

HOSTAFORM® C 27021 LS colored

Injection molding grade with high flow

POM copolymer

Very easy flowing Injection molding type with high rigidity and hardness; with UV additives, mass colored Burning rate ISO 3795 and FMVSS 302 < 75 mm/min for a thickness more than 1 mm.

FMVSS = Federal Motor Vehicle Safety Standard (USA)

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

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
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/m ²	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

Thermal properties

Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	106	°C	ISO 75-1/-2
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	2210	J/(kg K)	Internal

Electrical properties

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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

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Internal

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Comparative tracking index PLC 0 PLC UL 746A

Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.65 %	Sim. to ISO 62
Density	1410 kg/m³	ISO 1183
Density of melt	1200 kg/m ³	Internal

Injection

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

Characteristics

Additives Release agent

Additional information

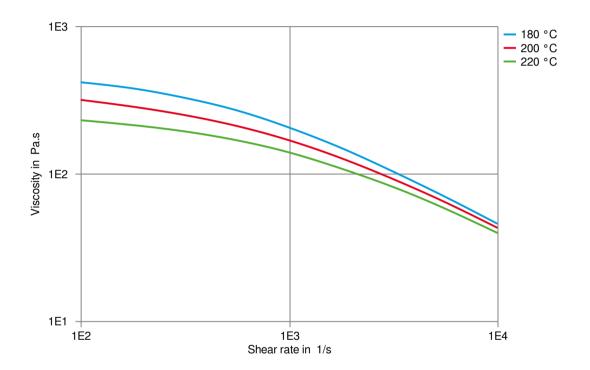
Injection molding Standard injection moulding machines with three phase (15 to 25 D)

plasticating screws will fit.

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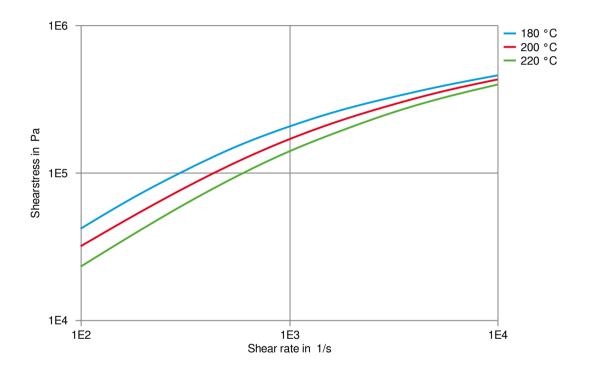
Viscosity-shear rate



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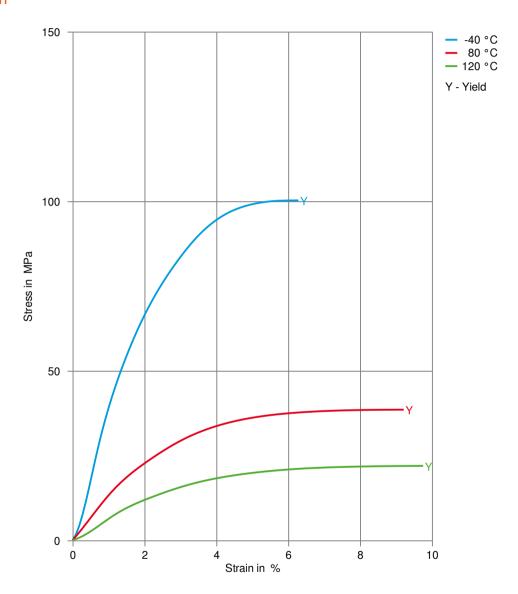
Shearstress-shear rate



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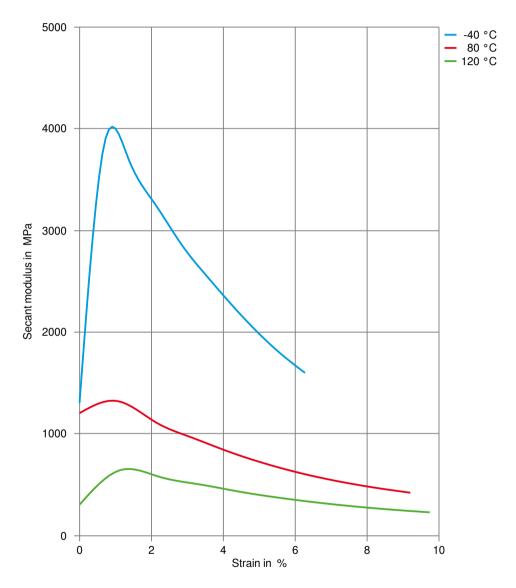
Stress-strain



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Secant modulus-strain



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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.

Other Approvals

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OEM	Specification	Additional Information
Ford	WSK-M4D840-A3	100% color match
Stellantis - PSA Group	DT00102.AS POM - 002	

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Revised: 2023-02-23 Source: Celanese Materials Database

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