

HOSTAFORM® CP15X

creep resistant, high viscosity acetal copolymer

Preliminary Data Sheet

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

Rheological properties

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

Typical mechanical properties

Tensile Modulus	2700 MPa	ISO 527-1/-2
Yield stress, 50mm/min	66 MPa	ISO 527-1/-2
Yield strain, 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

Thermal properties

Melting temperature, 10°C/min	167 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	92 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	163 °C	ISO 306
Coeff. of linear therm. expansion, parallel	100 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, 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

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 Temperature	100 - 120 °C	
Drying Time, Dehumidified Dryer	3 - 4 h	
Melt Temperature Optimum	205 °C	Internal
Max. mould temperature	90 - 120 °C	
Back pressure	4 MPa	
Injection speed	slow	

Characteristics

Additives	Release agent
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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.
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