

Hostaform® C 9021 GV1/20 XGM

Acetal (POM) Copolymer

Celanese Corporation

Message:

Chemical abbreviation according to ISO 1043-1: POM

Molding compound ISO 9988- POM-K, M-GS2, 02-003, GF20

POM copolymer

Injection molding type, reinforced with ca 20 % glass fibers; includes PTFE for improved wear performance; high resistance to thermal and oxidative degradation; reduced thermal expansion and shrinkage.

Ranges of applications: For molded parts requiring improved low wear performance while exhibiting very high strength and rigidity as well as higher hardness.

FMVSS = Federal Motor Vehicle Safety Standard (USA)

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	PTFE lubricant		
Features	Rigidity, high		
	High strength		
	Good wear resistance		
	Lubrication		
	Low shrinkage		
	High hardness		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Resin ID (ISO 1043)	POM		
Physical	Nominal Value	Unit	Test Method
Density	1.57	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	4.00	cm³/10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7700	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	100	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.5	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	7400	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	5.5	kJ/m²	ISO 179/1eA
23°C	5.5	kJ/m²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ¹	166	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	3.0E-5	cm/cm/°C	ISO 11359-2

Lateral	9.0E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	100 - 120	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.15	%	
Hopper Temperature	20.0 - 30.0	°C	
Rear Temperature	170 - 180	°C	
Middle Temperature	180 - 190	°C	
Front Temperature	190 - 200	°C	
Nozzle Temperature	190 - 210	°C	
Processing (Melt) Temp	190 - 210	°C	
Mold Temperature	80.0 - 120	°C	
Injection Pressure	60.0 - 120	MPa	
Injection Rate	Slow		
Holding Pressure	60.0 - 120	MPa	
Back Pressure	0.00 - 0.500	MPa	
Injection instructions			
Manifold Temperature: 190 to 210°C Zone 4 Temperature: 190 to 210°C Feed Temperature: 60 to 80°C			
NOTE			
1.	10°C/min		

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