.

In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120 °C / max. 40 mm

layer / 3 to 6 hours) is recommended.

Max. Water content 0,2 %

Injection molding Postprocessing Conditioning e.g. moisturizing is not necessary.

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Revised: 2023-05-26 Source: Celanese Materials Database

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