

HOSTAFORM® C 2521 LS

Stiff-flowing grade for injection molding and extrusion, UV resistant
 POM copolymer

Stiff-flowing type for injection molding and extrusion with high impact toughness and good tracking resistance over a high range of temperature; good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation. This grade has been specially stabilized to prevent discoloration and deterioration of mechanical properties from ultraviolet light exposure. The material is available in natural, black and colored.

Burning rate ISO 3795 and FMVSS 302 < 75 mm/min for a thickness more than 1 mm.

Ranges of applications: injection molding thick-walled, void-free molded parts; extrusion e.g. for boards and pipes.

FMVSS = Federal Motor Vehicle Safety Standard (USA)

Rheological properties

Melt volume-flow rate	2.5 cm ³ /10min	ISO 1133
Temperature	190 °C	
Load	2.16 kg	
Moulding shrinkage range, parallel	2.1 %	ISO 294-4, 2577
Moulding shrinkage range, normal	1.8 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	2600 MPa	ISO 527-1/-2
Yield stress, 50mm/min	62 MPa	ISO 527-1/-2
Yield strain, 50mm/min	9 %	ISO 527-1/-2
Nominal strain at break	32 %	ISO 527-1/-2
Flexural Modulus	2500 MPa	ISO 178
Tensile creep modulus, 1h	2300 MPa	ISO 899-1
Tensile creep modulus, 1000h	1100 MPa	ISO 899-1
Charpy impact strength, 23°C	250 ^[P] kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	250 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	8.5 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	7 kJ/m ²	ISO 179/1eA
Ball indentation hardness, H 358/30	144 MPa	ISO 2039-1

[P]: Partial Break

Thermal properties

Melting temperature, 10°C/min	165 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	101 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	151 °C	ISO 306
Coeff. of linear therm. expansion, parallel	110 E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.155 W/(m K)	Internal
Spec. heat capacity of melt	2210 J/(kg K)	Internal



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Electrical properties

Relative permittivity, 100Hz	4	IEC 62631-2-1
Relative permittivity, 1MHz	4	IEC 62631-2-1
Dissipation factor, 100Hz	15 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	50 E-4	IEC 62631-2-1
Volume resistivity	1E12 Ohm.m	IEC 62631-3-1
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	0.65 %	Sim. to ISO 62
Density	1410 kg/m³	ISO 1183
Density of melt	1200 kg/m³	Internal

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	4 MPa	
Injection speed	slow-medium	
Ejection temperature	140 °C	Internal

Characteristics

Additives	Release agent
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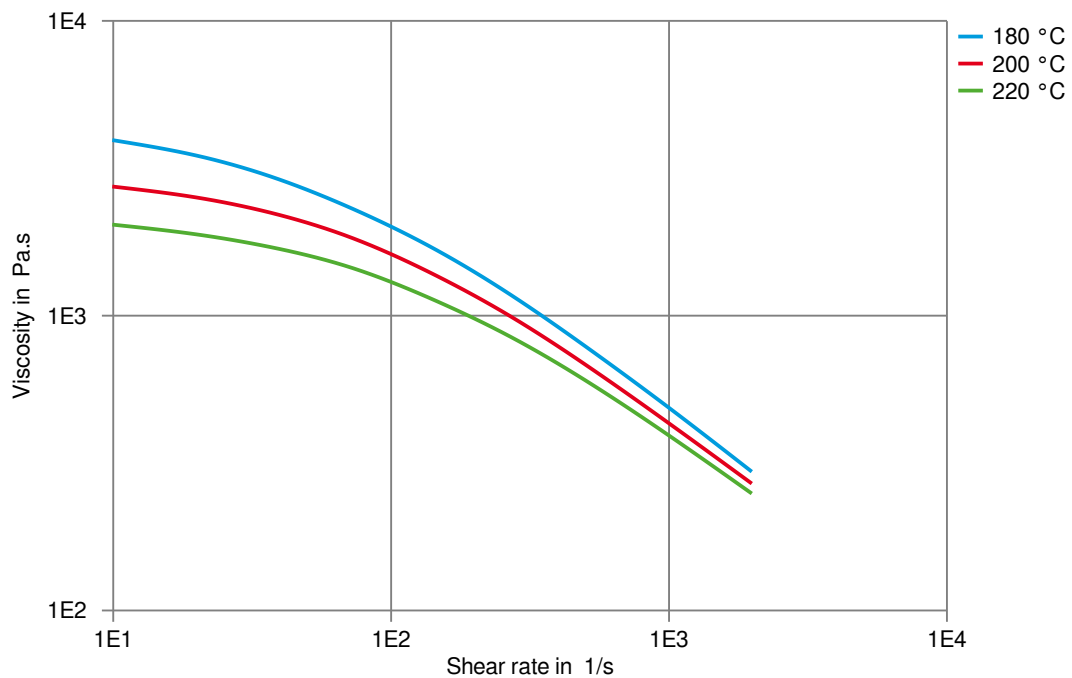
Additional information

