

Celanese Hostaform® C 9021 TF5

Hostaform® C 9021 TF5 is a standard flow low level polytetrafluoroethylene filled (PTFE) product designed for use in wear applications against plastics, metal, glass or ceramic mating surfaces where silicone lubricants can not be tolerated.

Physical Properties	Metric	English	Comments
Density	1.44 g/cc	0.0520 lb/in ³	ISO 1183
Water Absorption at Saturation	0.65 %	0.65 %	ISO 62
Melt Flow	8.5 g/10 min @Load 2.16 kg, Temperature 190 °C	8.5 g/10 min @Load 4.76 lb, Temperature 374 °F	[cm ³ /10min]; ISO 1133

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	58.0 MPa	8410 psi	50mm/min; ISO 527-2/1A
Elongation at Yield	9.0 %	9.0 %	50mm/min; ISO 527-2/1A
Tensile Modulus	2.60 GPa	377 ksi	50mm/min; ISO 527-2/1A
Charpy Impact Unnotched	12.5 J/cm ²	59.5 ft-lb/in ²	ISO 179/1eU
	11.0 J/cm ² @Temperature -30.0 °C	52.3 ft-lb/in ² @Temperature -22.0 °F	ISO 179/1eU
Charpy Impact, Notched	0.520 J/cm ²	2.47 ft-lb/in ²	ISO 179/1eA

Thermal Properties	Metric	English	Comments
Melting Point	166 °C	331 °F	10°C/min; ISO 11357-1,-2,-3
Deflection Temperature at 1.8 MPa (264 psi)	102 °C	216 °F	ISO 75-1,-2

Processing Properties	Metric	English	Comments
Processing Temperature	80.0 - 120 °C	176 - 248 °F	cavity
	190 - 210 °C	374 - 410 °F	hot runner
Feed Temperature	60.0 - 80.0 °C	140 - 176 °F	
Zone 1	170 - 180 °C	338 - 356 °F	
Zone 2	180 - 190 °C	356 - 374 °F	

Zone 3	190 - 200 °C	374 - 392 °F
Zone 4	190 - 210 °C	374 - 410 °F
Die Temperature	190 - 210 °C	374 - 410 °F
Melt Temperature	190 - 210 °C	374 - 410 °F
Drying Temperature	100 - 120 °C	212 - 248 °F
Dry Time	3.00 - 4.00 hour	3.00 - 4.00 hour
Injection Pressure	60.0 - 120 MPa	8700 - 17400 psi
Hold Pressure	60.0 - 120 MPa	8700 - 17400 psi
Back Pressure	<= 2.00 MPa	<= 290 psi

Descriptive Properties

Injection molding	Yes
Injection speed	slow
Processing conditions acc. ISO	9988-2