

## HOSTAFORM® C 36021 | POM | Unfilled

### Description

Hostaform® C 36021 is an unfilled acetal copolymer grade formulated for high flow while retaining a good balance of mechanical properties.

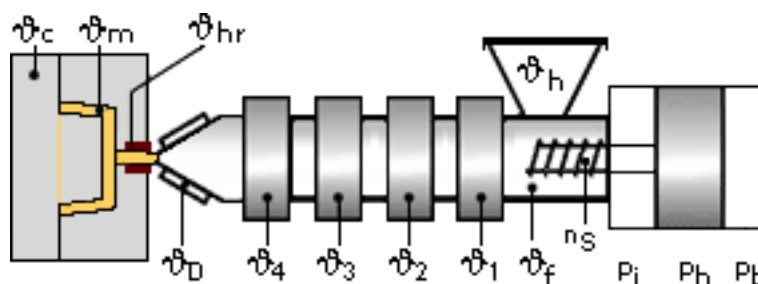
Chemical abbreviation according to ISO 1043-1: POM

Physical properties	Value	Unit	Test Standard
Density	<b>1410</b>	kg/m <sup>3</sup>	ISO 1183
Melt volume rate (MVR)	<b>32</b>	cm <sup>3</sup> /10min	ISO 1133
MVR test temperature	<b>190</b>	°C	ISO 1133
MVR test load	<b>2.16</b>	kg	ISO 1133
Mold shrinkage - parallel	<b>1.9</b>	%	ISO 294-4
Mold shrinkage - normal	<b>1.8</b>	%	ISO 294-4

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	<b>2800</b>	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	<b>68</b>	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	<b>8</b>	%	ISO 527-2/1A
Flexural modulus (23°C)	<b>2800</b>	MPa	ISO 178
Charpy notched impact strength @ 23°C	<b>5.0</b>	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	<b>166</b>	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	<b>103</b>	°C	ISO 75-1/-2
Coeff.of linear therm. expansion (parallel)	<b>1.1</b>	E-4/°C	ISO 11359-2

### Typical injection moulding processing conditions



#### Pre Drying:

Normally not necessary to dry Hostaform. However, drying is recommended for the best surface finish. Product can be stored in standard conditions until processed.

**Drying time: 3 - 4 h**

**Drying temperature: 80 - 100 °C**

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### Temperature:

	ϕ_Mold	ϕ_Melt	ϕ_Nozzle	ϕ_Zone4	ϕ_Zone3	ϕ_Zone2	ϕ_Zone1
min (°C)	80	180	180	180	180	180	170
max (°C)	120	200	200	200	190	190	180

### Pressure:

	Inj press	Hold press	Back pressure
min (bar)	600	600	0
max (bar)	1200	1200	5

### Speed:

**Injection speed: medium**

## Injection Molding

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

Melt temperature 190-230 °C  
Mould temperature 80-120 °C

## Contact Information

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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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