



Hostaform® SlideX™ C0304 XAP²™

Celanese Corporation - Acetal (POM) Copolymer

Sunday, November 3, 2019

General Information

Product Description

POM copolymer Injection molding grade with tribological modification for demanding applications that require prevention of audible noise caused by stick-slip phenomenon. Excellent tribological performance with low friction and low wear under various conditions of sliding against plastics and metals. Reduced emission grade. Emissions according to VDA 275 < 5 mg/kg Preliminary Data Sheet

General

Material Status	• Experimental: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Low Emissions	• Low Friction	• Wear Resistant
RoHS Compliance	• Contact Manufacturer		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.40	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	26	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.8	%	
Flow	1.9	%	
Water Absorption (Saturation, 73°F)	0.65	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	377000	psi	ISO 527-2/1A
Tensile Stress (Yield)	8120	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	8.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	45	%	ISO 527-2/1A/50
Flexural Modulus (73°F)	341000	psi	ISO 178
Flexural Stress (73°F)	11200	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	2.6	ft·lb/in ²	
73°F	2.6	ft·lb/in ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	69	ft·lb/in ²	
73°F	71	ft·lb/in ²	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness ²	19100	psi	ISO 2039-1
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	194	°F	ISO 75-2/A
Vicat Softening Temperature	293	°F	ISO 306/B50
Melting Temperature ³	331	°F	ISO 11357-3
CLTE - Flow	7.8E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	7.8E-5	in/in/°F	ISO 11359-2

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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 347	°F
Middle Temperature	356 to 365	°F
Front Temperature	356 to 383	°F
Nozzle Temperature	374 to 392	°F
Processing (Melt) Temp	356 to 392	°F
Mold Temperature	176 to 248	°F
Injection Rate	Slow-Moderate	
Back Pressure	< 580	psi

Injection Notes

Feeding zone temperature: 60 to 80°C
Zone4 temperature: 180 to 200°C
Hot runner temperature: 190 to 200°C

Notes

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

² 30s

³ 10°C/min