



Hostaform® C 9021 GV1/20 XGM

Celanese Corporation - Acetal (POM) Copolymer

Saturday, November 2, 2019

General Information

Product Description

Chemical abbreviation according to ISO 1043-1: POM Molding compound ISO 9988- POM-K, M-GS2, 02-003, GF20 POM copolymer Injection molding type, reinforced with ca 20 % glass fibers; includes PTFE for improved wear performance; high resistance to thermal and oxidative degradation; reduced thermal expansion and shrinkage. Ranges of applications: For molded parts requiring improved low wear performance while exhibiting very high strength and rigidity as well as higher hardness. FMVSS = Federal Motor Vehicle Safety Standard (USA)

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Additive	• PTFE Lubricant		
Features	• High Hardness • High Stiffness • High Strength	• Low CLTE • Low Shrinkage • Lubricated	• Wear Resistant
RoHS Compliance	• Contact Manufacturer		
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• POM		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.57	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/2.16 kg)	4.00	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.12E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	14500	psi	ISO 527-2/1A/5
Tensile Strain (Break)	2.5	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.07E+6	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	2.6	ft-lb/in ²	
73°F	2.6	ft-lb/in ²	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	86		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	316	°F	ISO 75-2/A
Melting Temperature ²	331	°F	ISO 11357-3
CLTE - Flow	1.7E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	5.0E-5	in/in/°F	ISO 11359-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	212 to 248	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.15	%

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Injection	Nominal Value	Unit
Hopper Temperature	68 to 86	°F
Rear Temperature	338 to 356	°F
Middle Temperature	356 to 374	°F
Front Temperature	374 to 392	°F
Nozzle Temperature	374 to 410	°F
Processing (Melt) Temp	374 to 410	°F
Mold Temperature	176 to 248	°F
Injection Rate	Slow	
Back Pressure	< 290	psi

Injection Notes

Feeding zone temperature: 60 to 80°C

Zone4 temperature: 190 to 210°C

Hot runner temperature: 190 to 210°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 10°C/min