HOSTAFORM® C 9021 TF XAP®2

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Chemical abbreviation according to ISO 1043-1: POM Molding compound ISO 29988- POM-K, M-GNS, 2-2 POM copolymer Injection molding type, modified with PTFE; good chemical resistance to solvents, fuel and strong alkalis as well as good hydrolysis resistance; high resistance to thermal and oxidative degradation; for sliding combinations with very low coefficient of friction. Reduced emission grade. Emissions according to VDA 275 < 5 mg/kg Burning rate ISO 3795 and FMVSS 302 < 100 mm/min for a thickness more than 1 mm. Ranges of applications: For sliding combinations with very low coefficient of friction. FMVSS = Federal Motor Vehicle Safety Standard (USA)

Product information

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

Rheological properties

Melt volume-flow rate	6	cm^3/10min	ISO 1133
Temperature	374	°F	
Load	4.76	lb	
Molding shrinkage, parallel	2.0	%	ISO 294-4, 2577
Molding shrinkage, normal	1.7	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	341000	psi	ISO 527-1/-2
Tensile stress at yield, 50mm/min	7300	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	10	%	ISO 527-1/-2
Nominal strain at break	16	%	ISO 527-1/-2
Flexural modulus	326000	psi	ISO 178
Tensile creep modulus, 1h	290000	psi	ISO 899-1
Tensile creep modulus, 1000h	167000	psi	ISO 899-1
Charpy impact strength, 23°C	28.5	ftlb/in^2	ISO 179/1eU
Charpy impact strength, -30°C	28.5	ftlb/in^2	ISO 179/1eU
Charpy notched impact strength, 23°C	1.9	ftlb/in^2	ISO 179/1eA
Charpy notched impact strength, -30°C	1.9	ftlb/in^2	ISO 179/1eA
Ball indentation hardness, H 358/30	17400	psi	ISO 2039-1

Thermal properties

Melting temperature, 10°C/min	331	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	208	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.61	E-4/°F	ISO 11359-1/-2

Flammability

FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	2.87	in/min	ISO 3795 (FMVSS 302)

Electrical properties

Relative permittivity, 100Hz	3.7		IEC 62631-2-1
Relative permittivity, 1MHz	3.7		IEC 62631-2-1
Dissipation factor, 100Hz	20	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	80	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	838	kV/in	IEC 60243-1
Comparative tracking index	600		IEC 60112

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Water absorption, 2mm	0.65	%	Sim. to ISO 62
Density	0.0545	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
Back pressure	290	psi

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Mercedes-Benz	DBL5404	BQF
Mercedes-Benz	DBL5410	

Characteristics

Processing	Injection Molding, Other Extrusion
Additives	Release agent
Special characteristics	Low wear / Low friction, Low emissions

Additional information

Processing Notes

Pre-Drying

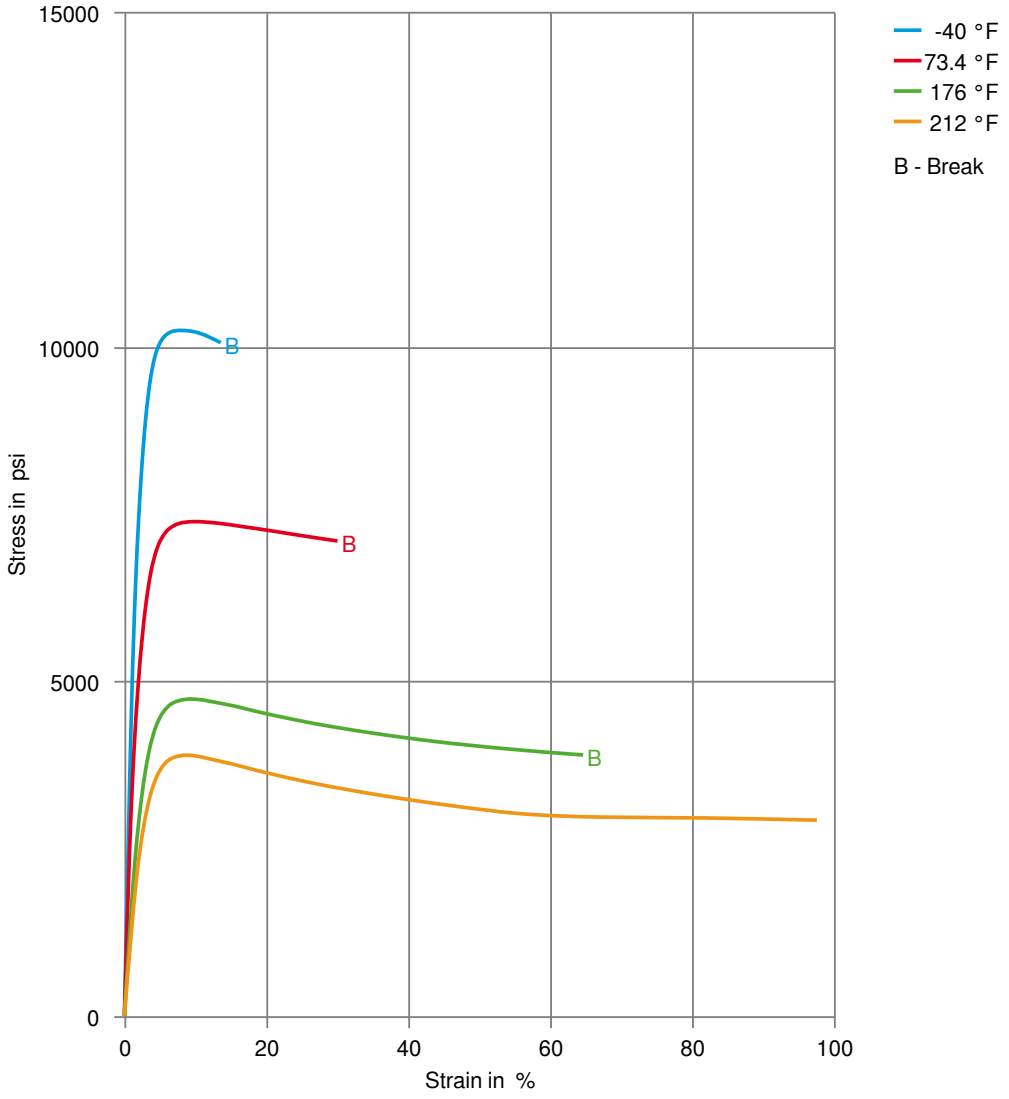
It is normally not necessary to dry HOSTAFORM. However, should there be surface moisture (condensate) on the molding compound as a result of incorrect storage, drying is required. A circulating air drying cabinet can be used for this purpose.

