HOSTAFORM® CP15X

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Preliminary Data Sheet
Hostaform® acetal copolymer grade CP15X is a creep resistant, high viscosity polymer providing excellent performance in injection molding. This grade provides overall excellent performance in applications requiring high stiffness over time.

Product information

Resin Identification	POM		ISO 1043
Part Marking Code	>POM<		ISO 11469

Rheological properties

Melt volume-flow rate	1.7	cm^3/10min	ISO 1133
Temperature	374	°F	
Load	4.76	lb	
Molding shrinkage, parallel	2.1	%	ISO 294-4, 2577
Molding shrinkage, normal	2.0	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	392000	psi	ISO 527-1/-2
Tensile stress at yield, 50mm/min	9600	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	12	%	ISO 527-1/-2
Nominal strain at break	40	%	ISO 527-1/-2
Flexural modulus	355000	psi	ISO 178
Flexural strength	12600	psi	ISO 178
Flexural stress at 3.5%	10300	psi	ISO 178
Hardness, Rockwell, M-scale	84		ISO 2039-2

Thermal properties

Melting temperature, 10°C/min	329	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	198	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.56	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.556	E-4/°F	ISO 11359-1/-2

Electrical properties

Volume resistivity	1E12	Ohm.m	IEC 62631-3-1
Surface resistivity	1E14	Ohm	IEC 62631-3-2

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Water absorption, 2mm	0.75	%	Sim. to ISO 62
Density	0.0509	lb/in^3	ISO 1183

Injection

Drying Recommended	no	
Drying Temperature	212	°F
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%

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Melt Temperature Optimum	401	°F
Min. melt temperature	392	°F
Max. melt temperature	419	°F
Max. screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	221	°F
Min. mold temperature	194	°F
Max. mold temperature	248	°F
Hold pressure range	8700 - 17400	psi
Hold Pressure Time (h is the max. wall thickness of the part in mm)	$2h^2$-3	s
Back pressure	580	psi
Ejection temperature	270	°F

Characteristics

Processing	Injection Molding, Extrusion
Additives	Release agent
Special characteristics	High viscosity, Improved creep

Additional information

Processing Notes

Pre-Drying

Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying may be necessary to prevent splay and odor problems.

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