



Hostaform® CP15X

Celanese Corporation - Acetal (POM) Copolymer

Saturday, November 2, 2019

General Information

Product Description

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.

General

Material Status	• Experimental: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Creep Resistant • General Purpose	• High Stiffness • High Viscosity	
Uses	• General Purpose		
RoHS Compliance	• Contact Manufacturer		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	1.70	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	2.0	%	
Flow	2.1	%	
Water Absorption (Saturation, 73°F)	0.75	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	392000	psi	ISO 527-2/1A
Tensile Stress (Yield)	9570	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	12	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	40	%	ISO 527-2/1A/50
Flexural Modulus (73°F)	355000	psi	ISO 178
Flexural Stress			ISO 178
3.5% Strain	10300	psi	
73°F	12600	psi	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	84		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	198	°F	ISO 75-2/A
Vicat Softening Temperature	325	°F	ISO 306/B50
Melting Temperature ²	333	°F	ISO 11357-3
Melting Temperature	329	°F	
CLTE - Flow	5.6E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	5.6E-5	in/in/°F	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093

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Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	356 to 392	°F
Middle Temperature	374 to 410	°F
Front Temperature	374 to 410	°F
Nozzle Temperature	383 to 419	°F
Processing (Melt) Temp	392 to 419	°F
Mold Temperature	194 to 248	°F
Injection Rate	Slow	
Back Pressure	< 580	psi

Injection Notes

Zone4 temperature: 195 to 215°C
Hot runner temperature: 195 to 215°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 10°C/min