

HOSTAFORM® C 9021 GV3/20 | POM | Glass Reinforced

Description

Chemical abbreviation according to ISO 1043-1: POM
Molding compound ISO 9988- POM-K, M-GNR, 03-002, GB20

POM copolymer

Injection molding type, reinforced with ca. 20 % glass spheres; high resistance to thermal and oxidative degradation.

UL-registration in natural and a thickness more than 0.81 mm, in black and a thickness more than 1.5 mm as UL94 HB, temperature index UL 746 B for a thickness of 3 mm, electrical 105 °C, mechanical 95 °C (tensile impact) and 100 °C (tensile).

Burning rate ISO 3795 and FMVSS 302 < 100 mm/min for a thickness more than 1 mm.

Ranges of applications: For low-warpage molded parts with higher rigidity and hardness.

FMVSS = Federal Motor Vehicle Safety Standard (USA)

UL = Underwriters Laboratories (USA)

Physical properties	Value	Unit	Test Standard
Density	1530	kg/m ³	ISO 1183
Melt volume rate (MVR)	8.5	cm ³ /10min	ISO 1133
MVR test temperature	190	°C	ISO 1133
MVR test load	2.16	kg	ISO 1133
Water absorption (23°C-sat)	0.8	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	3400	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	46	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	6.5	%	ISO 527-2/1A
Nominal strain at break (50mm/min)	15	%	ISO 527-2/1A
Tensile creep modulus (1h)	3000	MPa	ISO 899-1
Tensile creep modulus (1000h)	1700	MPa	ISO 899-1
Flexural modulus (23°C)	3200	MPa	ISO 178
Charpy impact strength @ 23°C	50	kJ/m ²	ISO 179/1eU
Charpy impact strength @ -30°C	50	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	3.5	kJ/m ²	ISO 179/1eA
Charpy notched impact strength @ -30°C	3.5	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	166	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	110	°C	ISO 75-1/-2
Coeff.of linear therm. expansion (parallel)	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)	0.81	mm	UL94

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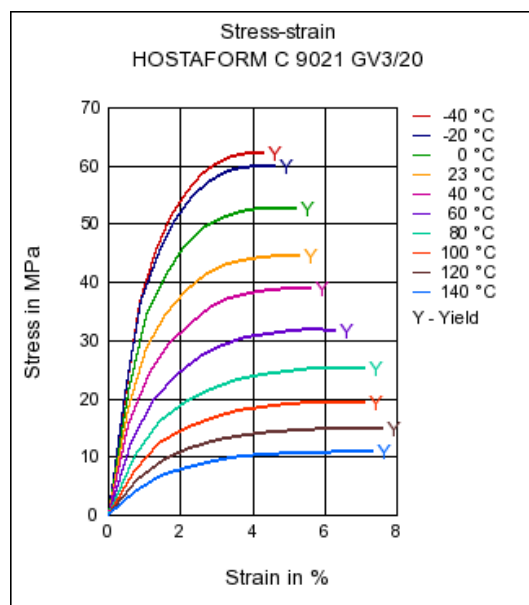
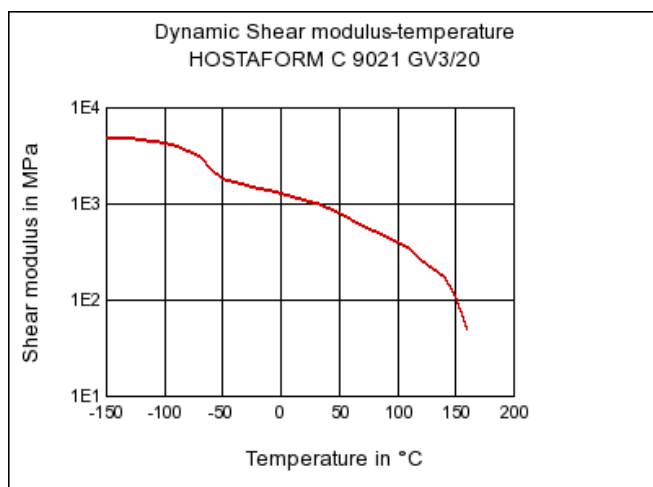
Thermal properties	Value	Unit	Test Standard
UL recognition (h)	UL	-	UL94

Electrical properties	Value	Unit	Test Standard
Relative permittivity - 100 Hz	4.5	-	IEC 60250
Relative permittivity - 1 MHz	4.2	-	IEC 60250
Dissipation factor - 100 Hz	200	E-4	IEC 60250
Dissipation factor - 1 MHz	70	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

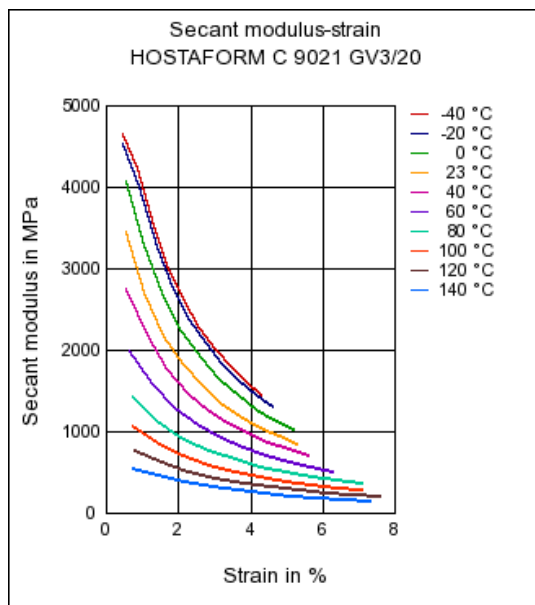
Dynamic Shear modulus-temperature

Stress-strain

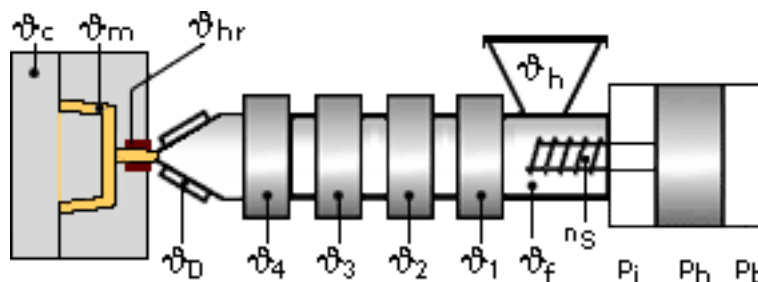


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Secant modulus-strain



Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.15%

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.

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

Drying time: 3 - 4 h

Drying temperature: 100 - 120 °C

Temperature:

	T_{Manifold}	T_{Mold}	T_{Melt}	T_{Nozzle}	T_{Zone4}	T_{Zone3}	T_{Zone2}	T_{Zone1}	T_{Feed}	T_{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	20

Speed:

Injection speed: slow

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	80-120 °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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