

HOSTAFORM® C 2521 | POM | Unfilled

Description

Chemical abbreviation according to ISO 1043-1: POM
Molding compound ISO 9988- POM-K, M-GNR, 01-002

POM copolymer

Stiff-flowing type for injection molding and extrusion with high impact toughness and good tracking resistance over a high range of temperature; good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation.

Fulfills EG-directive 2002/72/EU as well as the recommendation XXXIII for consumer goods of the BgVV, corresponding to FDA-regulation for food contact.

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: injection molding thick-walled, void-free molded parts; extrusion e.g. for boards and pipes.

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)	2.5	cm ³ /10min	ISO 1133
MVR test temperature	190	°C	ISO 1133
MVR test load	2.16	kg	ISO 1133
Mold shrinkage - parallel	2.1	%	ISO 294-4
Mold shrinkage - normal	1.8	%	ISO 294-4
Water absorption (23°C-sat)	0.65	%	ISO 62
Humidity absorption (23°C/50%RH)	0.2	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	2600	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	62	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	9	%	ISO 527-2/1A
Nominal strain at break (50mm/min)	32	%	ISO 527-2/1A
Tensile creep modulus (1h)	2300	MPa	ISO 899-1
Tensile creep modulus (1000h)	1100	MPa	ISO 899-1
Charpy impact strength @ 23°C	220P	kJ/m ²	ISO 179/1eU
Charpy impact strength @ -30°C	200	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	8.5	kJ/m ²	ISO 179/1eA
Charpy notched impact strength @ -30°C	7	kJ/m ²	ISO 179/1eA

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Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	165	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	101	°C	ISO 75-1/-2
Vicat softening temperature B50 (50°C/h 50N)	151	°C	ISO 306
Coeff. of linear therm. expansion (parallel)	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

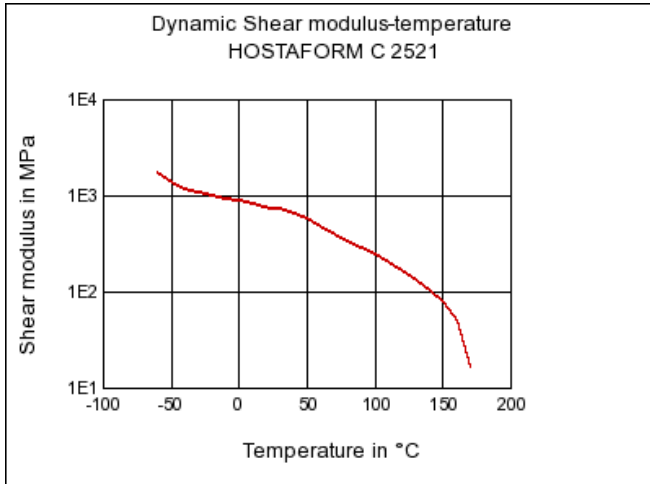
Electrical properties	Value	Unit	Test Standard
Relative permittivity - 100 Hz	4	-	IEC 60250
Relative permittivity - 1 MHz	4	-	IEC 60250
Dissipation factor - 100 Hz	15	E-4	IEC 60250
Dissipation factor - 1 MHz	50	E-4	IEC 60250
Volume resistivity	1E12	Ohm*m	IEC 60093
Surface resistivity	1E14	Ohm	IEC 60093
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
Injection molding melt temperature	195	°C	ISO 294
Injection molding mold temperature	85	°C	ISO 294
Injection molding flow front velocity	200	mm/s	ISO 294
Injection molding hold pressure	90	MPa	ISO 294

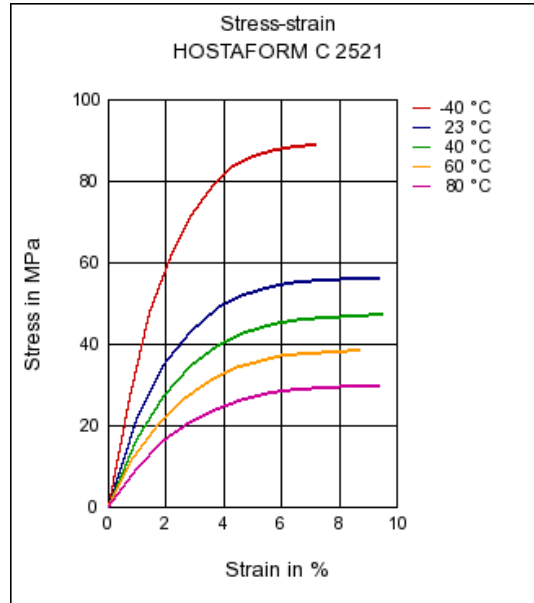
Rheological Calculation properties	Value	Unit	Test Standard
Density of melt	1200	kg/m ³	Internal
Thermal conductivity of melt	0.155	W/(m K)	Internal
Specific heat capacity of melt	2210	J/(kg K)	Internal
Ejection temperature	165	°C	Internal

