

HOSTAFORM® C 9021 GV1/20 - POM

Description

Chemical abbreviation according to ISO 1043-1: POM Molding compound ISO 9988- POM-K, M-GNR, 02-003, GF20 POM copolymer Injection molding type, reinforced with ca. 20 % glass fibers; high resistance to thermal and oxidative degradation; reduced thermal expansion and shrinkage. UL-registration in natural and black and a thickness more than 1.5 mm as UL 94 HB, temperature index UL 746 B, electrical 105 °C, mechanical 105 °C Burning rate ISO 3795 and FMVSS 302 < 100 mm/min for a thickness more than 1 mm thickness. Ranges of applications: For molded parts with high strength and rigidity as well as higher hardness. FMVSS = Federal Motor Vehicle Safety Standard (USA) UL = Underwriters Laboratories (USA)

Physical properties	Value	Unit	Test Standard
Density	1550	kg/m ³	ISO 1183
Melt volume rate, MVR	4.5	cm ³ /10min	ISO 1133
MVR temperature	190	°C	ISO 1133
MVR load	2.16	kg	ISO 1133
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	ISO 294-4, 2577
Water absorption, 23°C-sat	0.85	%	ISO 62
Humidity absorption, 23°C/50%RH	0.19	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	7200	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	120	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	3	%	ISO 527-2/1A
Tensile creep modulus, 1h	6500	MPa	ISO 899-1
Tensile creep modulus, 1000h	4000	MPa	ISO 899-1
Flexural modulus, 23°C	6900	MPa	ISO 178
Flexural stress at break	170	MPa	ISO 178
Flexural strain at break	3.4	%	ISO 178
Charpy impact strength, 23°C	35	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	40	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	8	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	8	kJ/m ²	ISO 179/1eA
Ball indentation hardness, 30s	190	MPa	ISO 2039-1

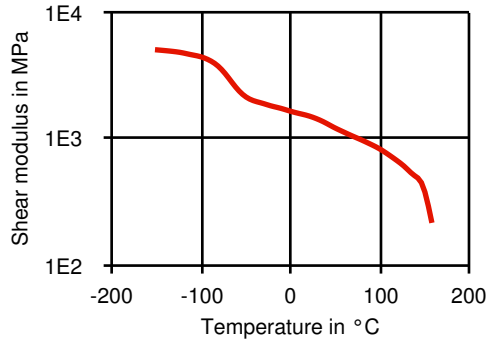
Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	159	°C	ISO 75-1, -2
DTUL at 8.0 MPa	105	°C	ISO 75-1, -2
Coeff. of linear therm expansion, parallel	0.5	E-4/°C	ISO 11359-2
Coeff. of linear therm expansion, normal	0.8	E-4/°C	ISO 11359-2
Flammability @1.6mm nom. thickn.	HB	class	UL 94
thickness tested (1.6)	1.5	mm	UL 94
UL recognition (1.6)	UL	-	UL 94
Flammability at thickness h	HB	class	UL 94
thickness tested (h)	3.00	mm	UL 94
UL recognition (h)	UL	-	UL 94

Electrical properties	Value	Unit	Test Standard
Relative permittivity, 100Hz	4.3	-	IEC 60250
Relative permittivity, 1MHz	4.3	-	IEC 60250
Dissipation factor, 100Hz	30	E-4	IEC 60250
Dissipation factor, 1MHz	60	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	600	-	IEC 60112

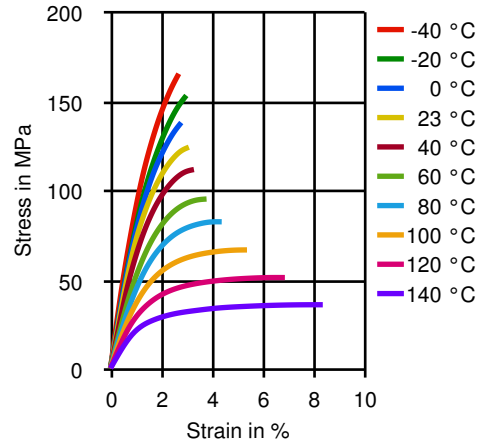
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Diagrams

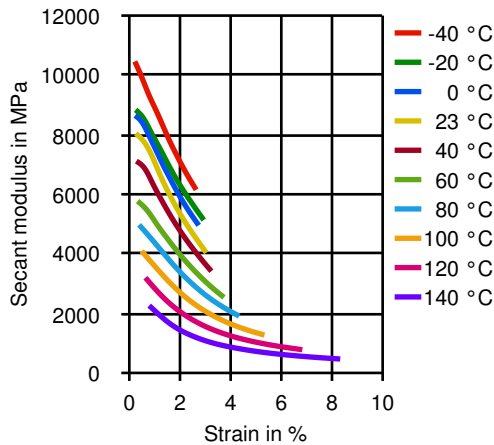
Dynamic Shear modulus-temperature



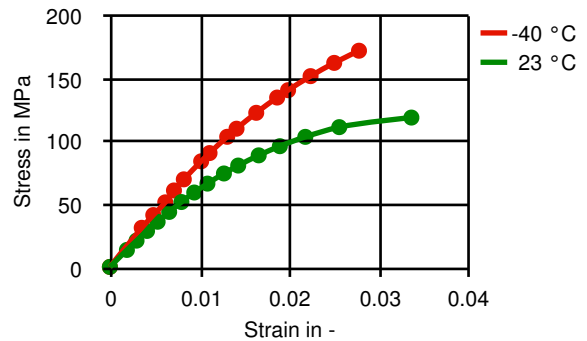
Stress-strain



Secant modulus-strain



True Stress-strain



Typical injection moulding processing conditions

	Value	Unit	Test Standard
Pre Drying			
Necessary low maximum residual moisture content	0.15	%	-
Drying time	3 - 4	h	-
Drying temperature	100 - 120	°C	-
Temperature			
Hopper temperature	20 - 30	°C	-
Feeding zone temperature	60 - 80	°C	-
Zone1 temperature	170 - 180	°C	-
Zone2 temperature	180 - 190	°C	-
Zone3 temperature	190 - 200	°C	-
Zone4 temperature	190 - 210	°C	-
Nozzle temperature	190 - 210	°C	-
Melt temperature	190 - 210	°C	-
Mold temperature	80 - 120	°C	-
Hot runner temperature	190 - 210	°C	-
Pressure			
Back pressure max.	20	bar	-
Speed			
Injection speed	slow	-	-

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Screw Speed	Value	Unit	Test Standard
Screw speed diameter, 25mm	150	RPM	-
Screw speed diameter, 40mm	100	RPM	-
Screw speed diameter, 55mm	70	RPM	-

Other text information

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.

Longer pre-drying times/storage

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

Injection molding

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

Melt temperature 190-210 °C

Mould temperature 80-120 °C

Characteristics

Product Categories

Glass reinforced

Delivery Form

Pellets

Processing

Injection molding

Additives

Release agent

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. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users seek

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