

HOSTAFORM® CKX-5740 - POM

Experimental Grade. Please contact your Celanese representative for further information.

Description

Hostaform CKX-5740 is an experimental grade moderate flow POM copolymer grade for injection molding with media resistance, general purpose acetal, fuel resistance including hot diesel, improved media resistance.

Physical properties	Value	Unit	Test Standard
Density	1400	kg/m ³	ISO 1183
Melt volume rate, MVR	12.9	cm ³ /10min	ISO 1133
MVR temperature	190	°C	ISO 1133
MVR load	2.16	kg	ISO 1133
Molding shrinkage, parallel	2.0	%	ISO 294-4, 2577
Molding shrinkage, normal	1.9	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	2570	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	55	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	13	%	ISO 527-2/1A
Flexural modulus, 23°C	2250	MPa	ISO 178
Charpy impact strength, 23°C	5.8	kJ/m ²	ISO 179/1eU

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	171	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	96	°C	ISO 75-1, -2

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Drying time	3 - 4	h	-
Drying temperature	100 - 120	°C	-
Temperature	Value	Unit	Test Standard
Hopper temperature	20 - 30	°C	-
Feeding zone temperature	60 - 80	°C	-
Zone2 temperature	170 - 180	°C	-
Zone3 temperature	180 - 190	°C	-
Zone4 temperature	190 - 200	°C	-
Nozzle temperature	190 - 210	°C	-
Melt temperature	190 - 210	°C	-
Mold temperature	80 - 120	°C	-
Hot runner temperature	190 - 210	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	40	bar	-
Speed	Value	Unit	Test Standard
Injection speed	slow-medium	-	-
Screw Speed	Value	Unit	Test Standard
Screw speed diameter, 25mm	150	RPM	-
Screw speed diameter, 40mm	100	RPM	-
Screw speed diameter, 55mm	70	RPM	-

