HOSTAFORM® EC140CF10

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

Preliminary Data Sheet

Product information

Resin Identification	POM-CF10	ISO 1043
Part Marking Code	>POM-CF10<	ISO 11469

Rheological properties

Melt volume-flow rate	12	cm^3/10min	ISO 1133
Temperature	374	°F	
Load	4.76	lb	
Molding shrinkage, parallel	0.8	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	1.23E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	10200	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.5	%	ISO 527-1/-2
Flexural modulus	1.23E6	psi	ISO 178
Charpy notched impact strength, 23°C	1.52	$ftlb/in^2$	ISO 179/1eA
Charpy notched impact strength, -30°C	1.52	$ftlb/in^2$	ISO 179/1eA
Poisson's ratio	0.454		

Thermal properties

Melting temperature, 10°C/min	329	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	316	°F	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	324	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.17	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

Surface resistivity	1000	Ohm	IEC 62631-3-2
Resistivity, conductive plastics	0.2	Ohm.m	ISO 3915

Physical/Other properties

Density	0.052	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	%
Melt Temperature Optimum	392	°F
Min. melt temperature	374	°F

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Max. melt temperature	410	°F
Max. screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	212	°F
Min. mold temperature	176	°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	290	psi

Characteristics

Processing	Injection Molding
Special characteristics	Increased electrical conductivity, Static dissipative

