

HOSTAFORM® C 9021 | POM | Unfilled

Description

Chemical abbreviation according to ISO 1043-1: POM
Molding compound ISO 9988- POM-K, M-GNR, 03-002

POM copolymer

Standard-Injection molding type with high rigidity, hardness and toughness; good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation.

Fulfils EG-directive 2002/72/EU as well as the recommendation XXXIII for consumer goods of the BgVV,
FDA compliant according to 21 CFR 177.2470

UL-registration for all colours and a thickness more than 1.5 mm as UL 94 HB, temperature index UL 746 B electrical 110 °C, mechanical 90 °C.

Burning rate ISO 3795 and FMVSS 302 < 75 mm/min for a thickness more than 1 mm.

Ranges of applications: automotive engineering, precision engineering, electric and electronical industry, domestic appliances.

FDA = Food and Drug Administration (USA)
BgVV = Bundesinstitut für gesundheitlichen Verbraucherschutz und Veterinärmedizin
FMVSS = Federal Motor Vehicle Safety Standard (USA)
UL = Underwriters Laboratories (USA)

Physical properties	Value	Unit	Test Standard
Density	1410	kg/m ³	ISO 1183
Melt volume rate (MVR)	8	cm ³ /10min	ISO 1133
MVR test temperature	190	°C	ISO 1133
MVR test load	2.16	kg	ISO 1133
Mold shrinkage - parallel	2	%	ISO 294-4
Mold shrinkage - normal	1.8	%	ISO 294-4
Water absorption (23°C-sat)	0.65	%	ISO 62

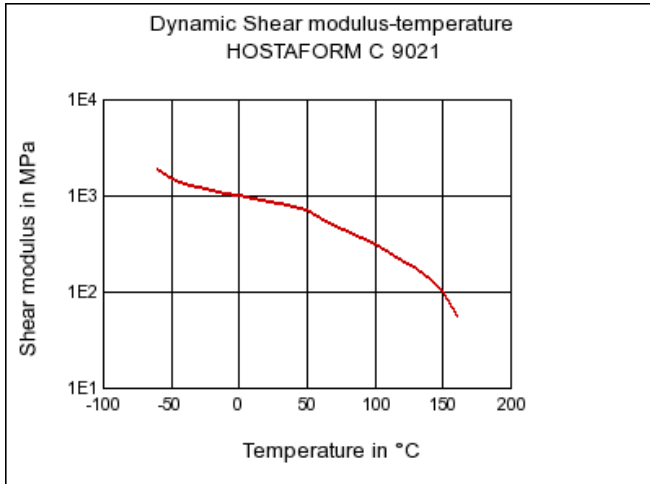
Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	2850	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	64	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	9	%	ISO 527-2/1A
Nominal strain at break (50mm/min)	30	%	ISO 527-2/1A
Tensile creep modulus (1h)	2500	MPa	ISO 899-1
Tensile creep modulus (1000h)	1300	MPa	ISO 899-1
Flexural modulus (23°C)	2700	MPa	ISO 178
Charpy impact strength @ 23°C	180P	kJ/m ²	ISO 179/1eU
Charpy impact strength @ -30°C	160	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	6.5	kJ/m ²	ISO 179/1eA
Charpy notched impact strength @ -30°C	6	kJ/m ²	ISO 179/1eA

