

HOSTAFORM® WR140LG - POM

Description

Hostaform® acetal copolymer grade WR140LG Black is a specialty weatherable grade of acetal copolymer formulated to provide good flow with a low gloss finish and a UV stability necessary for exterior automotive applications.

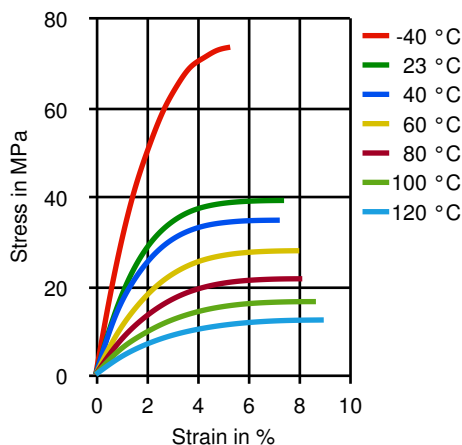
Physical properties	Value	Unit	Test Standard
Density	1330	kg/m ³	ISO 1183
Melt volume rate, MVR	13	cm ³ /10min	ISO 1133
MVR temperature	190	°C	ISO 1133
MVR load	2,16	kg	ISO 1133
Molding shrinkage, parallel	1,6	%	ISO 294-4, 2577
Molding shrinkage, normal	1,5	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	1800	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	41	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	10	%	ISO 527-2/1A
Flexural modulus, 23 °C	1850	MPa	ISO 178
Flexural stress at 3.5% strain	50	MPa	ISO 178
Charpy notched impact strength, 23 °C	3,6	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30 °C	3,6	kJ/m ²	ISO 179/1eA

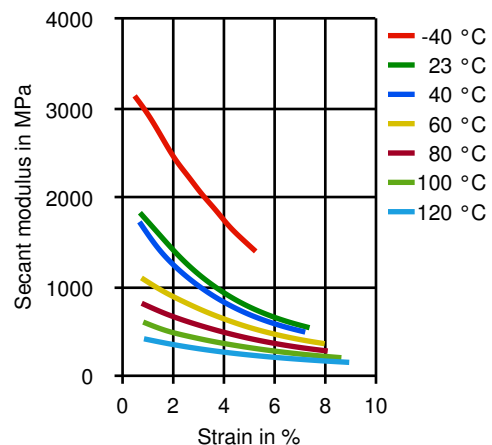
Thermal properties	Value	Unit	Test Standard
Melting temperature, 10 °C/min	165	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	80	°C	ISO 75-1, -2
Coeff. of linear therm expansion, parallel	1,3	E-4/°C	ISO 11359-2
Coeff. of linear therm expansion, normal	1,3	E-4/°C	ISO 11359-2

Diagrams

Stress-strain



Secant modulus-strain



Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Drying time	3 - 4	h	-
Drying temperature	100 - 120	°C	-
Temperature	Value	Unit	Test Standard
Zone1 temperature	170 - 175	°C	-
Zone2 temperature	170 - 180	°C	-
Zone3 temperature	175 - 185	°C	-
Zone4 temperature	180 - 190	°C	-
Nozzle temperature	185 - 195	°C	-
Melt temperature	180 - 195	°C	-

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Mold temperature	80 - 105	°C	-
Hot runner temperature	180 - 200	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	40	bar	-
Speed	Value	Unit	Test Standard
Injection speed	slow	-	-

Other text information

Pre-drying

Predrying is required before processing to ensure a low gloss finish. Use slow injection speed until material passes through gate, then increase.

Injection molding

Standard reciprocating screw injection molding machines with a high compression screw (minimum 3:1 and preferably 4:1) and low back pressure (0.35 Mpa/50 PSI) are favored. Using a low compression screw (I.E. general purpose 2:1 compression ratio) can result in unmelted particles and poor melt homogeneity. Using a high back pressure to make up for a low compression ratio may lead to excessive shear heating and deterioration of the material.

Melt Temperature: Preferred range 182-199 C (360-390 F). Melt temperature should never exceed 230 C (450 F).

Mold Surface Temperature: Preferred range 82-93 C (180-200 F) especially with wall thickness less than 1.5 mm (0.060 in.). May require mold temperature as high as 120 C (250 F) to reproduce mold surface or to assure minimal molded in stress. Wall thickness greater than 3mm (1/8 in.) may use a cooler (65 C/150 F) mold surface temperature and wall thickness over 6mm (1/4 in.) may use a cold mold surface down to 25 C (80 F). In general, mold surface temperatures lower than 82 C (180 F) may hinder weld line formation and produce a hazy surface or a surface with flow lines, pits and other included defects that can hinder part performance.

Characteristics

Special Characteristics

UV resistant

Delivery Form

Pellets

Processing

Injection molding

Contact Information

Americas

8040 Dixie Highway
Florence, KY 41042 USA
Product Information Service
t: +1-800-833-4882
t: +1-859-372-3244
Customer Service
t: +1-800-526-4960
t: +1-859-372-3214
e: info-engineeredmaterials-am@celanese.com

Asia

4560 Jinke Road
Zhang Jiang Hi Tech Park
Shanghai 201203 PRC
Customer Service
t: +86 21 3861 9266
f: +86 21 3861 9599
e: info-engineeredmaterials-
asia@celanese.com

Europe

Am Unisys-Park 1
65843 Sulzbach, Germany
Product Information Service
t: +49-800-86427-531
t: +49-(0)-69-45009-1011
e: info-engineeredmaterials-eu@celanese.com

General Disclaimer

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