Injection molding	Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.
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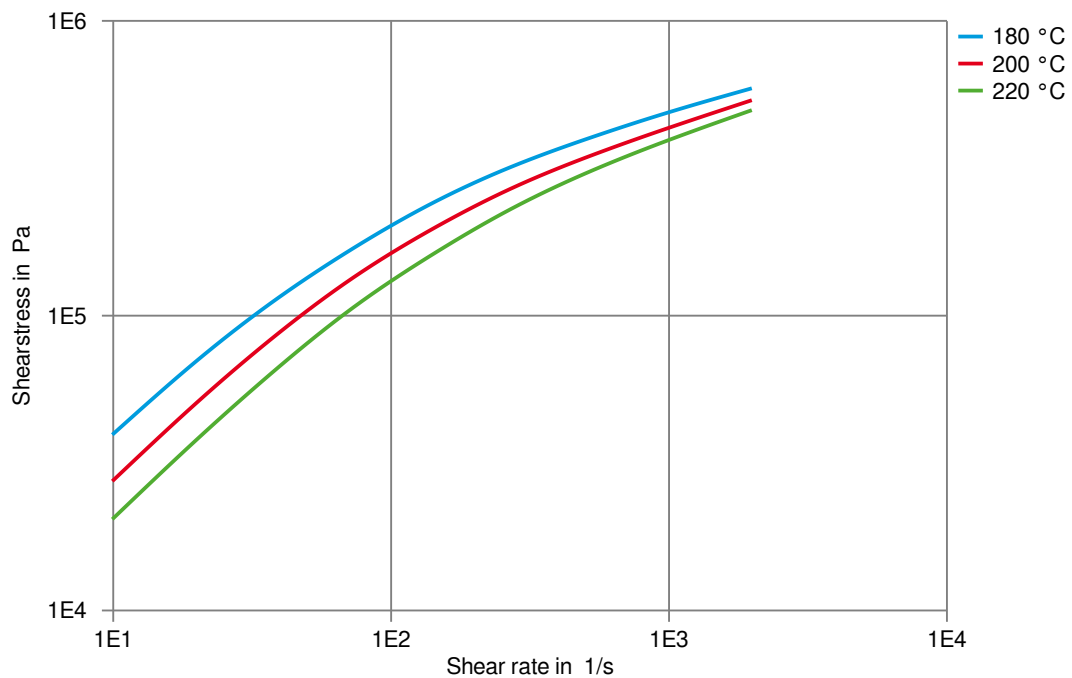
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Viscosity-shear rate



