

Hostaform® C 9021 GV1/20

Acetal (POM) Copolymer

Celanese Corporation

Message:

Chemical abbreviation according to ISO 1043-1: POM

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

POM copolymer

Injection molding type, reinforced with ca. 20 % glass fibers; high resistance to thermal and oxidative degradation; reduced thermal expansion and shrinkage.

UL-registration in natural and black and a thickness more than 1.5 mm as UL 94 HB, temperature index UL 746 B, electrical 105°C, mechanical 105°C

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

Ranges of applications: For molded parts with high strength and rigidity as well as higher hardness.

FMVSS = Federal Motor Vehicle Safety Standard (USA)

UL = Underwriters Laboratories (USA)

General Information			
UL YellowCard	E42337-234613		
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Features	Rigidity, high		
	High strength		
	High hardness		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)		
	Shear Modulus vs. Temperature (ISO 11403-1)		
Resin ID (ISO 1043)	POM		
Physical	Nominal Value	Unit	Test Method
Density	1.57	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	4.50	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 23°C)	0.85	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7200	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	120	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.0	%	ISO 527-2/1A/5
Tensile Creep Modulus			ISO 899-1
1 hr	6500	MPa	ISO 899-1
1000 hr	4000	MPa	ISO 899-1

Flexural Modulus (23°C)	6900	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	8.0	kJ/m ²	ISO 179/1eA
23°C	8.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	40	kJ/m ²	ISO 179/1eU
23°C	35	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, not annealed	159	°C	ISO 75-2/A
8.0 MPa, not annealed	105	°C	ISO 75-2/C
Melting Temperature ¹	166	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	5.0E-5	cm/cm/°C	ISO 11359-2
Lateral	8.0E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms · cm	IEC 60093
Dielectric Strength	35	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	4.30		IEC 60250
1 MHz	4.30		IEC 60250
Dissipation Factor			IEC 60250
100 Hz	3.0E-3		IEC 60250
1 MHz	6.0E-3		IEC 60250
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.50 mm	HB		UL 94
3.00 mm	HB		UL 94
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 - 2.00	MPa

Injection instructions

Manifold Temperature: 190 to 210°CZone 4 Temperature: 190 to 210°CFeed Temperature: 60 to 80°C

NOTE

1.
- 10°C/min

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