



Hostaform® EC140CF10

Celanese Corporation - Acetal (POM) Copolymer

Saturday, November 2, 2019

General Information

Product Description

Hostaform® acetal copolymer grade EC140CF10 is a 10% carbon fiber reinforced grade for increase strength, stiffness and electrical conductivity.
Preliminary Data Sheet

General

Material Status	• Experimental: Active
Availability	• Africa & Middle East • Europe • Asia Pacific • Latin America • North America
Filler / Reinforcement	• Carbon Fiber, 10% Filler by Weight
Features	• Good Electrical Properties
RoHS Compliance	• Contact Manufacturer

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.44	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	12	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.0	%	
Flow	0.80	%	

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.23E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	10200	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.5	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.23E+6	psi	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	1.5	ft·lb/in ²	
73°F	1.5	ft·lb/in ²	

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (66 psi, Unannealed)	324	°F	ISO 75-2/B
Heat Deflection Temperature (264 psi, Unannealed)	316	°F	ISO 75-2/A
Melting Temperature ²	329	°F	ISO 11357-3
Melting Temperature	329	°F	
CLTE - Flow	1.7E-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+3	ohms	IEC 60093
Volume Resistivity	2.0E+3	ohms·cm	IEC 60093

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	338 to 356	°F

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Injection	Nominal Value	Unit
Middle Temperature	356 to 374	°F
Front Temperature	356 to 374	°F
Nozzle Temperature	374 to 392	°F
Processing (Melt) Temp	356 to 392	°F
Mold Temperature	176 to 248	°F
Injection Rate	Slow	
Back Pressure	< 290	psi

Injection Notes

Zone4 temperature: 190 to 200°C
Hot runner temperature: 190 to 210°C

Notes

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

² 10°C/min