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Shearstress-shear rate

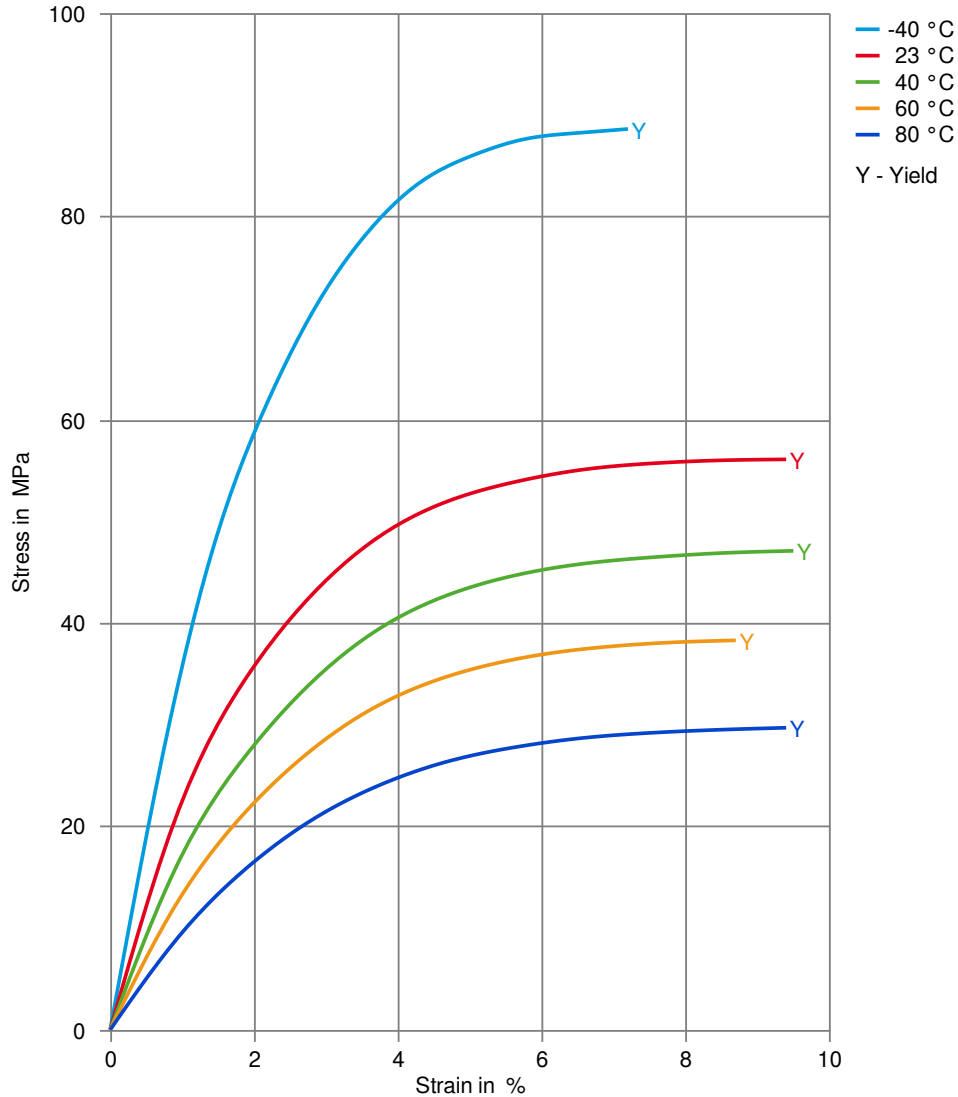


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Stress-strain

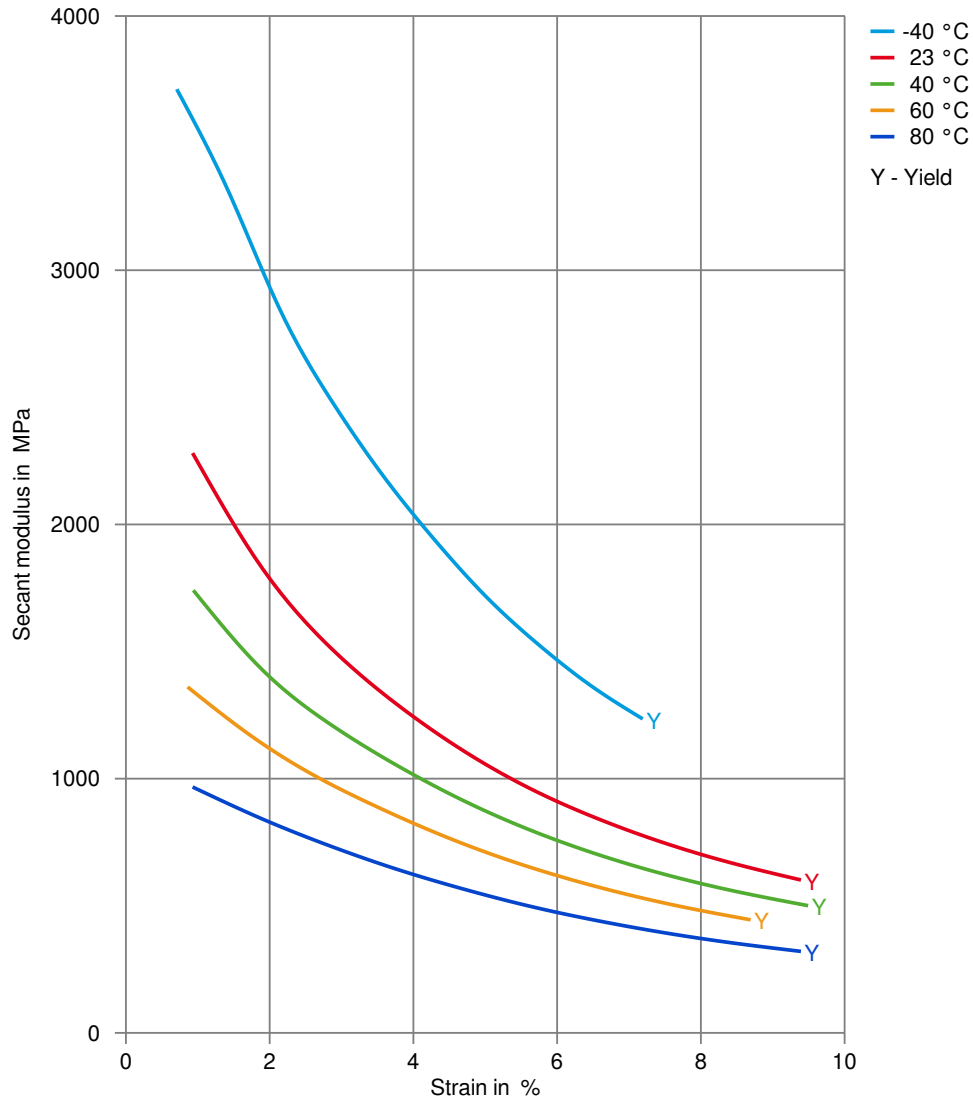


