

HOSTAFORM® CKX-5771 - POM

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

Description

Hostaform CKX-5771 is an experimental grade of high flow POM copolymer grade for metal injection molding application. Stainless steel feedstock based on Hostaform CKX-5771 has very high flow and toughness.

Physical properties	Value	Unit	Test Standard
Density	1400	kg/m ³	ISO 1183
Melt flow rate, MFR	61	g/10min	ISO 1133
MFR temperature	190	°C	ISO 1133
MFR load	2.16	kg	ISO 1133

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	2300	MPa	ISO 527-2/1A
Tensile stress at break, 50mm/min	42	MPa	ISO 527-2/1A
Tensile strain at break, 50mm/min	47	%	ISO 527-2/1A
Flexural modulus, 23°C	2000	MPa	ISO 178
Flexural strength, 23°C	52	MPa	ISO 178
Charpy impact strength, 23°C	123	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	5.3	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
DTUL at 1.8 MPa	81	°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
Zone1 temperature	170 - 180	°C	-
Zone2 temperature	180 - 190	°C	-
Zone3 temperature	180 - 190	°C	-
Zone4 temperature	190 - 200	°C	-
Nozzle temperature	190 - 200	°C	-
Melt temperature	180 - 200	°C	-
Mold temperature	80 - 120	°C	-
Hot runner temperature	180 - 200	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	40	bar	-
Speed	Value	Unit	Test Standard
Injection speed	medium	-	-
Other	Value	Unit	Test Standard
Flow temperature	174	°C	Internal