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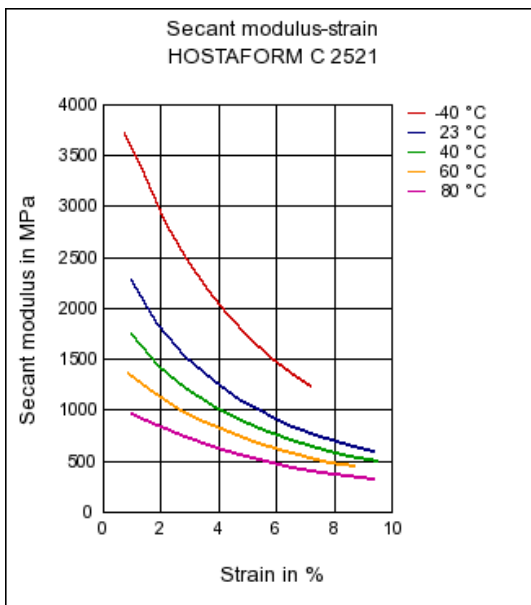
Dynamic Shear modulus-temperature



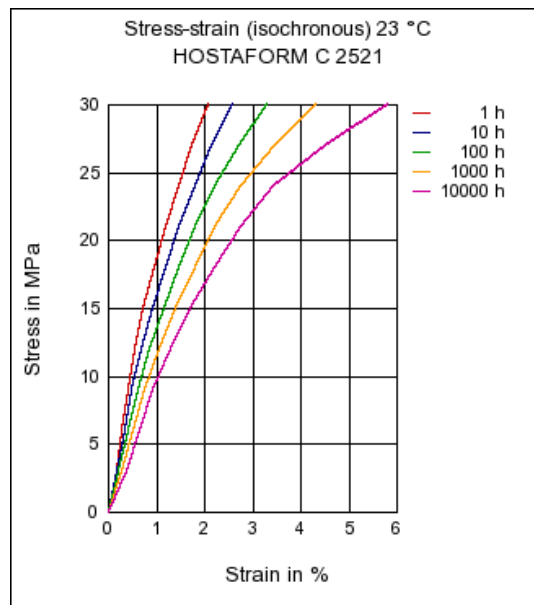
Stress-strain



Secant modulus-strain

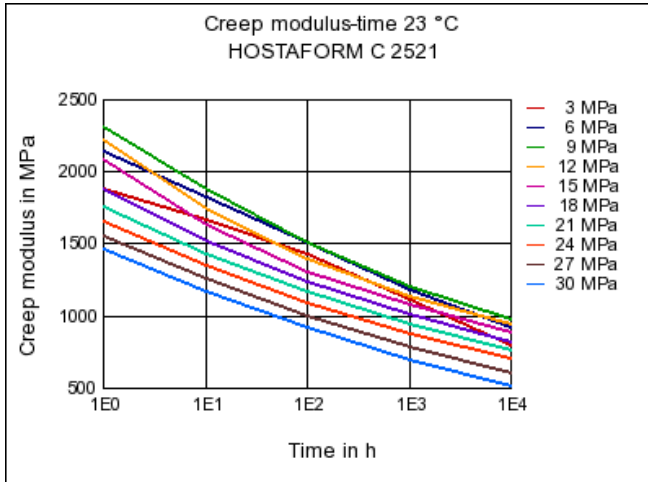


Stress-strain (isochronous)

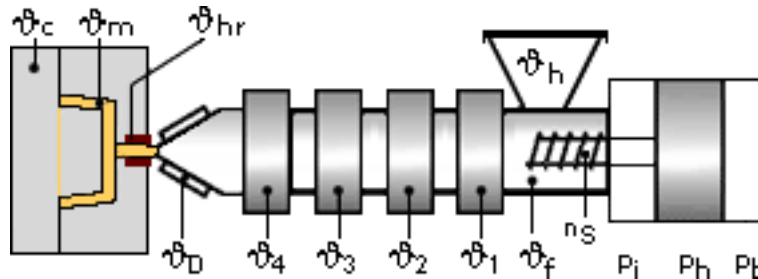


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Creep modulus-time



Typical injection moulding processing conditions



Maximum residual moisture content: 0.1500%

Processing Temperatures:

	ϕ _{Cavity}	ϕ _{Melt}	ϕ _{Hot Runner}	ϕ _{Die}	ϕ ₄	ϕ ₃	ϕ ₂	ϕ ₁	ϕ _{Feeding}	ϕ _{Hopper}
min (°C)	80	190	190	190	190	190	180	170	60	20
max (°C)	120	210	210	210	210	200	190	180	80	30

Processing Pressures:

	Injection Pressure	Holding Pressure	Back Pressure
min (bar)	600	600	0
max (bar)	1200	1200	40

Injection speed: slow - medium

Screw speed:

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Screw diameter (mm)	25	40	55
Screw speed (rpm)	120	100	70

Pre-drying conditions:

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

Special information:

No special information available.

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

Melt temperature 180-190 °C

Blow Molding

Standard extruders with plasticating screws (20 to 25 D) will fit.

Melt temperature 180-190 °C

Mould-surface temperature 60-100 °C

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**0,06€/Call + local landline rates

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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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