

Hostaform® C 9021 S1

Acetal (POM) Copolymer

Celanese Corporation

Message:

POM copolymer

Standard-Injection molding type with high rigidity, hardness and toughness; good chemical resistance. Modified with 1% silicon oil

Available in natural and colored

Monomers and additives are listed in EU-Regulation (EU) 10/2011

FDA compliant according to 21 CFR 177.2470

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

Ranges of applications: precision engineering, electric and electronical industry, domestic appliances.

FDA = Food and Drug Administration (USA)

FMVSS = Federal Motor Vehicle Safety Standard (USA)

General Information			
Additive	Silicone lubricant (1%)		
Features	Rigidity, high		
	Good chemical resistance		
	Good toughness		
	Lubrication		
	High hardness		
Agency Ratings	FDA 21 CFR 177.2470		
	Europe 10/1/2011 12:00:00 AM		
RoHS Compliance	Contact manufacturer		
Appearance	Available colors		
	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	1.8	%	ISO 294-4
Flow direction	2.0	%	ISO 294-4
Water Absorption (Saturation, 23°C)	0.65	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2700	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	60.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	12	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	35	%	ISO 527-2/1A/50

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	6.0	kJ/m ²	ISO 179/1eA
23°C	6.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	160	kJ/m ²	ISO 179/1eU
23°C, local fracture	180	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ¹	166	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.1E-4	cm/cm/°C	ISO 11359-2
Lateral	1.1E-4	cm/cm/°C	ISO 11359-2
Fill Analysis	Nominal Value	Unit	Test Method
Density of Melt	1.200	g/cm ³	Internal method
Ejection Temperature	165	°C	Internal method
Specific Heat Capacity of Melt	2210	J/kg/°C	Internal method
Thermal Conductivity of Melt	0.16	W/m/K	Internal method
Effective Thermal Diffusivity	0.0485	cSt	Internal method
Injection	Nominal Value	Unit	
Drying Temperature	120 - 140	°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-Moderate		
Holding Pressure	60.0 - 120	MPa	
Back Pressure	0.00 - 4.00	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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