

HOSTAFORM® C 2521 - POM

Description

Chemical abbreviation according to ISO 1043-1: POM
 Molding compound ISO 9988- POM-K, M-GNR, 01-002

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.

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 < 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.
 FDA = Food and Drug Administration (USA)
 FMVSS = Federal Motor Vehicle Safety Standard (USA)

Physical properties	Value	Unit	Test Standard
Density	1410	kg/m ³	ISO 1183
Melt volume rate, MVR	2,5	cm ³ /10min	ISO 1133
MVR temperature	190	°C	ISO 1133
MVR load	2,16	kg	ISO 1133
Molding shrinkage, parallel	2,1	%	ISO 294-4, 2577
Molding shrinkage, normal	1,8	%	ISO 294-4, 2577
Water absorption, 23°C-sat	0,65	%	ISO 62
Humidity absorption, 23°C/50%RH	0,2	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	2600	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	62	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	9	%	ISO 527-2/1A
Tensile nominal strain at break, 50mm/min	32	%	ISO 527-2/1A
Tensile creep modulus, 1h	2300	MPa	ISO 899-1
Tensile creep modulus, 1000h	1100	MPa	ISO 899-1
Flexural modulus, 23°C	2500	MPa	ISO 178
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, 30s	144	MPa	ISO 2039-1

P: Partial Break

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	165	°C	ISO 11357-1/-3
DTUL at 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	1,1	E-4/°C	ISO 11359-2
Flammability @1.6mm nom. thickn.	HB	class	UL 94
thickness tested (1.6)	1,5	mm	UL 94
UL recognition (1.6)	UL	-	UL 94
Flammability at thickness h	HB	class	UL 94
thickness tested (h)	3,00	mm	UL 94
UL recognition (h)	UL	-	UL 94

Electrical properties	Value	Unit	Test Standard
Relative permittivity, 100Hz	4	-	IEC 60250
Relative permittivity, 1MHz	4	-	IEC 60250
Dissipation factor, 100Hz	15	E-4	IEC 60250
Dissipation factor, 1MHz	50	E-4	IEC 60250
Volume resistivity	1E12	Ohm*m	IEC 60093
Surface resistivity	1E14	Ohm	IEC 60093
Electric strength	35	kV/mm	IEC 60243-1

HOSTAFORM® C 2521 - POM

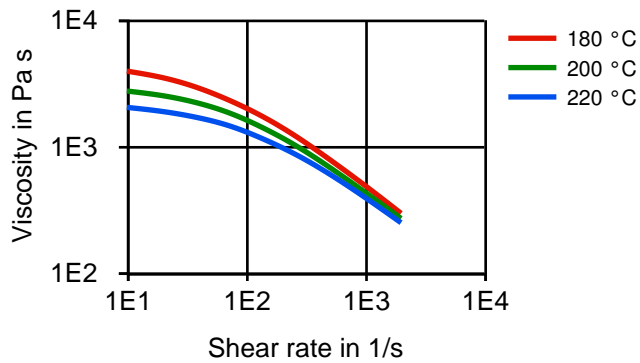
Comparative tracking index	600	-	IEC 60112
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Test specimen production	Value	Unit	Test Standard
Processing conditions acc. ISO	9988	-	Internal
Injection Molding, melt temperature	205	°C	ISO 294
Injection Molding, mold temperature	90	°C	ISO 294
Injection Molding, injection velocity	140	mm/s	ISO 294
Injection Molding, pressure at hold	90	MPa	ISO 294

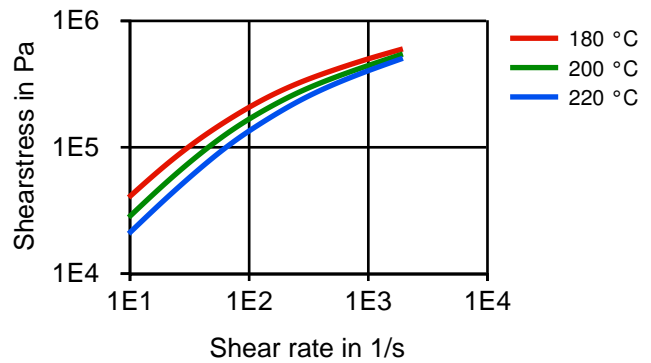
Rheological calculation properties	Value	Unit	Test Standard
Density of melt	1200	kg/m ³	Internal
Thermal conductivity of melt	0,155	W/(m K)	Internal
Spec. heat capacity melt	2210	J/(kg K)	Internal
Ejection temperature	140	°C	Internal

