

# HOSTAFORM® C 9021 XLE

POM copolymer Standard injection molding grade with reduced emissions especially for automotive interior application.  
 Burning rate according to FMVSS 302 < 100 mm/min (1 mm thickness) Emission according to VDA 275 < 1 mg/kg.

## Rheological properties

|                       |                          |          |
|-----------------------|--------------------------|----------|
| Melt volume-flow rate | 8 cm <sup>3</sup> /10min | ISO 1133 |
| Temperature           | 190 °C                   |          |
| Load                  | 2.16 kg                  |          |

## Typical mechanical properties

|                                       |                       |              |
|---------------------------------------|-----------------------|--------------|
| Tensile Modulus                       | 2700 MPa              | ISO 527-1/-2 |
| Yield stress, 50mm/min                | 65 MPa                | ISO 527-1/-2 |
| Yield strain, 50mm/min                | 10 %                  | ISO 527-1/-2 |
| Strain at break, 5mm/min              | 30 %                  | ISO 527-1/-2 |
| Flexural Modulus                      | 2650 MPa              | ISO 178      |
| Flexural Stress at 3.5%               | 74 MPa                | ISO 178      |
| Charpy notched impact strength, 23°C  | 6.5 kJ/m <sup>2</sup> | ISO 179/1eA  |
| Charpy notched impact strength, -30°C | 6 kJ/m <sup>2</sup>   | ISO 179/1eA  |

## Thermal properties

|                                             |           |                |
|---------------------------------------------|-----------|----------------|
| Melting temperature, 10°C/min               | 166 °C    | ISO 11357-1/-3 |
| Temp. of deflection under load, 1.8 MPa     | 100 °C    | ISO 75-1/-2    |
| Coeff. of linear therm. expansion, parallel | 129 E-6/K | ISO 11359-1/-2 |
| Coeff. of linear therm. expansion, normal   | 131 E-6/K | ISO 11359-1/-2 |

## Other properties

|                          |                        |                |
|--------------------------|------------------------|----------------|
| Humidity absorption, 2mm | 0.2 %                  | Sim. to ISO 62 |
| Water absorption, 2mm    | 0.65 %                 | Sim. to ISO 62 |
| Density                  | 1410 kg/m <sup>3</sup> | ISO 1183       |

## 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    |

## Characteristics

|           |               |
|-----------|---------------|
| Additives | Release agent |
|-----------|---------------|

