

Celanese Hostaform[®] C 2521 G

Chemical abbreviation according to ISO 1043-1: POM
Information provided by Celanese

Physical Properties	Metric	English	Comments
Density	1.34 g/cc	0.0484 lb/in ³	ISO 1183
Water Absorption at Saturation	0.80 %	0.80 %	ISO 62
Melt Flow	1.5 g/10 min @Load 2.16 kg, Temperature 190 °C	1.5 g/10 min @Load 4.76 lb, Temperature 374 °F	[cm ³ /10min]; ISO 1133

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	44.0 MPa	6380 psi	50mm/min; ISO 527-2/1A
Elongation at Break	15 %	15 %	
Elongation at Yield	12 %	12 %	50mm/min; ISO 527-2/1A
Tensile Modulus	2.10 GPa	305 ksi	50mm/min; ISO 527-2/1A
Flexural Modulus	2.00 GPa	290 ksi	ISO 178
Charpy Impact Unnotched	5.00 J/cm ²	23.8 ft-lb/in ²	ISO 179/1eU
	5.00 J/cm ² @Temperature -30.0 °C	23.8 ft-lb/in ² @Temperature -22.0 °F	ISO 179/1eU
Charpy Impact, Notched	0.500 J/cm ²	2.38 ft-lb/in ²	ISO 179/1eA
	0.450 J/cm ² @Temperature -30.0 °C	2.14 ft-lb/in ² @Temperature -22.0 °F	ISO 179/1eA
Tensile Creep Modulus, 1 hour	1800 MPa	261000 psi	ISO 899-1
Tensile Creep Modulus, 1000 hours	1000 MPa	145000 psi	ISO 899-1

Electrical Properties	Metric	English	Comments
Volume Resistivity	1.00e+14 ohm-cm	1.00e+14 ohm-cm	IEC 60093
Surface Resistance	1.00e+14 ohm	1.00e+14 ohm	IEC 60093
Dielectric Constant	3.8 @Frequency 1e+6 Hz	3.8 @Frequency 1e+6 Hz	IEC 60250
	3.8 @Frequency 100 Hz	3.8 @Frequency 100 Hz	IEC 60250
Dielectric Strength	35.0 kV/mm	889 kV/in	IEC 60243-1
Dissipation Factor	0.0020 @Frequency 100 Hz	0.0020 @Frequency 100 Hz	IEC 60250
	0.0070 @Frequency 1e+6 Hz	0.0070 @Frequency 1e+6 Hz	IEC 60250

Thermal Properties	Metric	English	Comments
Comparative Tracking Index	600 V	600 V	IEC 60112
CTE, linear, Parallel to Flow	100 µm/m-°C	55.6 µin/in-°F	ISO 11359-2
Melting Point	165 °C	329 °F	10°C/min; ISO 11357-1,-2,-3
Deflection Temperature at 1.8 MPa (264 psi)	84.0 °C	183 °F	ISO 75-1, -2
Processing Properties	Metric	English	Comments
Processing Temperature	80.0 - 120 °C	176 - 248 °F	cavity
	190 - 210 °C	374 - 410 °F	hot runner
Feed Temperature	60.0 - 80.0 °C	140 - 176 °F	
Zone 1	170 - 180 °C	338 - 356 °F	
Zone 2	180 - 190 °C	356 - 374 °F	
Zone 3	190 - 200 °C	374 - 392 °F	
Zone 4	190 - 210 °C	374 - 410 °F	
Die Temperature	190 - 210 °C	374 - 410 °F	
Melt Temperature	190 - 210 °C	374 - 410 °F	
Drying Temperature	100 - 120 °C	212 - 248 °F	
Dry Time	3.00 - 4.00 hour	3.00 - 4.00 hour	
Moisture Content	<= 0.15 %	<= 0.15 %	
Injection Pressure	60.0 - 120 MPa	8700 - 17400 psi	
Hold Pressure	60.0 - 120 MPa	8700 - 17400 psi	
Back Pressure	<= 2.00 MPa	<= 290 psi	
Screw Speed	70 rpm @Diameter 55.0 mm	70 rpm @Diameter 2.17 in	
	100 rpm @Diameter 40.0 mm	100 rpm @Diameter 1.57 in	
	150 rpm @Diameter 25.0 mm	150 rpm @Diameter 0.984 in	