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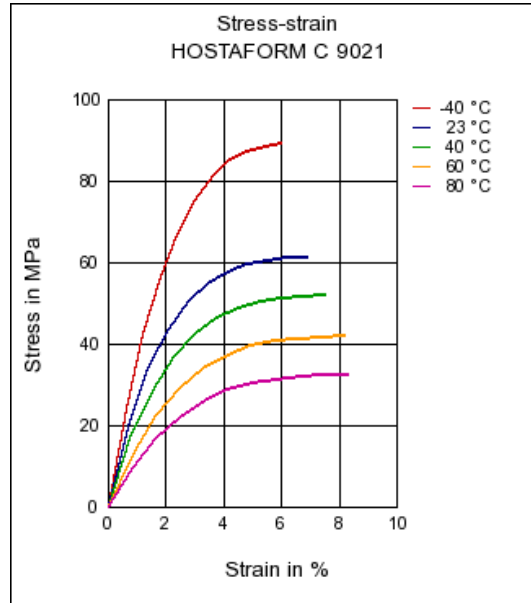
Mechanical properties	Value	Unit	Test Standard
Ball indentation hardness 30 sec value	144	N/mm ²	ISO 2039-1
Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	166	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	104	°C	ISO 75-1/-2
Vicat softening temperature B50 (50°C/h 50N)	150	°C	ISO 306
Coeff.of linear therm. expansion (parallel)	1.1	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	1.1	E-4/°C	ISO 11359-2
Flammability @1.6mm nom. thickn.	HB	class	UL94
thickness tested (1.6)	1.5	mm	UL94
UL recognition (1.6)	UL	-	UL94
Flammability at thickness h	HB	class	UL94
thickness tested (h)	3	mm	UL94
UL recognition (h)	UL	-	UL94
Electrical properties	Value	Unit	Test Standard
Relative permittivity - 100 Hz	4	-	IEC 60250
Relative permittivity - 1 MHz	4	-	IEC 60250
Dissipation factor - 100 Hz	20	E-4	IEC 60250
Dissipation factor - 1 MHz	50	E-4	IEC 60250
Volume resistivity	1E12	Ohm*m	IEC 60093
Surface resistivity	1E14	Ohm	IEC 60093
Electric strength	35	kV/mm	IEC 60243-1
Comparative tracking index CTI	600	-	IEC 60112
Test specimen production	Value	Unit	Test Standard
Processing conditions acc. ISO	9988	-	Internal
Rheological Calculation properties	Value	Unit	Test Standard
Density of melt	1200	kg/m ³	Internal
Thermal conductivity of melt	0.155	W/(m K)	Internal
Specific heat capacity of melt	2210	J/(kg K)	Internal
Eff. thermal diffusivity	4.85E-8	m ² /s	Internal
Ejection temperature	165	°C	Internal

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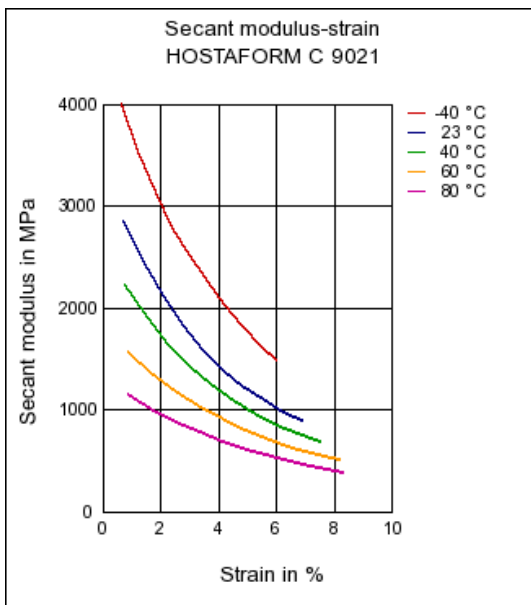
Dynamic Shear modulus-temperature