Diagrams

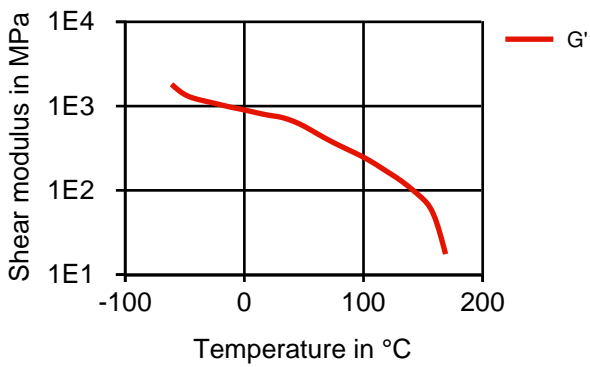
Viscosity-shear rate



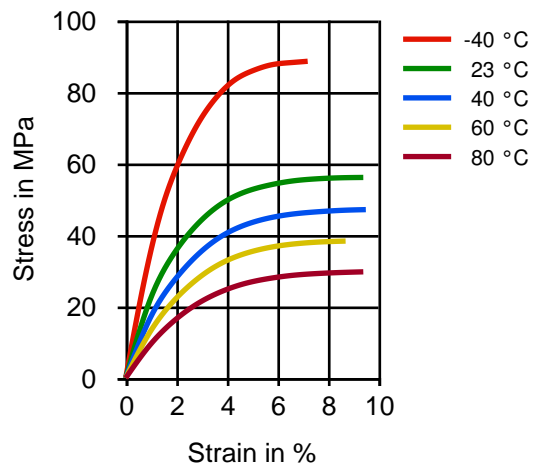
Shearstress-shear rate



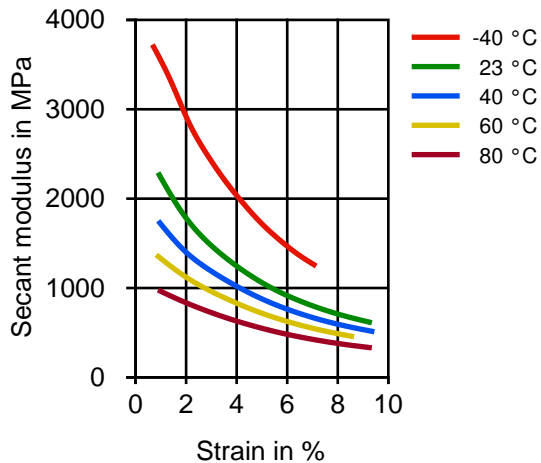
Dynamic Shear modulus-temperature



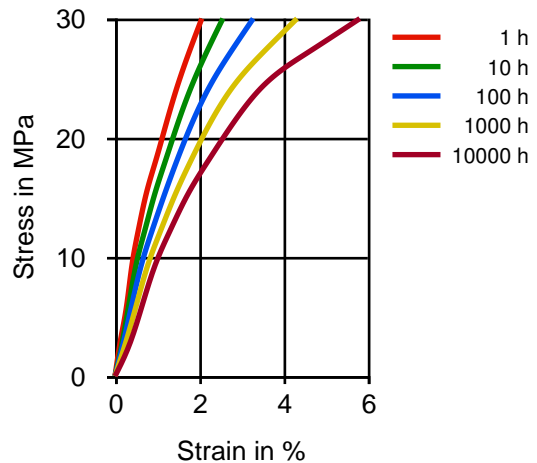
Stress-strain



Secant modulus-strain



Stress-strain (isochronous) 23 °C



Typical injection moulding processing conditions

	Value	Unit	Test Standard
Pre Drying			
Necessary low maximum residual moisture content	0,15	%	-
Drying time	3 - 4	h	-
Drying temperature	100 - 120	°C	-
Temperature			
Hopper temperature	20 - 30	°C	-
Feeding zone temperature	60 - 80	°C	-
Zone1 temperature	170 - 180	°C	-
Zone2 temperature	180 - 190	°C	-
Zone3 temperature	190 - 200	°C	-
Zone4 temperature	190 - 210	°C	-
Die temperature	190 - 210	°C	-
Melt temperature	190 - 210	°C	-
Cavity temperature	80 - 120	°C	-
Hot runner temperature	190 - 210	°C	-
Pressure			
Back pressure max.	40	bar	-
Speed			
Injection speed	slow-medium	-	-
Screw Speed			
Screw speed diameter, 25mm	150	RPM	-
Screw speed diameter, 40mm	100	RPM	-
Screw speed diameter, 55mm	70	RPM	-

Other text information

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.

Melt temperature 190-210 °C
 Mould temperature 80-120 °C

Film extrusion

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

HOSTAFORM® C 2521 - POM

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

Profile extrusion

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

Blow molding

Standard extruders with plasticating screws (20 to 25 D) will fit.

Melt temperature 180-190 °C

Mould-surface temperature 60-100 °C

Characteristics

Product Categories

Unfilled

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