Additional information

Processing Notes

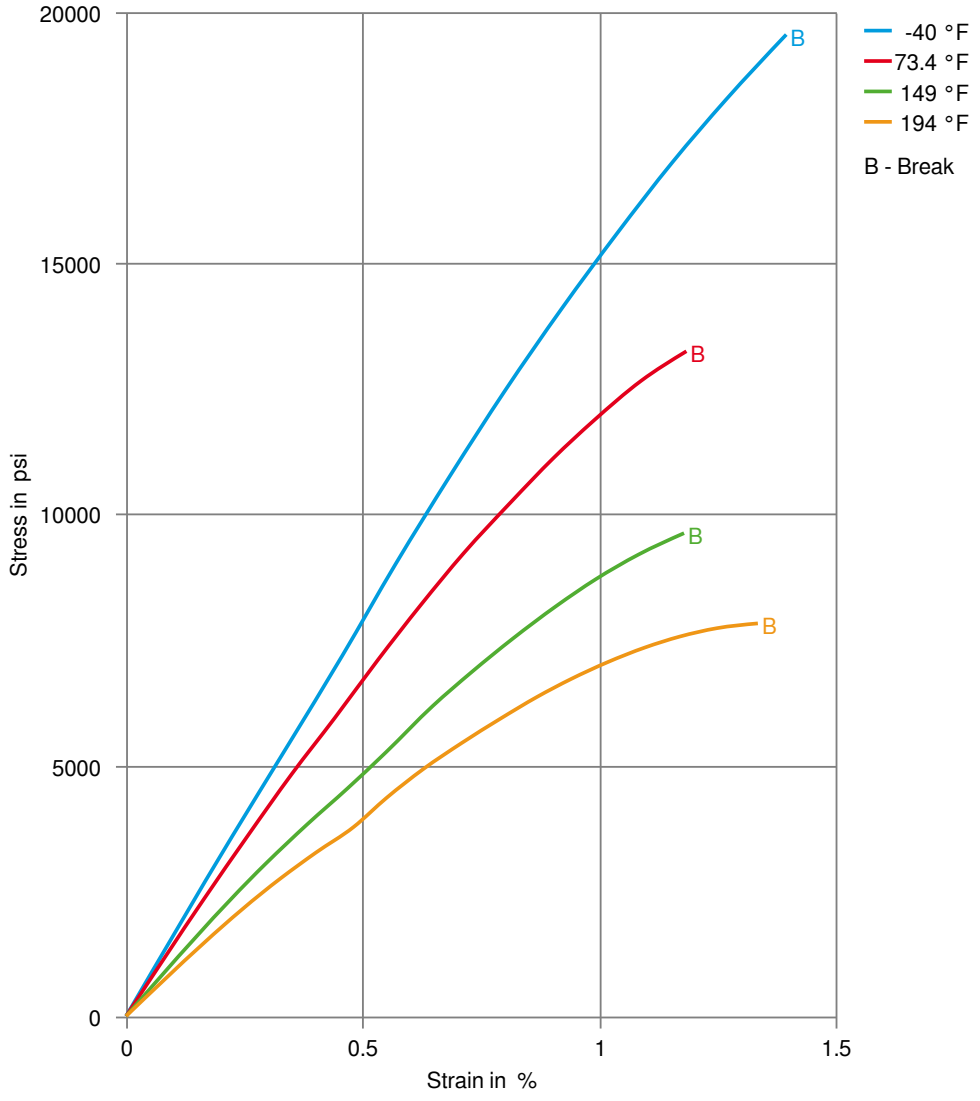
Pre-Drying

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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Stress-strain

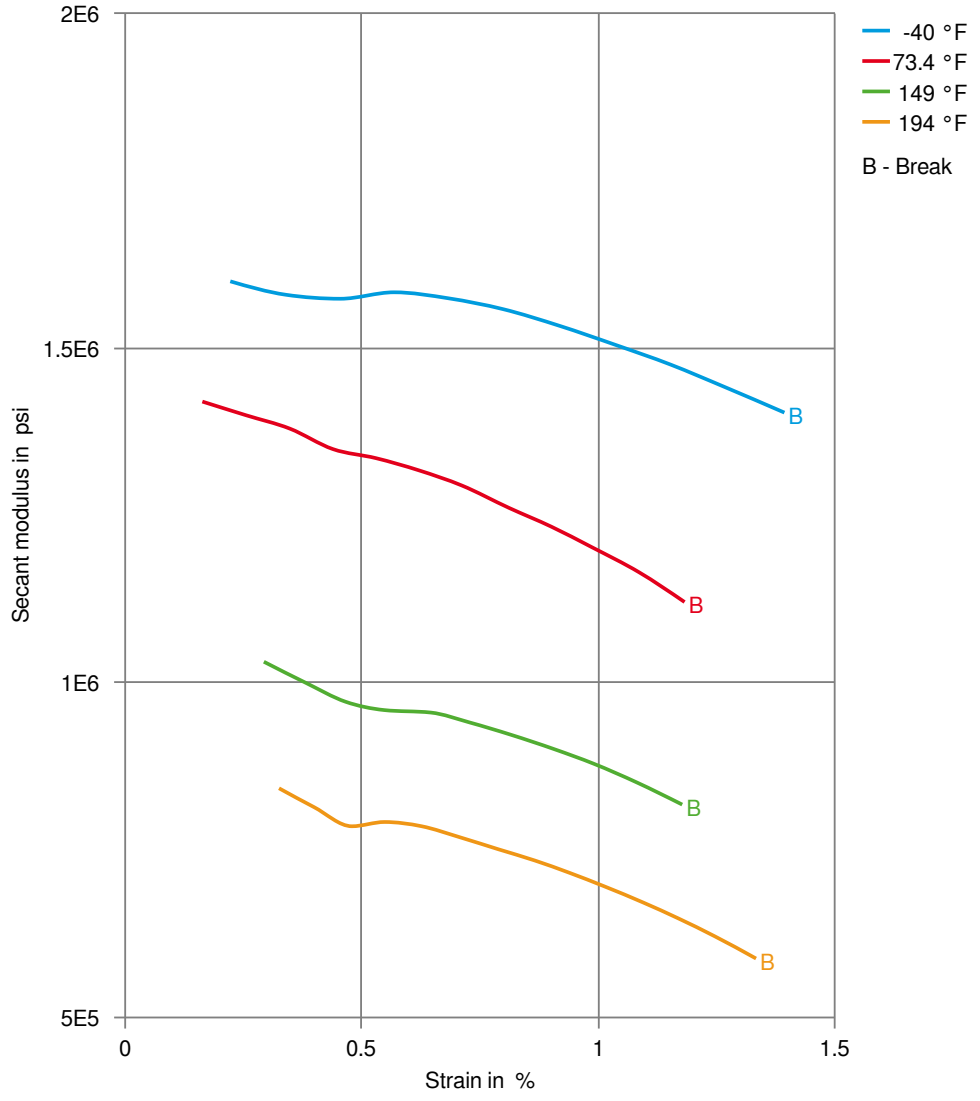


Revised: 2024-07-17 Source: Celanese Materials Database

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Secant modulus-strain



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