Storage

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The product can then be stored in standard conditions until processed.

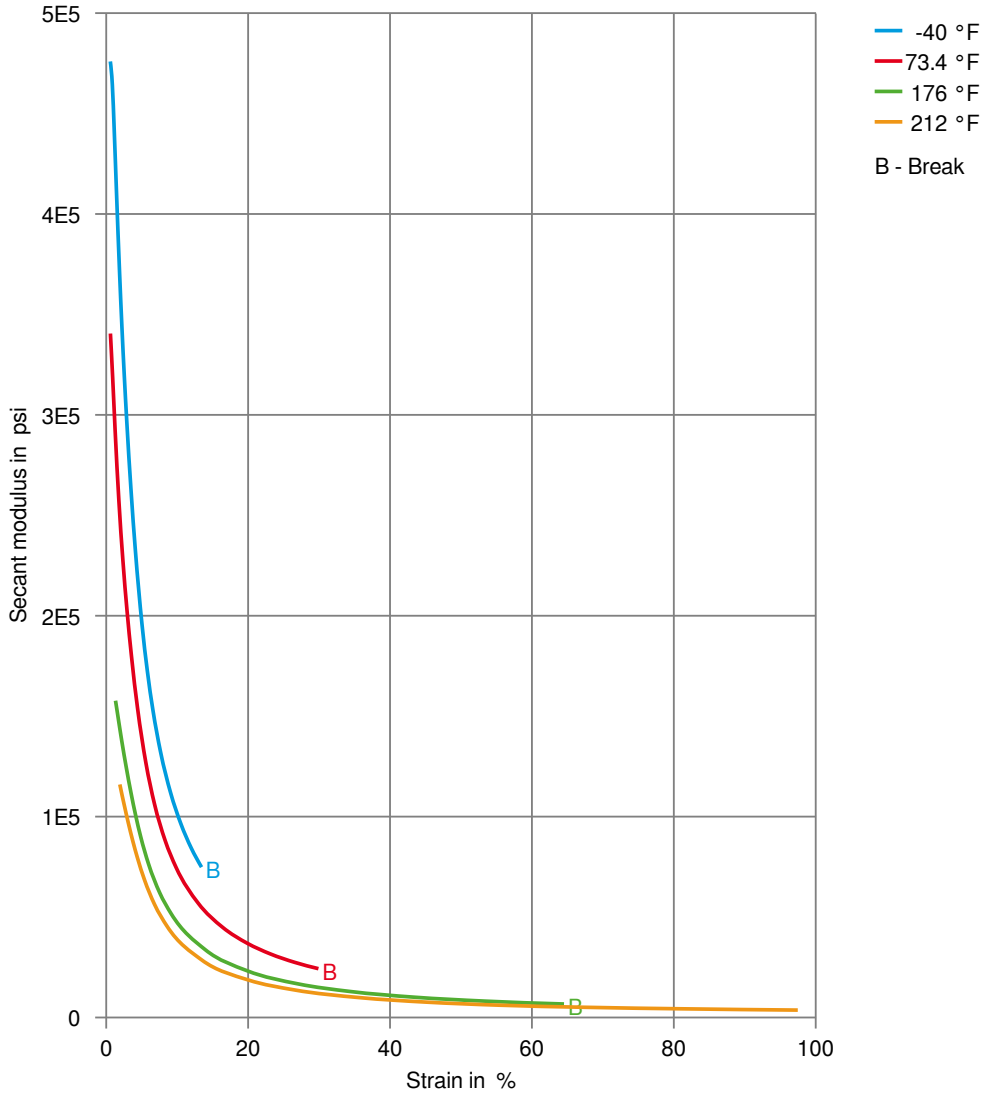
Stress-strain



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Secant modulus-strain



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