

Celanese Hostaform® C 36021

Hostaform® C 36021 is an unfilled acetal copolymer grade formulated for high flow while retaining a good balance of mechanical properties.

Information provided by Celanese

Physical Properties	Metric	English	Comments
Density	1.41 g/cc	0.0509 lb/in ³	ISO 1183
Linear Mold Shrinkage, Flow	0.019 cm/cm	0.019 in/in	ISO 294-4
Linear Mold Shrinkage, Transverse	0.018 cm/cm	0.018 in/in	ISO 294-4

Melt Flow	32 g/10 min @Load 2.16 kg, Temperature 190 °C	32 g/10 min @Load 4.76 lb, Temperature 374 °F	[cm ³ /10min]; ISO 1133
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Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	68.0 MPa	9860 psi	50mm/min; ISO 527-2/1A
Elongation at Yield	8.0 %	8.0 %	50mm/min; ISO 527-2/1A
Tensile Modulus	2.80 GPa	406 ksi	50mm/min; ISO 527-2/1A
Flexural Modulus	2.80 GPa	406 ksi	ISO 178
Charpy Impact, Notched	0.500 J/cm ²	2.38 ft-lb/in ²	ISO 179/1eA

Thermal Properties	Metric	English	Comments
CTE, linear, Parallel to Flow	110 µm/m-°C	61.1 µin/in-°F	ISO 11359-2
Melting Point	166 °C	331 °F	10°C/min; ISO 11357-1,-2,-3
Deflection Temperature at 1.8 MPa (264 psi)	103 °C	217 °F	ISO 75-1, -2

Processing Properties	Metric	English	Comments
Processing Temperature	80.0 - 120 °C	176 - 248 °F	cavity
Zone 1	170 - 180 °C	338 - 356 °F	
Zone 2	180 - 190 °C	356 - 374 °F	
Zone 3	180 - 190 °C	356 - 374 °F	
Zone 4	180 - 200 °C	356 - 392 °F	
Die Temperature	180 - 200 °C	356 - 392 °F	
Melt Temperature	180 - 200 °C	356 - 392 °F	
Drying Temperature	80.0 - 100 °C	176 - 212 °F	
Dry Time	3.00 - 4.00 hour	3.00 - 4.00 hour	
Injection Pressure	60.0 - 120 MPa	8700 - 17400 psi	
Hold Pressure	60.0 - 120 MPa	8700 - 17400 psi	
Back Pressure	<= 4.00 MPa	<= 580 psi	