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HOSTAFORM® C 2521 G

Stiff-flowing grade for injection molding and extrusion; modified with (R) GUR (PE-UHMW)
Chemical abbreviation according to ISO 1043-1: POM Molding compound ISO 29988- POM-K, M-GNS, 01-001 POM copolymer Stiff-flowing type for injection molding and extrusion, modified with (R) GUR (PE-UHMW); good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation; with GUR (PE-UHMW) modified extrusion type, therefore very good lubricating properties. Burning rate ISO 3795 and FMVSS 302 < 100 mm/min for a thickness more than 1 mm. Ranges of applications: For injection molding parts and semi-finished products with higher requirements on lubricating properties. FMVSS = Federal Motor Vehicle Safety Standard (USA)

Product information

Part Marking Code	POM		ISO 11469

Rheological properties

Melt volume-flow rate	1.5	cm^3/10min	ISO 1133
Temperature	190	°C	
Load	2.16	kg	

Typical mechanical properties

Tensile Modulus	2100	MPa	ISO 527-1/-2
Yield stress, 50mm/min	44	MPa	ISO 527-1/-2
Yield strain, 50mm/min	12	%	ISO 527-1/-2
Nominal strain at break	15	%	ISO 527-1/-2
Flexural Modulus	2000	MPa	ISO 178
Tensile creep modulus, 1h	1800	MPa	ISO 899-1
Tensile creep modulus, 1000h	1000	MPa	ISO 899-1
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	5	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	4.5	kJ/m^2	ISO 179/1eA
Ball indentation hardness, H 358/30	110	MPa	ISO 2039-1

Thermal properties

Melting temperature, 10°C/min	165	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	84	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	140	°C	ISO 306
Coeff. of linear therm. expansion, parallel	100	E-6/K	ISO 11359-1/-2

Electrical properties

Relative permittivity, 100Hz	3.8		IEC 62631-2-1
Relative permittivity, 1MHz	3.8		IEC 62631-2-1
Dissipation factor, 100Hz	20	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	70	E-4	IEC 62631-2-1
Volume resistivity	1E12	Ohm.m	IEC 62631-3-1

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Surface resistivity	1E14	Ohm	IEC 62631-3-2
Electric strength	35	kV/mm	IEC 60243-1
Comparative tracking index	PLC 0	PLC	UL 746A

Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Water absorption, 2mm	0.8	%	Sim. to ISO 62
Density	1340	kg/m³	ISO 1183

Injection

Drying Temperature	100 - 120	°C
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	0.15	%
Screw tangential speed	0.2 - 0.21	m/s
Max. mould temperature	80 - 120	°C
Back pressure	2	MPa
Injection speed	slow	

Characteristics

Additives	Release agent

Additional information

Injection molding	Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.
Film extrusion	Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit. Melt temperature 180-190 °C
Other extrusion	Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit. Melt temperature 180-190 °C

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Profile extrusion

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	Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit. Melt temperature 180-190 °C
Sheet extrusion	Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit. Melt temperature 180-190 °C

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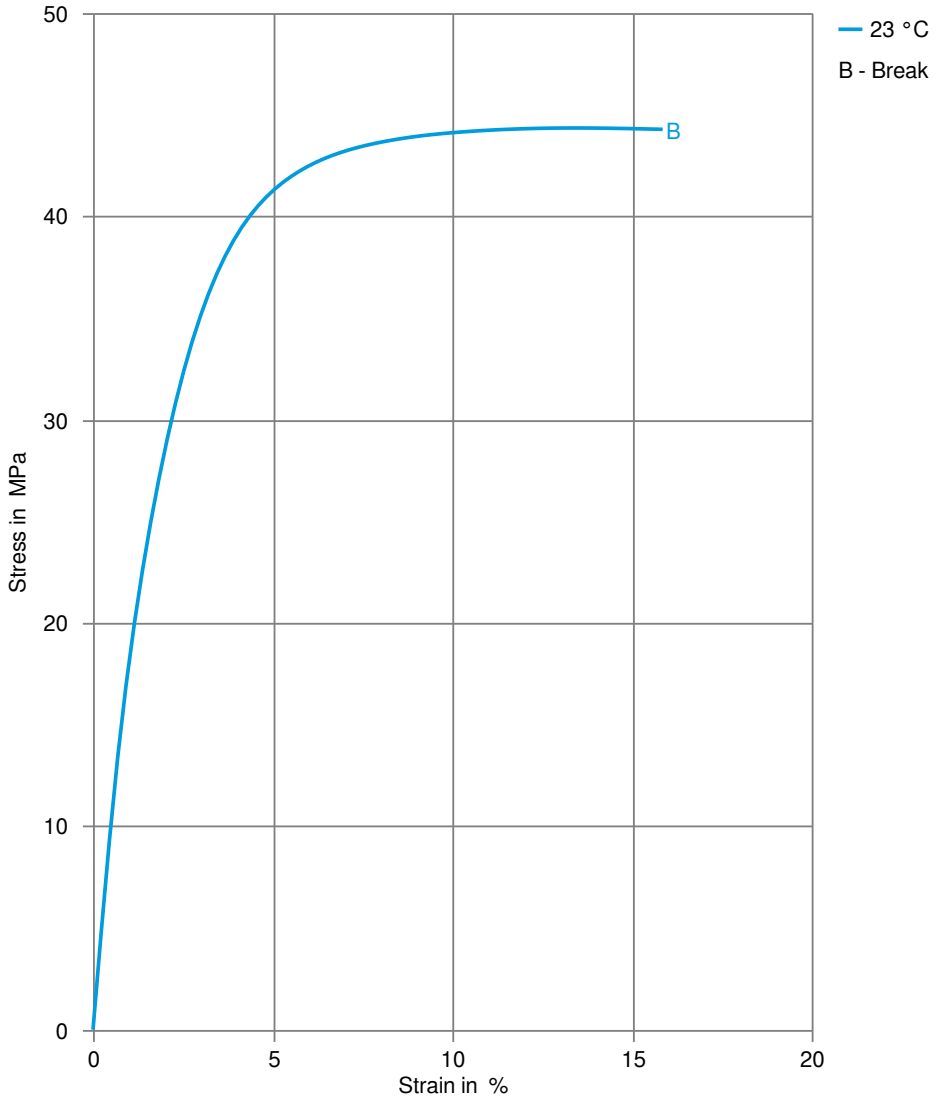
Stress-strain



