HOSTAFORM® C 9021 GV3/30 TF2

HOSTAFORM®

Injection molding grade with 30% glass beads, for low warpage parts, slip modified with PTFE

Product information

Resin Identification	(POM+PTFE)-GB30	ISO 1043
Part Marking Code	>(POM+PTFE)-GB30<	ISO 11469

Rheological properties

Melt volume-flow rate	7.5	cm^3/10min	ISO 1133
Temperature	374	°F	
Load	4.76	lb	

Typical mechanical properties

Tensile modulus	551000	psi	ISO 527-1/-2
Tensile stress at yield, 50mm/min	5500	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	5	%	ISO 527-1/-2
Nominal strain at break	13	%	ISO 527-1/-2
Charpy notched impact strength, 23°C	1.19	$ftlb/in^2$	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	331	°F	ISO 11357-1/-3

Physical/Other properties

Density	0.0588	lb/in^3	ISO 1183

Injection

Drying Recommended	no	
Drying Temperature	212	°F
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	392	°F
Min. melt temperature	374	°F
Max. melt temperature	410	°F
Max. screw tangential speed	≤0.3	m/s
Mold Temperature Optimum	212	°F
Min. mold temperature	176	°F
Max. mold temperature	248	°F
Hold pressure range	8700 - 17400	psi
Hold Pressure Time (h is the max. wall thickness of the part in mm)	$2h^2$-3	s

Characteristics

Processing	Injection Molding
Additives	Release agent
Special characteristics	Low wear / Low friction, Low Warpage

Revised: 2025-02-27 Source: Celanese Materials Database

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Additional information

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 %

Processing

Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.

Postprocessing

Conditioning e.g. moisturizing is not necessary.

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