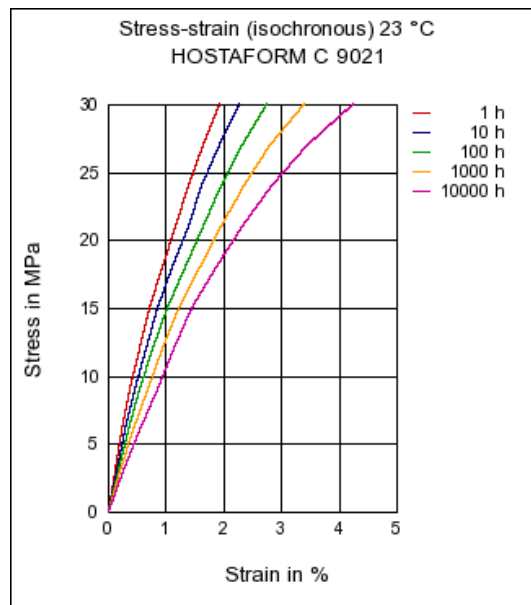
Stress-strain



Secant modulus-strain

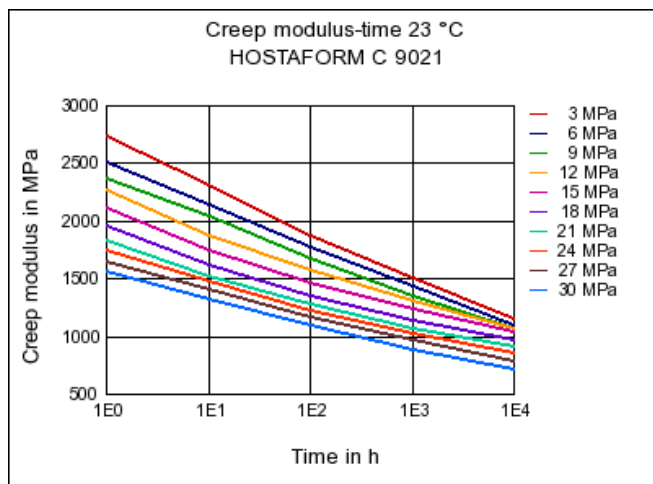


Stress-strain (isochronous)

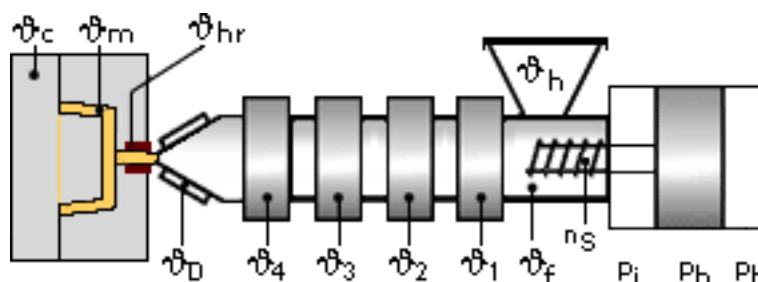


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Creep modulus-time



Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.15%

It is normally not necessary to dry HOSTAFORM. However, should there be surface moisture (condensate) on the molding compound as a result of incorrect storage, drying is required. A circulating air drying cabinet can be used for this purpose if the granules

The product can then be stored in standard conditions until processed.

Drying time: 3 - 4 h

Drying temperature: 120 - 140 °C

Temperature:

	ϕ Manifold	ϕ Mold	ϕ Melt	ϕ Nozzle	ϕ Zone4	ϕ Zone3	ϕ Zone2	ϕ Zone1	ϕ Feed	ϕ Hopper
min (°C)	190	80	190	190	190	190	180	170	60	20
max (°C)	210	120	210	210	210	200	190	180	80	30

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Pressure:

	Inj press	Hold press	Back pressure
min (bar)	600	600	0
max (bar)	1200	1200	40

Speed:

Injection speed: slow-medium

Screw speed

Screw diameter (mm)	16	25	40	55	75
Screw speed (RPM)	-	150	100	70	-

Injection Molding

Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.

Melt temperature	190-230 °C
Mould temperature	60-120 °C

Film Extrusion

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature	180-190 °C
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Other Extrusion

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature	180-190 °C
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Sheet Extrusion

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature	180-190 °C
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General Disclaimer

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values.

Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use.

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We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed (+49 (0) 69 30516299 for Europe and +1 859-372-3244 for the Americas) for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.

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