

HOSTAFORM® C 9021 GV3/30 TF2

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Injection molding grade with 30% glass beads, for low warpage parts, slip modified with PTFE

Product information

Resin Identification	(POM+PTFE)-GB30	ISO 1043
Part Marking Code	>(POM+PTFE)-GB30<	ISO 11469

Rheological properties

Melt volume-flow rate	7.5 cm ³ /10min	ISO 1133
Temperature	190 °C	
Load	2.16 kg	

Typical mechanical properties

Tensile modulus	3800 MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	38 MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	5 %	ISO 527-1/-2
Nominal strain at break	13 %	ISO 527-1/-2
Charpy notched impact strength, 23°C	2.5 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.36 ^[C]	

[C]: Calculated

Thermal properties

Melting temperature, 10°C/min	166 °C	ISO 11357-1/-3
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Physical/Other properties

Density	1630 kg/m ³	ISO 1183
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Injection

Drying Recommended	no
Drying Temperature	100 °C
Drying Time, Dehumidified Dryer	3 - 4 h
Processing Moisture Content	≤0.2 %
Melt Temperature Optimum	200 °C
Min. melt temperature	190 °C
Max. melt temperature	210 °C
Screw tangential speed	≤0.3 m/s
Mold Temperature Optimum	100 °C
Min. mould temperature	80 °C
Max. mould temperature	120 °C
Hold pressure range	60 - 120 MPa

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Release agent
Special characteristics	Low wear / Low friction, Low Warpage

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Additional information

Injection molding

Preprocessing

General drying is not necessary due to low moisture absorption of the resin.

In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended.

Max. Water content 0,2 %

Processing

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

Postprocessing

Conditioning e.g. moisturizing is not necessary.