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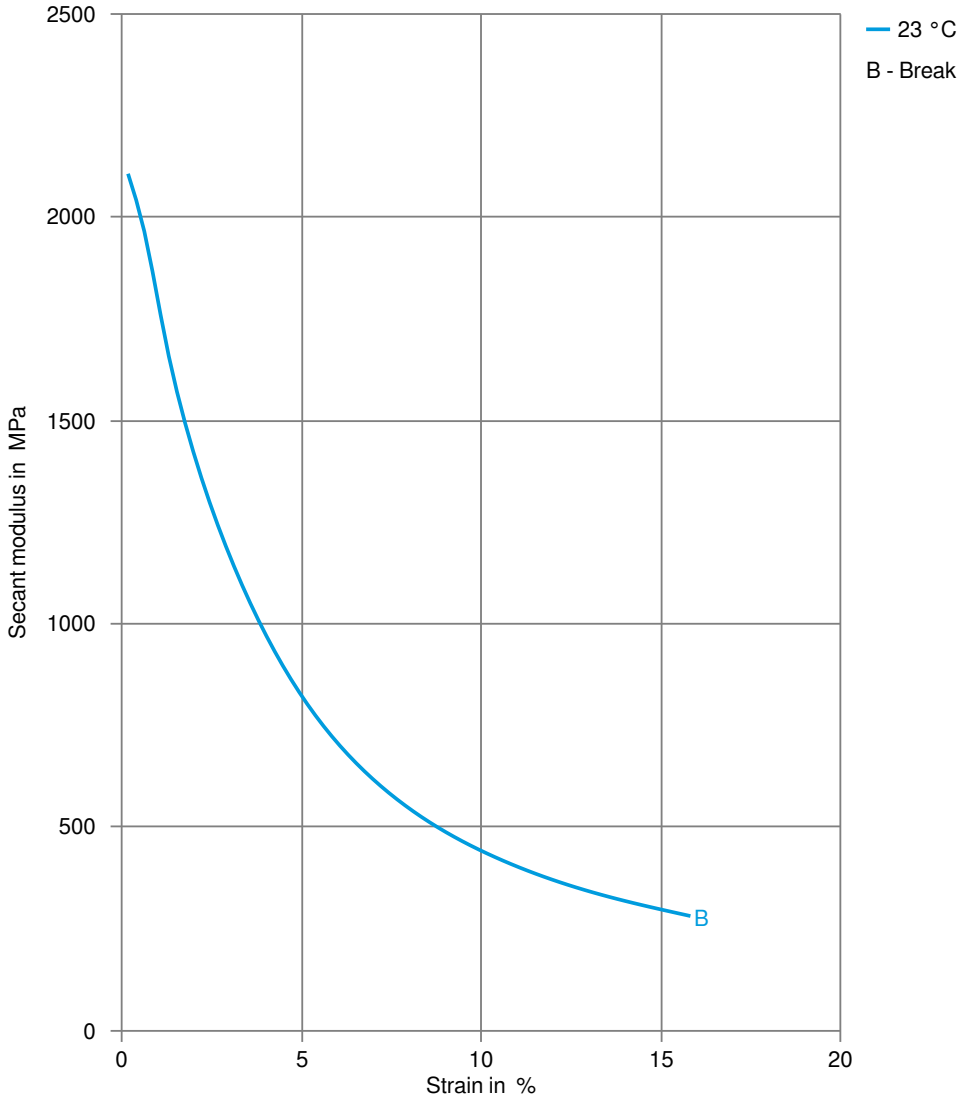
Secant modulus-strain



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Processing Texts

Pre-drying	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.
Longer pre-drying times/storage	The product can then be stored in standard conditions until processed.
Injection molding	Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.
Injection molding Preprocessing	General drying is not necessary due to low moisture absorption of the resin. In case of bad storage conditions (water contact or condensed water) the use of a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended. Max. Water content 0,2 %
Injection molding Postprocessing	Conditioning e.g. moisturizing is not necessary.

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