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Secant modulus-strain

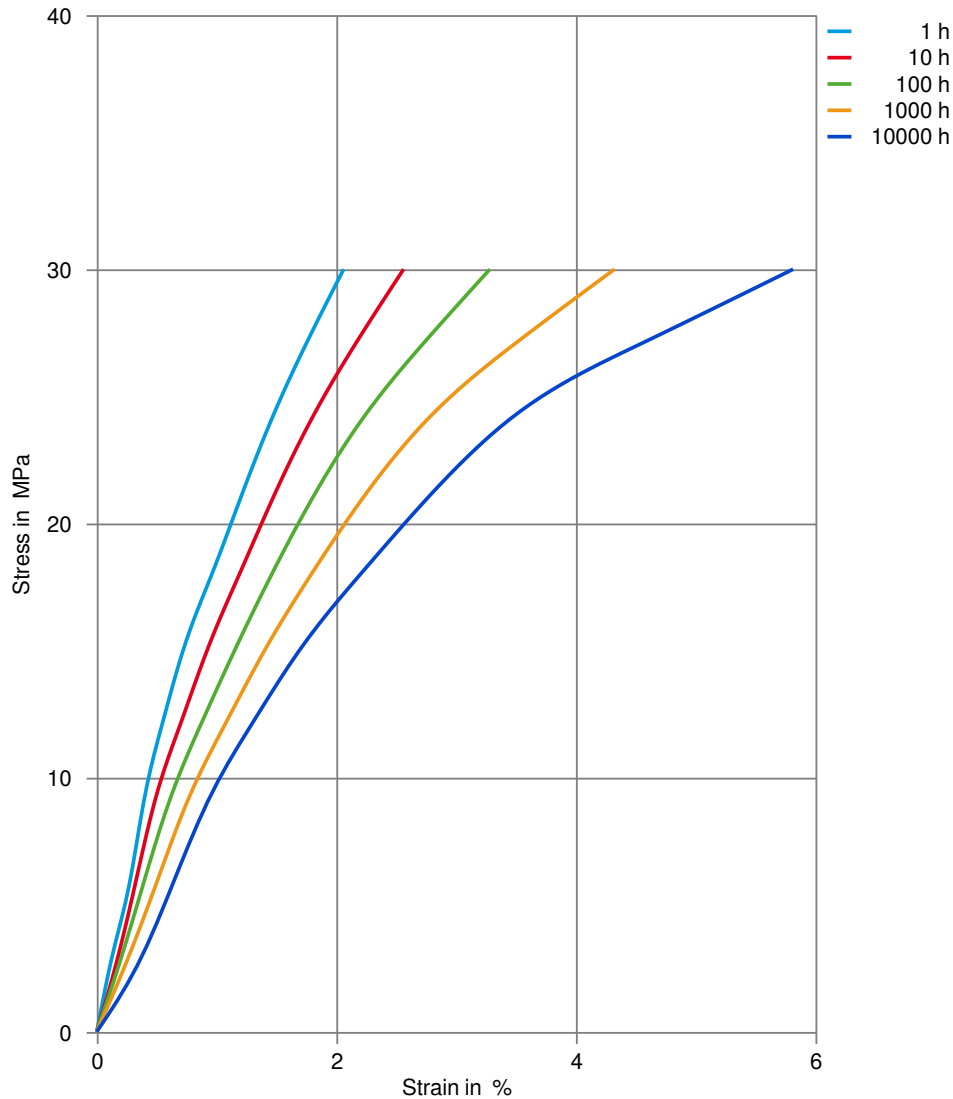


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Stress-strain (isochronous) 23°C

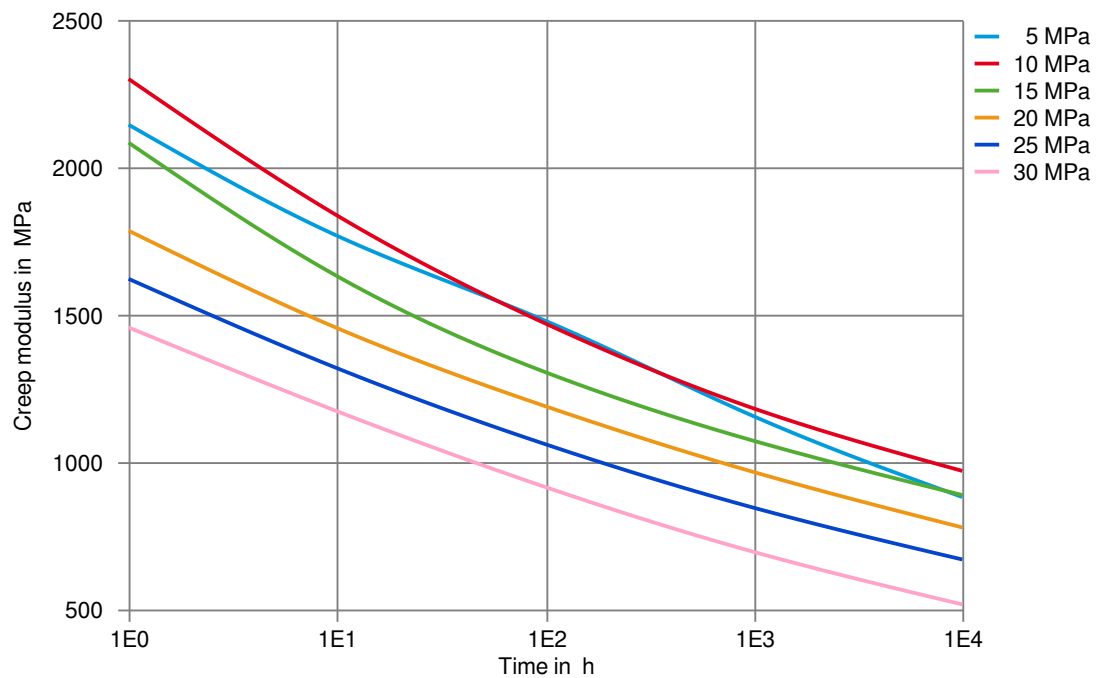


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Creep modulus-time 23°C



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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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