



Hostaform® S 4000P CT

Celanese Corporation - Acetal (POM) Copolymer

Sunday, November 3, 2019

General Information

Product Description

Chemical abbreviation according to ISO 1043-1: POM-HI POM copolymer, modified Hostaform® S 4000P CT is an impact-modified acetal copolymer with high flowability for demanding injection molding applications. Hostaform® S 4000P CT has a significantly higher MVR compared to Hostaform® S 27064, with comparable mechanical properties, and is non-hygroscopic in nature. It is recommended for long flow length and/or thin-walled part geometries.

General

Material Status	• Experimental: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Impact Modifier		
Features	• High Flow	• Impact Modified	
Uses	• Thin-walled Parts		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.37	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	39	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 73°F)	0.65	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	232000	psi	ISO 527-2/1A
Tensile Stress (Yield)	5510	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	12	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	4.0	ft·lb/in ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ²	331	°F	ISO 11357-3

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.15	%
Hopper Temperature	68 to 86	°F
Rear Temperature	338 to 356	°F
Middle Temperature	356 to 374	°F
Front Temperature	374 to 392	°F
Nozzle Temperature	374 to 392	°F
Processing (Melt) Temp	374 to 392	°F
Mold Temperature	140 to 185	°F
Injection Rate	Slow-Moderate	
Back Pressure	< 290	psi

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Injection Notes

Feeding zone temperature: 60 to 80°C

Zone4 temperature: 190 to 200°C

Hot runner temperature: 190 to 200°C

Notes

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

² 10°C/min