

HOSTAFORM® M30AE - POM

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

Description

Hostaform® M30AE is a special grade of acetal copolymer targeted for extrusion shapes (rod, bar, plate, etc) free of center porosity in large diameters and thicknesses. Chemical abbreviation according to ISO 1043-1: POM

Physical properties	Value	Unit	Test Standard
Density	1410	kg/m ³	ISO 1183
Melt volume rate, MVR	2.8	cm ³ /10min	ISO 1133
MVR temperature	190	°C	ISO 1133
MVR load	2.16	kg	ISO 1133
Humidity absorption, 23°C/50%RH	0.2	%	ISO 62

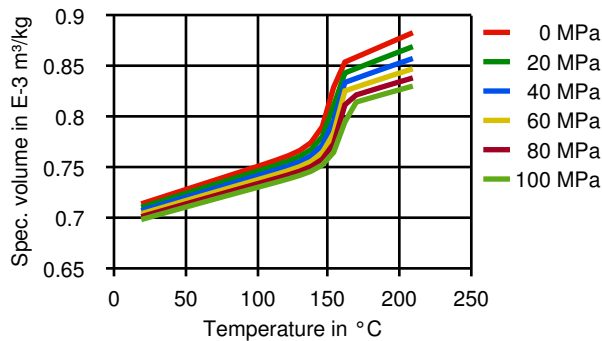
Mechanical properties	Value	Unit	Test Standard
Tensile modulus	2400	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	61	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	11	%	ISO 527-2/1A
Flexural modulus, 23°C	2400	MPa	ISO 178
Charpy impact strength, 23°C	250 ^[P]	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	250	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	8.5	kJ/m ²	ISO 179/1eA

P: Partial Break

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	163	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	91	°C	ISO 75-1, -2
Vicat softening temperature, 50°C/h 50N	161	°C	ISO 306
Coeff. of linear therm expansion, parallel	1.1	E-4/°C	ISO 11359-2
Coeff. of linear therm expansion, normal	1	E-4/°C	ISO 11359-2

Diagrams

Moldflow Specific volume-temperature (pvT)



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	-
Zone1 temperature	170 - 180	°C	-
Zone2 temperature	180 - 190	°C	-



HOSTAFORM® M30AE - POM

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

Zone3 temperature	190 - 200	°C	-
Zone4 temperature	190 - 210	°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	-	-

Other text information

Pre-drying

Drying is not normally required. If material has come in contact with moisture through improper storage or handling or through regrind use, drying may be necessary to prevent splay and odor problems.

Profile extrusion

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature 180-190 °C

Sheet extrusion

Standard extruders with grooved feed zone and short compression screws (minimum 25 D) will fit.

Melt temperature 180-190 °C

Characteristics

Special Characteristics

High viscosity

Processing

Injection molding, Other extrusion, Sheet extrusion

Product Categories

Unfilled

Delivery Form

Pellets

