

HOSTAFORM® CKX-5766 - POM

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

Physical properties	Value	Unit	Test Standard
Density	1390	kg/m ³	ISO 1183
Melt flow rate, MFR	63	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	2247	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	53	MPa	ISO 527-2/1A
Tensile nominal strain at break, 50mm/min	15	%	ISO 527-2/1A
Flexural modulus, 23°C	2100	MPa	ISO 178
Flexural strength, 23°C	53	MPa	ISO 178
Charpy impact strength, 23°C	114 ^[P]	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	4.8	kJ/m ²	ISO 179/1eA

P: Partial Break

Thermal properties	Value	Unit	Test Standard
DTUL at 1.8 MPa	83	°C	ISO 75-1, -2

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0.15	%	-
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	-
Zone1 temperature	170 - 180	°C	-
Zone2 temperature	180 - 190	°C	-
Zone3 temperature	190 - 200	°C	-
Zone4 temperature	190 - 200	°C	-
Nozzle temperature	190 - 200	°C	-
Melt temperature	190 - 200	°C	-
Mold temperature	60 - 70	°C	-
Hot runner temperature	190 - 200	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	20	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	-

Characteristics

Product Categories	Delivery Form
Impact modified	Pellets
Processing	Additives
Injection molding	Release agent

