

#### Impact modified, low emission

Polyacetal copolymer, impact modified Easy flowing, elastomer-containing injection molding type based on HOSTAFORM® C 27021 with high toughness and reduced emissions HB. Burning rate ISO 3795 and FMVSS 302 < 100 mm/min for more than 1 mm thickness. Emission according to VDA 275 <10 mg/kg (natural and colored grades) Ranges of applications: For thin-walled molded parts with high energy-absorbing capacity. Preliminary datasheet

#### Rheological properties

Melt volume-flow rate Temperature Load Moulding shrinkage, parallel	190 2.16 1.8	kg %	ISO 1133 ISO 294-4, 2577
Moulding shrinkage, normal	1.7	%	ISO 294-4, 2577
Typical mechanical properties			
Tensile Modulus	1500	MPa	ISO 527-1/-2
Yield stress, 50mm/min	41	MPa	ISO 527-1/-2
Yield strain, 50mm/min	10	%	ISO 527-1/-2
Nominal strain at break	35		ISO 527-1/-2
Charpy impact strength, 23°C	150 <sup>[P]</sup>		ISO 179/1eU
Charpy impact strength, -30°C		kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C		kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30 °C		kJ/m²	ISO 179/1eA
Ball indentation hardness, H 358/30	90	MPa	ISO 2039-1
[P]: Partial Break			
Thermal properties			
Melting temperature, 10 ° C/min	166	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	77	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	125		ISO 306
Coeff. of linear therm. expansion, parallel	130	E-6/K	ISO 11359-1/-2
Electrical properties			
Relative permittivity, 100Hz	4.4		IEC 62631-2-1
Relative permittivity, 1MHz	4.4		IEC 62631-2-1
Dissipation factor, 100Hz	100	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	200	E-4	IEC 62631-2-1
Volume resistivity		Ohm.m	IEC 62631-3-1
Surface resistivity	1E13		IEC 62631-3-2
Electric strength	_	kV/mm	IEC 60243-1
Comparative tracking index	PLC 0	PLC	UL 746A

Printed: 2023-08-07 Page: 1 of 8



#### Other properties

Humidity absorption, 2mm 0.25 % Sim. to ISO 62 Water absorption, 2mm 0.65 % Sim. to ISO 62 Density 1370  $kg/m^3$  ISO 1183

#### 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 60 - 70 °C
Back pressure 2 MPa
Injection speed slow-medium

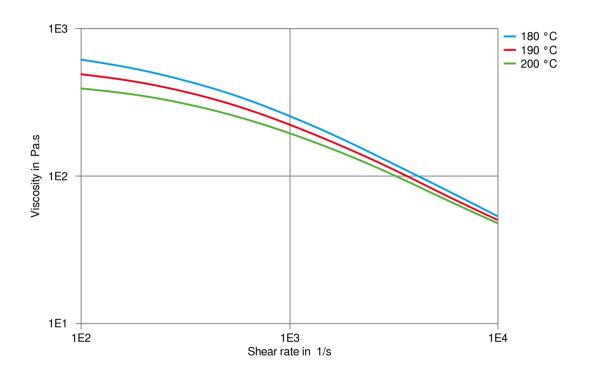
#### Characteristics

Additives Release agent

Printed: 2023-08-07 Page: 2 of 8



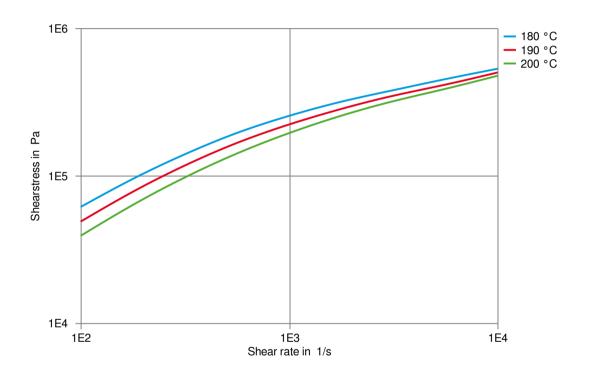
### Viscosity-shear rate



Printed: 2023-08-07 Page: 3 of 8



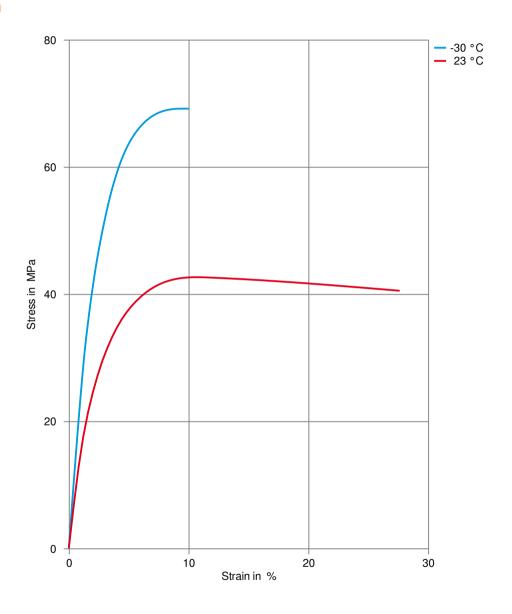
#### Shearstress-shear rate



Printed: 2023-08-07 Page: 4 of 8



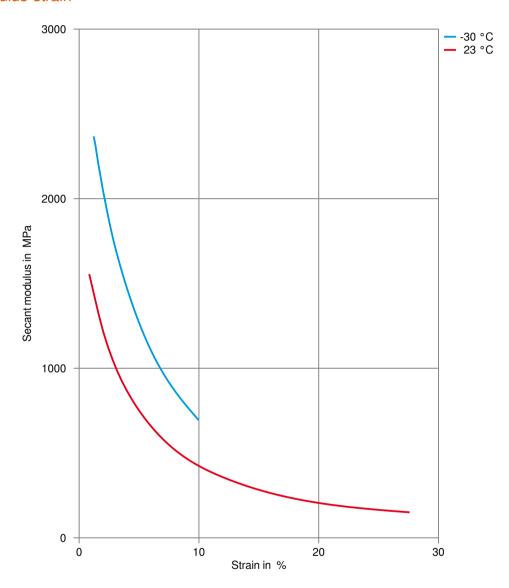
#### Stress-strain



Printed: 2023-08-07 Page: 5 of 8



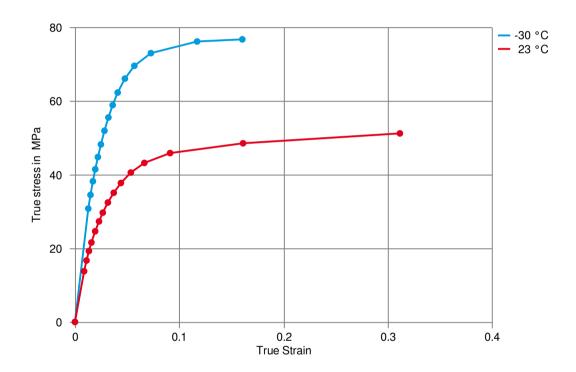
#### Secant modulus-strain



Printed: 2023-08-07 Page: 6 of 8



#### True stress-strain



Printed: 2023-08-07 Page: 7 of 8



#### **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.

Printed: 2023-08-07 Page: 8 of 8

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

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