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## Additional information

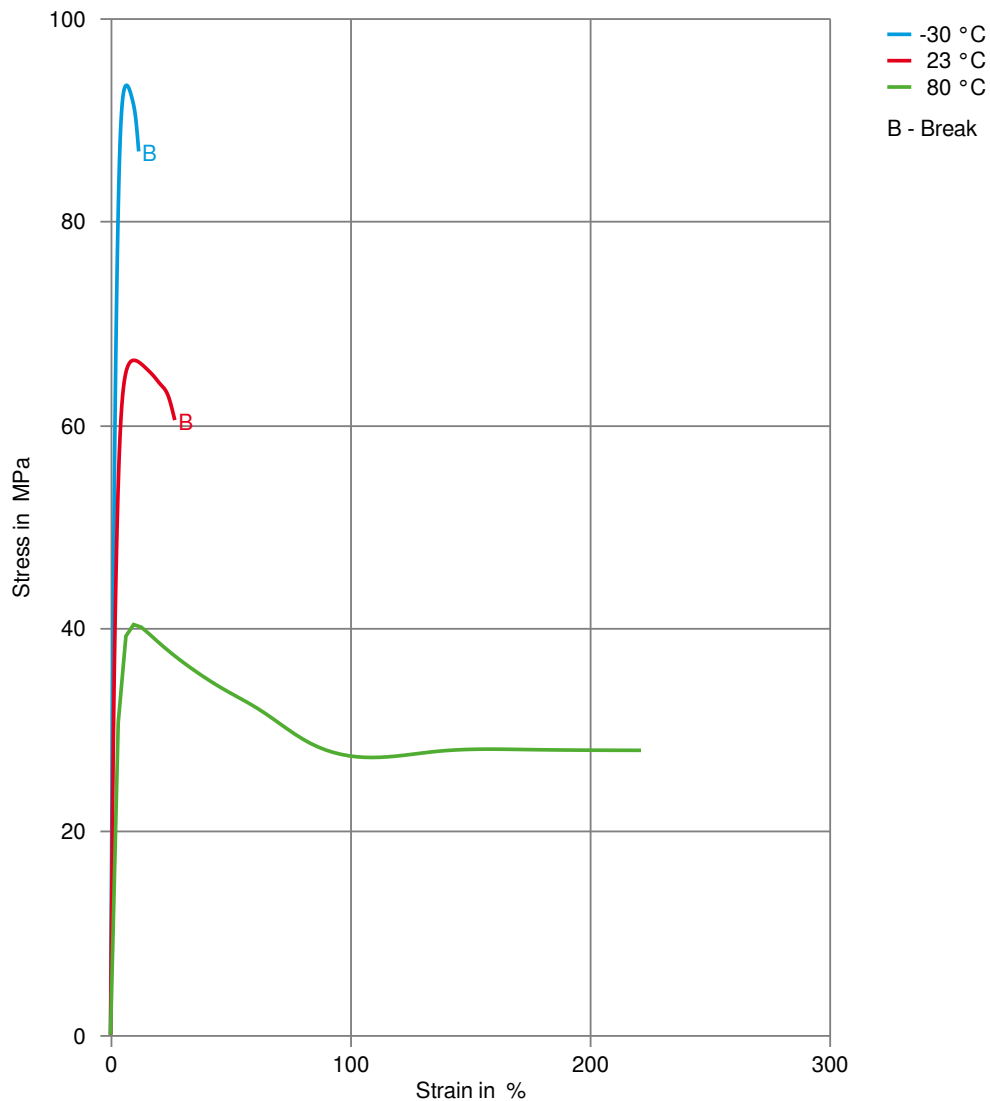
Injection molding

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

Melt temperature 180-190 °C

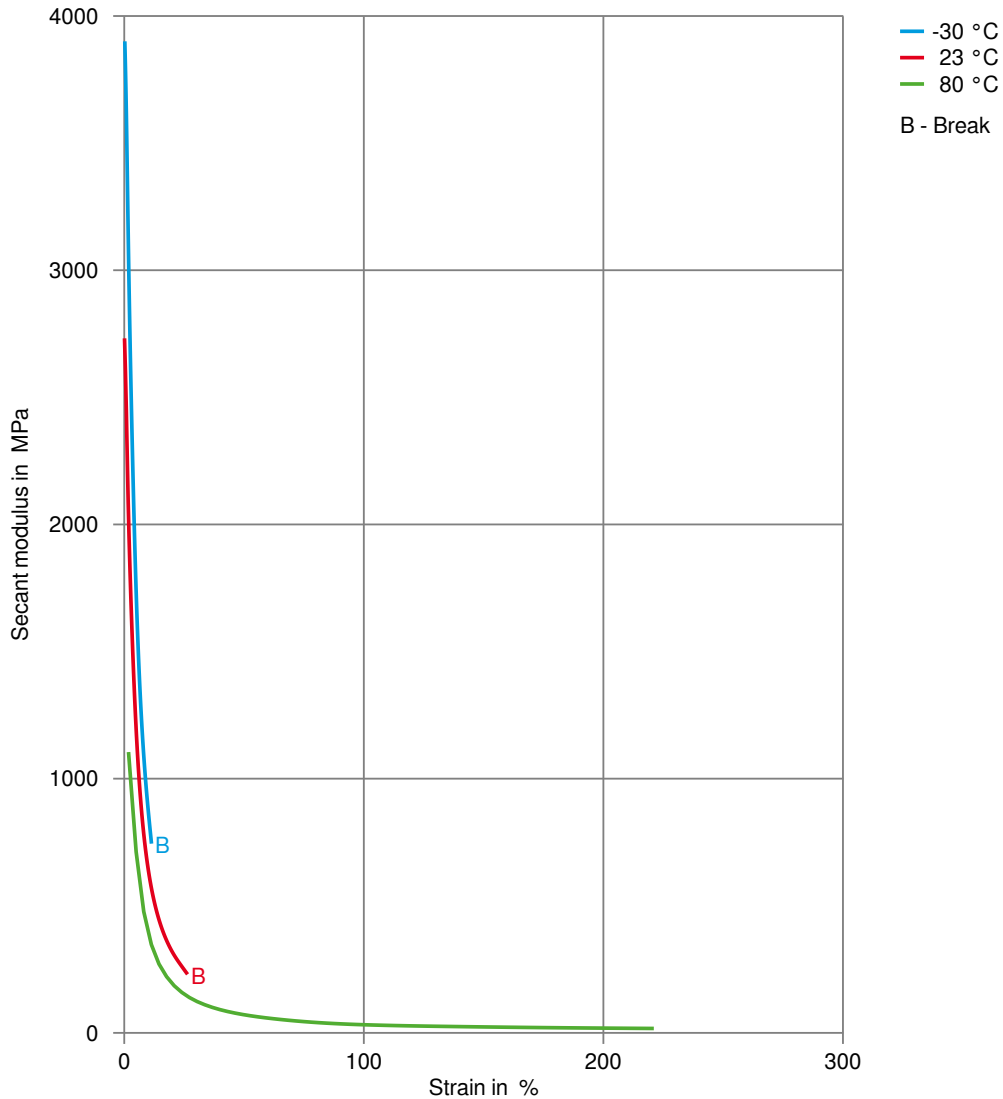
Mould temperature 60-120 °C

## Stress-strain



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## Secant modulus-strain



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## Processing Texts

|                                  |                                                                                                                                                                             |
|----------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Pre-drying                       | recommended                                                                                                                                                                 |
| Injection molding                | Standard injection moulding machines with three phase (15 to 25 D) plasticating screws will fit.<br><br>Melt temperature 180-190 °C<br>Mould temperature 60-120 °C          |
| Injection molding Preprocessing  | To achieve low emission values pre drying using a recirculating air dryer (100 to 120 °C / max. 40 mm layer / 3 to 6 hours) is recommended.<br><br>Max. Water content 0,1 % |
| Injection molding Postprocessing | Conditioning e.g. moisturizing is not necessary.                                                                                                                            |

## Other Approvals

|                 |         |               |                        |
|-----------------|---------|---------------|------------------------|
| Other Approvals | OEM     | Specification | Additional Information |
|                 | Li Auto | Q/LiA5310020  | 2021 (V2)              |